

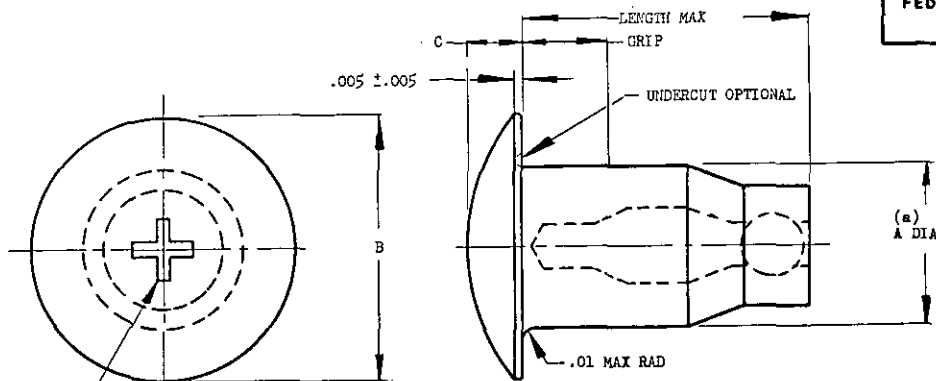
USER SYMBOLS:

REVIEWER SYMBOLS:

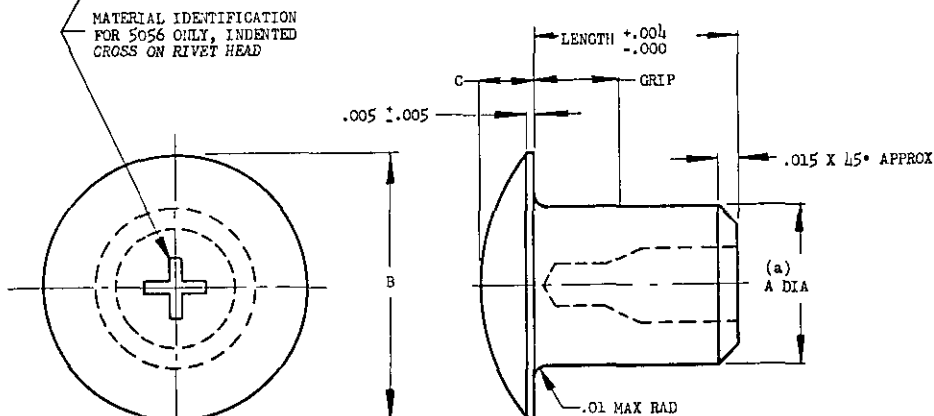
ARMY - EL, AV  
NAVY - AS  
USAF - 11

"Revised user information is current as of the date of this document.  
For future coordination of changes to this document, draft circulation  
should be based on the information in the current DODISS."

This military standard is approved for use by all Departments  
& Agencies of the Department of Defense. Selection for all new  
engineering and design applications and for repetitive use shall  
be made from this document.



STYLE A CHEMICALLY EXPANDED, CLOSED END RIVETS



(b) STYLE B CHEMICALLY EXPANDED, OPEN END RIVETS

RIVET SIZE NOM DIA	A ±.001 DIA	B ±.010	C
1/8	.134	.250	.050 ±.003
5/32	.171	.312	.063 ±.004
3/16	.202	.375	.075 ±.005

(a) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100 INCH OF BASE OF HEAD.

MATERIAL: ALUMINUM ALLOY, SPECIFICATION MIL-W-7986, COMP 2017 AND COMP 5056.

FINISH: ALUMINUM ALLOY, ANODIZE IN ACCORDANCE WITH SPECIFICATION MIL-A-8625, OR CHEMICALLY SURFACE TREAT IN ACCORDANCE WITH SPECIFICATION MIL-C-5541.

EXAMPLES OF PART NOS.: MS20602-12 = 5056 AL ALY STYLE A RIVET, .134 DIA, .286-.325 GRIP RANGE.

MS20602-32 = 2017 AL ALY STYLE B RIVET, .134 DIA, .306-.325 GRIP RANGE.

DIMENSIONS IN INCHES.

FOR ACCEPTABLE PRODUCTS, SEE QPL-300.

FOR LIMITATIONS FOR DESIGN AND USAGE, SEE STANDARD MS33522.

**INACTIVE FOR DESIGN AFTER 17 NOVEMBER 1972 USE NAS 1738**  
**SEE INTERCHANGEABILITY TABLE AND MIL-STD-32 FOR STATUS NOTES.**

(b) STYLE B (OPEN END) RIVETS INACTIVE FOR DESIGN AFTER 1 NOV 1958.  
 PROCURE ONLY STYLE A (CLOSED END) RIVETS AFTER 1 NOV 1958.

ADDED SHEET 5

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.

(D) DENOTES CHANGES

P.A. Navy - AS Other Cust Army - WC USAF - 82	TITLE RIVET, BLIND, CHEMICALLY EXPANDED, PROTRUDING HEAD, TYPE I, CLASS 1, STYLES A AND B	MILITARY STANDARD <b>MS20602</b>
PROCUREMENT SPECIFICATION MIL-R-7885	SUPERSEDES: USAF 459 NAF 1195	SHEET 1 OF 1