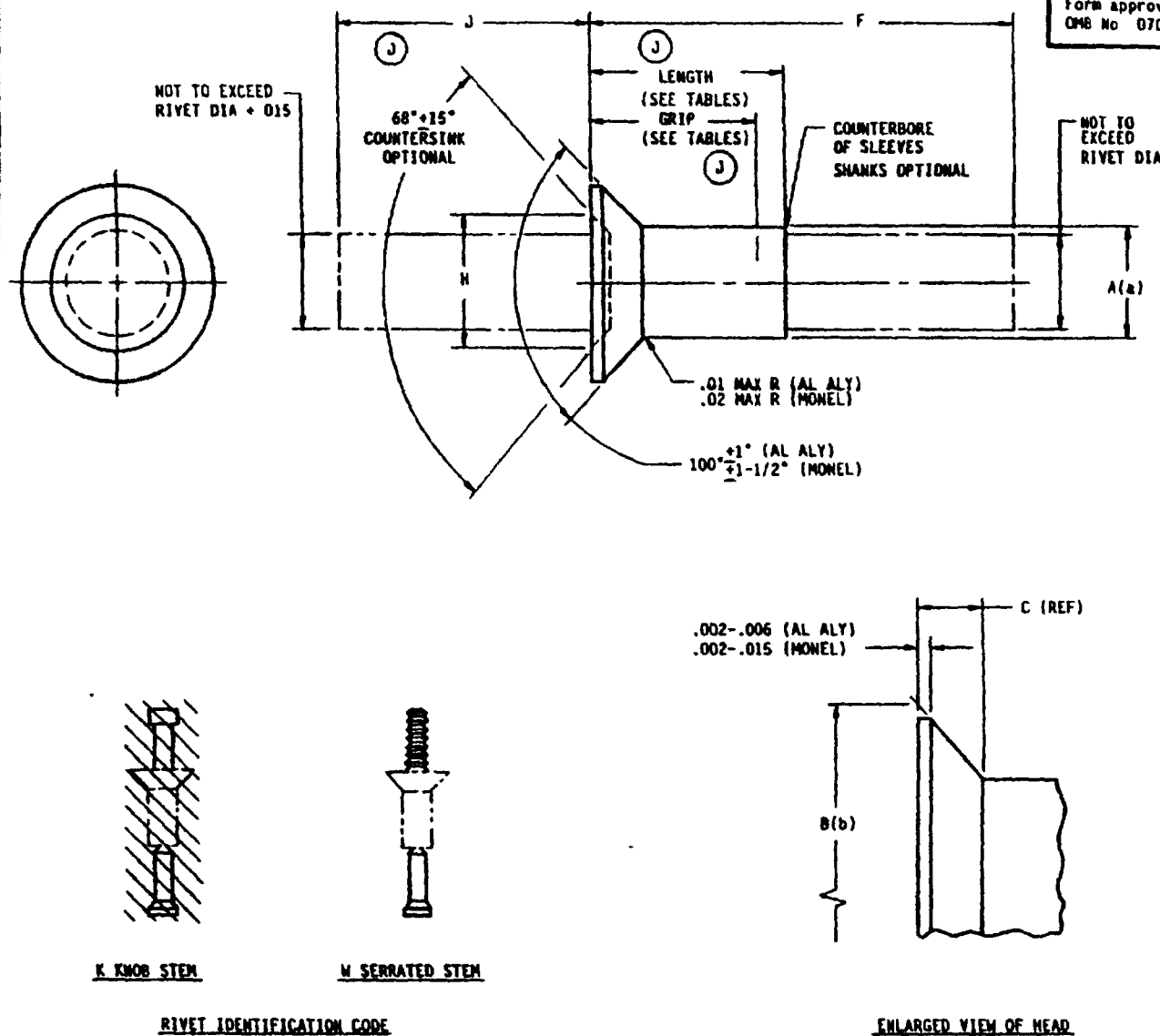


THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION MIL-R-7886

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE

Form approved
OMB No 0704-0188



J TABLE I. DIMENSIONS.

RIVET SIZE NOM DIA	A +.003 -.001 DIA	B +.004 DIA	C (REF)	H MAX DIA	J MIN
1/8	.125	.225	.042	.110	0.750
5/32	.156	.286	.055	.138	0.750
3/16	.187	.353	.070	.161	0.750
1/4	.250	.425	.085	.215	1.000

(a) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100 INCH OF BASE HEAD.
(b) MAXIMUM HEAD DIAMETERS ARE TO THEORETICAL SHARP CORNERS AS MEASURED BY PROJECTION.

J DENOTES CHANGES

PREPARING ACTIVITY NAVY-AS

CUSTODIANS ARMY-AR NAVY-

AIR FORCE-99 DLA-

REVIEW ARMY-ER, AV, MI NAVY-SH DLA-IS
AIR FORCE-82

PROJECT NUMBER 5320-0770

MILITARY SPECIFICATION SHEET

TITLE RIVET, BLIND, STRUCTURAL
PULL STEM, SELF-PLUGGING,
100° FLUSH HEAD, TYPE II

SPECIFICATION SHEET NUMBER

MS20601 10 AUG 92
REV J

SUPERSEDING
MS20601, REV H, 11 DEC 89

AMSC- N/A FSC 5320

W-SERRATED STEM**J** TABLE II 1/8 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MONEL DASH NO.	MONEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD4W1	B4W2	MAW1	MP4W1	NP TO .063		.170	.300
AD4W2	B4W3	MAW2	MP4W2	.063	.125	.232	.567
AD4W3	B4W3	MAW3	MP4W3	.126	.187	.295	.750
AD4W4	B4W4	MAW4	MP4W4	.188	.250	.357	.812
AD4W5	B4W5	MAW5	MP4W5	.251	.312	.420	1.010
AD4W6	B4W6	MAW6	MP4W6	.313	.375	.482	1.072
AD4W7	B4W7	MAW7	MP4W7	.376	.437	.545	1.197
AD4W8	B4W8	MAW8	MP4W8	.438	.500	.607	1.322
AD4W9	B4W9	MAW9	MP4W9	.501	.562	.670	1.509
AD4W10	B4W10	MAW10	MP4W10	.563	.625	.722	1.600
AD4W11	B4W11	MAW11	MP4W11	.626	.687	.785	1.730
AD4W12	B4W12	MAW12	MP4W12	.688	.750	.847	1.820

J TABLE III 3/32 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MONEL DASH NO.	MONEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD5W2	B5W2	MSW2	MP5W2	.065	.125	.254	.620
AD5W3	B5W3	MSW3	MP5W3	.126	.187	.317	.808
AD5W4	B5W4	MSW4	MP5W4	.188	.250	.379	.870
AD5W5	B5W5	MSW5	MP5W5	.251	.312	.441	1.058
AD5W6	B5W6	MSW6	MP5W6	.313	.375	.503	1.120
AD5W7	B5W7	MSW7	MP5W7	.376	.437	.567	1.339
AD5W8	B5W8	MSW8	MP5W8	.438	.500	.629	1.401
AD5W9	B5W9	MSW9	MP5W9	.501	.562	.692	1.567
AD5W10	B5W10	MSW10	MP5W10	.563	.625	.754	1.630
AD5W11	B5W11	MSW11	MP5W11	.626	.687	.817	1.817
AD5W12	B5W12	MSW12	MP5W12	.688	.750	.879	1.880
AD5W13	B5W13	MSW13	MP5W13	.751	.812	.942	2.067
AD5W14	B5W14	MSW14	MP5W14	.813	.875	1.004	2.130

J TABLE IV 3/16 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MONEL DASH NO.	MONEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD6W2	B6W2	MSW2	MP6W2	.080	.125	.277	.700
AD6W3	B6W3	MSW3	MP6W3	.126	.187	.340	.888
AD6W4	B6W4	MSW4	MP6W4	.188	.250	.403	.950
AD6W5	B6W5	MSW5	MP6W5	.251	.312	.465	1.138
AD6W6	B6W6	MSW6	MP6W6	.313	.375	.527	1.200
AD6W7	B6W7	MSW7	MP6W7	.376	.437	.590	1.419
AD6W8	B6W8	MSW8	MP6W8	.438	.500	.652	1.481
AD6W9	B6W9	MSW9	MP6W9	.501	.562	.715	1.637
AD6W10	B6W10	MSW10	MP6W10	.563	.625	.777	1.699
AD6W11	B6W11	MSW11	MP6W11	.626	.687	.840	1.887
AD6W12	B6W12	MSW12	MP6W12	.688	.750	.903	1.949
AD6W13	B6W13	MSW13	MP6W13	.751	.812	.965	2.074
AD6W14	B6W14	MSW14	MP6W14	.813	.875	1.027	2.199

J TABLE V 1/4 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MONEL DASH NO.	MONEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD8W3	B8W3	MSW3	MP8W3	.125	.187	.385	.968
AD8W4	B8W4	MSW4	MP8W4	.188	.250	.447	1.030
AD8W5	B8W5	MSW5	MP8W5	.251	.312	.510	1.218
AD8W6	B8W6	MSW6	MP8W6	.313	.375	.572	1.280
AD8W7	B8W7	MSW7	MP8W7	.376	.437	.635	1.468
AD8W8	B8W8	MSW8	MP8W8	.438	.500	.697	1.530
AD8W9	B8W9	MSW9	MP8W9	.501	.562	.760	1.718
AD8W10	B8W10	MSW10	MP8W10	.563	.625	.822	1.780
AD8W11	B8W11	MSW11	MP8W11	.626	.687	.885	1.968
AD8W12	B8W12	MSW12	MP8W12	.688	.750	.947	2.030
AD8W13	B8W13	MSW13	MP8W13	.751	.812	1.010	2.218
AD8W14	B8W14	MSW14	MP8W14	.813	.875	1.072	2.280
AD8W15	B8W15	MSW15	MP8W15	.876	.937	1.134	2.465
AD8W16	B8W16	MSW16	MP8W16	.938	1.000	1.198	2.530

PREPARING ACTIVITY NAVY-AS
CUSTODIANS ARMY-AR NAVY-
AIR FORCE-99 DLA-
REVIEW ARMY-ER, AV, MJ NAVY-SH DLA-IS
AIR FORCE 82
PROJECT NUMBER 5320-0770

MILITARY SPECIFICATION SHEET
TITLE RIVET, BLIND, STRUCTURAL
PULL STEM, SELF-PLUGGING,
100° FLUSH HEAD, TYPE II

SPECIFICATION SHEET NUMBER
MS20601 10 AUG 92
REV J
SUPERSEDING
MS20601, REV H, 11 DEC 89
AMSC- N/A FSC 5320

J REQUIREMENTS:

1. MATERIAL: SLEEVES, AL ALLOY, COMP 2117, QQ-A-430.
AL ALLOY, COMP 5056, QQ-A-430.
NICKEL-COPPER-ALLOY (MONEL), CLASS A, QQ-N-281.
PINS, AL ALLOY, COMP 2017, QQ-A-430.
AL ALLOY, COMP 5056, QQ-A-430.
NICKEL-COPPER-ALLOY (MONEL), CLASS A, QQ-N-281.
2. FINISH: ALUMINUM ALLOY; ANODIZE IN ACCORDANCE WITH MIL-A-8625 OR CHEMICALLY SURFACE TREAT IN ACCORDANCE WITH MIL-C-5541.
NICKEL-COPPER-ALLOY (MONEL); CADMIUM-PLATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
3. COLOR: 5056 ALUMINUM ALLOY RIVETS SHALL BE SUITABLY IDENTIFIED BY AN ORANGE COLOR IN ACCORDANCE WITH FEDERAL STANDARD NUMBER 596, COLOR NUMBER 32246.
4. ADD "AD" IN PLACE OF DASH TO INDICATE ALUMINUM ALLOY, COMPOSITION 2117.
ADD "B" IN PLACE OF DASH TO INDICATE ALUMINUM ALLOY, COMPOSITION 5056.
ADD "M" IN PLACE OF DASH TO INDICATE NICKEL-COPPER-ALLOY (MONEL). INACTIVE FOR DESIGN AFTER 1 FEBRUARY 1960.
ADD "ML" IN PLACE OF DASH TO INDICATE NICKEL-COPPER-ALLOY (MONEL) SILVER-PLATED.
ADD "P" AFTER MATERIAL DESIGNATION TO INDICATE CADMIUM PLATE.
5. ADD IDENTIFICATION CODE LETTERS AFTER DASH NUMBERS TO INDICATE TYPE OF RIVET BASED ON METHOD OF INSTALLATION.
ADD "K" TO INDICATE KNOB STEM RIVET.
ADD "W" TO INDICATE SERRATED STEM RIVET.
NO LETTER INDICATES A COMPLETE RIVET WITH TYPE OF STEM OPTIONAL. INACTIVE FOR DESIGN AFTER 21 MARCH 1962.
CANCELLED AFTER 1 FEBRUARY 1960.

J NOTES:

1. EXAMPLES OF PART NUMBERS:
MS20601 ADSMS = RIVET, 2117 ALUMINUM ALLOY SLEEVE, .156 DIA, SERRATED STEM, .251 TO .312 GRIP RANGE.
MS20601 BSMS = RIVET, 5056 AL ALLOY SLEEVE, .156 DIA, SERRATED STEM, .251 TO .312 GRIP RANGE.
MS20601 MPMMS = RIVET, NICKEL-ALLOY (MONEL) SLEEVE, CADMIUM-PLATED, .156 DIA, SERRATED STEM, .251 TO .312 GRIP RANGE.
2. DIMENSIONS ARE IN INCHES, UNLESS OTHERWISE SPECIFIED.
3. FOR QUALIFIED PRODUCTS, SEE QPL-7805.
4. FOR DESIGN USAGE LIMITATIONS, USE MS33522.
5. SILVER-PLATED NICKEL-COPPER-ALLOY (MONEL) (SERIES ML) RIVETS SHALL BE INACTIVE FOR DESIGN AFTER (DATE). USE EXISTING STOCK UNTIL DEPLETED. USE MONEL (SERIES M) OR CADMIUM-PLATED MONEL (SERIES MP) RIVETS IDENTIFIED BY THE SAME DASH NUMBER. KNOB STEM RIVETS (SERIES K) AND "NO LETTER RIVETS" INACTIVE FOR DESIGN AFTER 21 MARCH 1962, USE MS20601, SHEET 2, SERRATED STEM RIVETS (SERIES W). KNOB STEM RIVETS (SERIES K) WILL BE CANCELLED FROM THIS STANDARD 21 MARCH 1965.
6. INTERCHANGEABILITY RELATIONSHIP: SERRATED STEM RIVETS (SERIES W) ARE UNIVERSALLY, FUNCTIONALLY, AND DIMENSIONALLY INTERCHANGEABLE WITH KNOB STEM RIVETS (SERIES K) WITH PROPER TOOLING.
7. KNOB STEM RIVETS (SERIES K) SHOULD BE USED UNTIL EXISTING STOCK IS DEPLETED.
~~MONEL RIVETS IDENTIFIED BY M INACTIVE FOR DESIGN AFTER 1 FEBRUARY 1960. USE RIVETS IDENTIFIED BY ML (MONEL, SILVER-PLATED).~~
8. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

PREPARING ACTIVITY NAVY — AS

CUSTODIANS ARMY — AR NAVY —

AIR FORCE — 99 DLA —

REVIEW: ARMY — ER, AV, MI NAVY — SH DLA — IS
USER: AIRFORCE 82

PROJECT NUMBER: 5320-0770

MILITARY SPECIFICATION SHEETTITLE RIVET, BLIND, STRUCTURAL
PULL STEM, SELF-PLUGGING,
100° FLUSH HEAD, TYPE II

SPECIFICATION SHEET NUMBER

MS20601 10 AUG 92
REV J

SUPERSEDING

MS20601 REV H 11 DEC 89

AMSC — N/A

FSC 5320

(J) TABLE VI. INTERCHANGEABILITY

INACTIVE PART NUMBERS		SUBSTITUTE PART NUMBERS
MS20605		
MS20605	AD3E	MS20601
	AD4E	AD4W
	AD5E	AD5W
	AD6E	AD6W
	AD8E	AD8W
	B3E	
	B4E	B4W
	B5E	B5W
	B6E	B6W
	B8E	B7W
	ML3E	---
	MP3E	---
	M3E	---
	ML4E	MP4W
	MP4E	MP4W
	M4E	M4W
	ML5E	MP5W
	MP5E	MP5W
	M5E	M5W
	ML6E	MP6W
	MP6E	MP6W
	M6E	M6W
	ML8E	MP8W
	MP8E	MP8W
MS20605	M8E	MS20601 M8W

CORRESPONDING GRIP NUMBERS ARE DIRECTLY INTERCHANGEABLE.

PREPARING ACTIVITY. NAVY -- AS

CUSTODIANS: ARMY -- AR NAVY --

AIR FORCE -- 99 DLA --

REVIEW ARMY -- ER, AV, MI NAVY -- SH DLA -- IS

USER: AIR FORCE 02

PROJECT NUMBER 5320-0770

MILITARY SPECIFICATION SHEET

TITLE RIVET, BLIND, STRUCTURAL
PULL STEM, SELF-PLUGGING,
100° FLUSH HEAD, TYPE II

SPECIFICATION SHEET NUMBER

MS20601

10 AUG 92

REV J

SUPERSEDING

MS20601 REV H

11 DEC 89

AMSC -- N/A