

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 DODDS SPECIFIED IN THE SOLICITATION

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Form Approved
OMB No. 0704-0188

NOM DIA	#D		#A		B REF	C		E REF	F REF	R RAD	S	T RAD
	MIN	MAX	MIN	MAX		MIN	MAX					
1/16	061	065	119	131	094	027	037	031	016	054	016	019
3/32	093	097	178	196	141	040	050	047	023	082	023	029
1/8	124	128	238	262	188	054	064	062	031	108	031	039
5/32	155	160	296	328	234	067	077	078	039	135	039	049
3/16	186	191	356	394	281	080	090	094	047	164	047	059
1/4	249	254	475	525	375	107	117	125	062	217	062	078
5/16	311	316	594	658	469	133	143	156	078	272	078	098
3/8	374	379	713	787	562	161	171	188	094	328	094	117
7/16	436	442	832	918	0 625	189	199	219	109	383	110	137

REQUIREMENTS

- MATERIAL** STEEL, CARBON COMPOSITION C1005 THRU C1015, (UNSG10050 THRU UNS G10150) IN ACCORDANCE WITH ASTM A29/A29M ANNEALED AFTER HEADING
STEEL, CORROSION RESISTANT, CLASS 300 SERIES, IN ACCORDANCE WITH ASTM A380, ANNEALED AFTER HEADING
- PROTECTIVE COATING** STEEL, CARBON CADMIUM PLATED PER QQ-P-416, TYPE II, CLASS 2
STEEL, CORROSION RESISTANT, CLEANED DESCALE AND PASSIVATE IN ACCORDANCE WITH QQ-P-35
- SHEAR STRENGTH** CARBON STEEL, 38,000 TO 48,000 PSI
CORROSION RESISTANT STEEL, 85,000 TO 85,000 PSI
- TOLERANCES** UNLESS OTHERWISE SPECIFIED DECIMALS ± 0.10
- CONCENTRICITY** SHANK AND HEAD DIAMETERS SHALL BE CONCENTRIC WITHIN
0.10 FIM FOR RIVET SIZES .062 THRU .125
0.15 FIM FOR RIVET SIZES .156 AND .188
0.20 FIM FOR RIVET SIZES .250 THRU .438
- PART NUMBER** THE PART NUMBER SHALL CONSIST OF THE BASIC MS SHEET NUMBER FOLLOWED BY A DASH NUMBER SIGNIFYING THE NOMINAL DIAMETER IN THIRTY-SECONDS OF AN INCH INCREMENTS FOLLOWED BY A LETTER INDICATING THE REQUIRED MATERIAL AND AN ADDITIONAL NUMBER SIGNIFYING THE NOMINAL LENGTH IN SIXTEENTH OF AN INCH INCREMENTS

EXAMPLE MS20613- 2 P 2

NOMINAL LENGTH (1/16" INCREMENTS)

MATERIAL
P-CARBON STEEL
C-CORROSION RESISTANT STEEL

NOMINAL DIAMETER (1/32" INCREMENTS)

BASIC MS SHEET NUMBER

MS20613-2P2 - INDICATES RIVET SOLID-UNIVERSAL HEAD CARBON STEEL, CADMIUM PLATED 1/16" NOMINAL DIAMETER 1/8" NOMINAL LENGTH

(F) ENTIRE STANDARD REVISED

INCH-POUND

PREPARING ACTIVITY DLA-IS CUSTODIANS ARMY- AR NAVY- OS AIR FORCE- 99 DLA- REVIEW USER PROJECT NUMBER 5320-0813 DISTRIBUTION STATEMENT	MILITARY SPECIFICATION SHEET TITLE RIVET, SOLID-UNIVERSAL HEAD, STEEL, CARBON AND STEEL, CORROSION-RESISTANT	SPECIFICATION SHEET NUMBER MS20613 8 FEB 94 REV F SUPERSEDING MS20613 E 13 JAN 89 (SEE NOTE B) AMSC- N/A FSC 5320
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Page 1 of 3

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NOTES

1. DIMENSIONS DIMENSIONS ARE IN INCHES
2. RIVETS MAY BE FURNISHED WITH PLAIN ENDS OR WITH CHAMFERED END WITH A RADIUS TO THE "T" DIMENSIONS OR A 20° CHAMFER TO THE "S" DIMENSION
3. ILLUSTRATIONS ARE FOR IDENTIFICATION AND ARE NOT INTENDED TO RESTRICT DESIGNS AND SHAPES OF RIVETS WHICH OTHERWISE CONFORM TO REQUIREMENTS
4. UNPLATED CARBON STEEL RIVETS AND ZINC PLATED RIVETS INACTIVE FOR DESIGN AFTER 23 DECEMBER 1960 MS20613 REPLACED THE INACTIVE MS20435 RIVETS OF THE SAME DIAMETER LENGTH AND MATERIAL ON 23 DECEMBER 1960
5. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE
6. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN
7. FOR THE DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER ACQUISITIONS DOCUMENTS REFERENCED HEREIN
8. MS20613 SUPERSEDES MS20435 IN PART

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TABLE II DASH NUMBERS AND DIMENSIONS

LENGTH		CARBON STEEL								
		NOMINAL DIAMETERS								
		062	094	125	156	188	250	312	375	438
		DASH NUMBERS								
1/8	125	2P2		4P3		6P4				
3/16	188	2P3	3P3	4P4	5P4	6P5	8P5			
1/4	250	2P4	3P4	4P5	5P5	6P6	8P6			
5/16	312	2P5	3P5	4P6	5P6	6P7	8P7			
3/8	375	2P6	3P6	4P7	5P7	6P8	8P8			
7/16	438	2P7	3P7	4P8	5P8					
1/2	500	2P8	3P8							
9/16	562									
5/8	625			4P10	5P10	6P10	8P10	10P10		
3/4	750		3P12	4P12	5P12	6P12	8P12	10P12		
7/8	875		3P14	4P14	5P14	6P14	8P14	10P14		
1	1000		3P16	4P16	5P16	6P16	8P16	10P16	12P16	14P16
1-1/8	1125									
1-1/4	1250			4P20	5P20	6P20	8P20	10P20	12P20	14P20
1-3/8	1375									
1-1/2	1500			4P24	5P24	6P24	8P24	10P24	12P24	14P24
1-3/4	1750				5P28	6P28	8P28	10P28	12P28	14P28
2	2000				5P32	6P32	8P32	10P32	12P32	14P32

TABLE III DASH NUMBERS AND DIMENSIONS

LENGTH		CARBON STEEL								
		NOMINAL DIAMETERS								
		062	094	125	156	188	250	312	375	438
		DASH NUMBERS								
1/8	125	2C2		4C3		6C4				
3/16	188	2C3	3C3	4C4	5C4	6C5	8C5			
1/4	250	2C4	3C4	4C5	5C5	6C6	8C6			
5/16	312	2C5	3C5	4C6	5C6	6C7	8C7			
3/8	375	2C6	3C6	4C7	5C7	6C8	8C8			
7/16	438	2C7	3C7	4C8	5C8					
1/2	500	2C8	3C8							
9/16	562									
5/8	625			4C10	5C10	6C10	8C10	10C10		
3/4	750		3C12	4C12	5C12	6C12	8C12	10C12		
7/8	875		3C14	4C14	5C14	6C14	8C14	10C14		
1	1000		3C16	4C16	5C16	6C16	8C16	10C16	12C16	14C16
1-1/8	1125									
1-1/4	1250			4C20	5C20	6C20	8C20	10C20	12C20	14C20
1-3/8	1375									
1-1/2	1500			4C24	5C24	6C24	8C24	10C24	12C24	14C24
1-3/4	1750				5C28	6C28	8C28	10C28	12C28	14C28
2	2000				5C32	6C32	8C32	10C32	12C32	14C32

PREPARING ACTIVITY DLA-IS

CUSTODIANS ARMY- AR

NAVY- OS

AIR FORCE- 99

DLA-

MILITARY SPECIFICATION SHEET

TITLE

RIVET, SOLID-UNIVERSAL HEAD
STEEL, CARBON AND STEEL,
CORROSION-RESISTANT

SPECIFICATION SHEET NUMBER

MS20613

8 FEB 94
REV F

SUPERSEDING

MS20613 E 13 JAN 89 (SEE NOTE 8)

AMSC- N/A

FSC 5320

PROJECT NUMBER 5320-0813

DISTRIBUTION STATEMENT

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Page 2 of 3

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TABLE IV - INACTIVE RIVETS OF MS20435 IN PART, AND UNPLATED AND ZINC PLATED PLATED OF MS20613
ARE AS SHOWN IN NOTE 4 REPLACEMENT SHALL BE IN ACCORDANCE WITH THIS TABLE

MS20435 MS20613		MS20435		MS20613		MS20435		MS20613		MS20435		MS20613		MS20435		MS20613							
INACTIVE				NEW		INACTIVE		NEW		INACTIVE				NEW		INACTIVE		NEW					
CARBON STEEL						CORROSION RESISTANT STEEL						CARBON STEEL						CORROSION RESISTANT STEEL					
UN- PLATED		ZINC PLATED		CADMIUM PLATED								CADMIUM PLATED		UN- PLATED		ZINC PLATED							
DASH NUMBER						DASH NUMBER						DASH NUMBER						DASH NUMBER					
2-2	222	2C2	2P2	F2-2	2C2	6-6	626	6C6	6P6	F6-6	6C6	8-6	826	8C6	8P6	F8-6	8C6	10-6	10C6	10P6			
2-3	223	2C3	2P3	F2-3	2C3	6-7	627	6C7	6P7	F6-7	6C7	8-7	827	8C7	8P7	F8-7	8C7	10-7	10C7	10P7			
2-4	224	2C4	2P4	F2-4	2C4	6-8	628	6C8	6P8	F6-8	6C8	8-8	828	8C8	8P8	F8-8	8C8	10-8	10C8	10P8			
2-5	225	2C5	2P5	F2-5	2C5	6-10	6210	6C10	6P10	F6-10	6C10	8-10	8210	8C10	8P10	F8-10	8C10	10-10	10C10	10P10			
2-6	226	2C6	2P6	F2-6	2C6	6-12	6212	6C12	6P12	F6-12	6C12	8-12	8212	8C12	8P12	F8-12	8C12	10-12	10C12	10P12			
2-7	227	2C7	2P7	F2-7	2C7	6-14	6214	6C14	6P14	F6-14	6C14	8-14	8214	8C14	8P14	F8-14	8C14	10-14	10C14	10P14			
2-8	228	2C8	2P8	F2-8	2C8	6-16	6216	6C16	6P16	F6-16	6C16	8-16	8216	8C16	8P16	F8-16	8C16	10-16	10C16	10P16			
						6-18	6218	6C18	6P18	F6-18	6C18	8-18	8218	8C18	8P18	F8-18	8C18	10-18	10C18	10P18			
3-3	323	3C3	3P3	F3-3	3C3	6-20	6220	6C20	6P20	F6-20	6C20	8-20	8220	8C20	8P20	F8-20	8C20	10-20	10C20	10P20			
3-4	324	3C4	3P4	F3-4	3C4	6-22	6222	6C22	6P22	F6-22	6C22	8-22	8222	8C22	8P22	F8-22	8C22	10-22	10C22	10P22			
3-5	325	3C5	3P5	F3-5	3C5	6-24	6224	6C24	6P24	F6-24	6C24	8-24	8224	8C24	8P24	F8-24	8C24	10-24	10C24	10P24			
3-6	326	3C6	3P6	F3-6	3C6	6-28	6228	6C28	6P28	F6-28	6C28	8-28	8228	8C28	8P28	F8-28	8C28	10-28	10C28	10P28			
3-7	327	3C7	3P7	F3-7	3C7	6-32	6232	6C32	6P32	F6-32	6C32	8-32	8232	8C32	8P32	F8-32	8C32	10-32	10C32	10P32			
3-8	328	3C8	3P8	F3-8	3C8																		
3-10	3210	3C10	3P10	F3-10	3C10																		
3-12	3212	3C12	3P12	F3-12	3C12																		
3-14	3214	3C14	3P14	F3-14	3C14																		
3-16	3216	3C16	3P16	F3-16	3C16																		
4-3	423	4C3	4P3	F4-3	4C3	10-10	10210	10C10	10P10	F10-10	10C10	12-10	12210	12C10	12P10	F12-10	12C10	14-10	14C10	14P10			
4-4	424	4C4	4P4	F4-4	4C4	10-12	10212	10C12	10P12	F10-12	10C12	12-12	12212	12C12	12P12	F12-12	12C12	14-12	14C12	14P12			
4-5	425	4C5	4P5	F4-5	4C5	10-14	10214	10C14	10P14	F10-14	10C14	12-14	12214	12C14	12P14	F12-14	12C14	14-14	14C14	14P14			
4-6	426	4C6	4P6	F4-6	4C6	10-16	10216	10C16	10P16	F10-16	10C16	12-16	12216	12C16	12P16	F12-16	12C16	14-16	14C16	14P16			
4-7	427	4C7	4P7	F4-7	4C7	10-18	10218	10C18	10P18	F10-18	10C18	12-18	12218	12C18	12P18	F12-18	12C18	14-18	14C18	14P18			
4-8	428	4C8	4P8	F4-8	4C8	10-20	10220	10C20	10P20	F10-20	10C20	12-20	12220	12C20	12P20	F12-20	12C20	14-20	14C20	14P20			
4-10	4210	4C10	4P10	F4-10	4C10	10-22	10222	10C22	10P22	F10-22	10C22	12-22	12222	12C22	12P22	F12-22	12C22	14-22	14C22	14P22			
4-12	4212	4C12	4P12	F4-12	4C12	10-24	10224	10C24	10P24	F10-24	10C24	12-24	12224	12C24	12P24	F12-24	12C24	14-24	14C24	14P24			
4-14	4214	4C14	4P14	F4-14	4C14	10-28	10228	10C28	10P28	F10-28	10C28	12-28	12228	12C28	12P28	F12-28	12C28	14-28	14C28	14P28			
4-16	4216	4C16	4P16	F4-16	4C16	10-32	10232	10C32	10P32	F10-32	10C32	12-32	12232	12C32	12P32	F12-32	12C32	14-32	14C32	14P32			
4-20	4220	4C20	4P20	F4-20	4C20																		
4-24	4224	4C24	4P24	F4-24	4C24																		
5-4	524	5C4	5P4	F5-4	5C4																		
5-5	525	5C5	5P5	F5-5	5C5																		
5-6	526	5C6	5P6	F5-6	5C6																		
5-7	527	5C7	5P7	F5-7	5C7																		
5-8	528	5C8	5P8	F5-8	5C8																		
5-10	5210	5C10	5P10	F5-10	5C10																		
5-12	5212	5C12	5P12	F5-12	5C12																		
5-14	5214	5C14	5P14	F5-14	5C14																		
5-16	5216	5C16	5P16	F5-16	5C16																		
5-20	5220	5C20	5P20	F5-20	5C20																		
5-24	5224	5C24	5P24	F5-24	5C24																		
5-28	5228	5C28	5P28	F5-28	5C28																		
5-32	5232	5C32	5P32	F5-32	5C32																		
6-4	624	6C4	6P4	F6-4	6C4																		
6-5	625	6C5	6P5	F6-5	6C5																		

PREPARING ACTIVITY DLA-IS
CUSTODIANS ARMY- AR NAVY- OS
AIR FORCE- 99 DLA-
REVIEW
USER
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TITLE

RIVET SOLID-UNIVERSAL HEAD,
STEEL, CARBON AND STEEL,
CORROSION-RESISTANT

SPECIFICATION SHEET NUMBER

MS20613

8 FEB 94
REV F

SUPERSEDING

MS20613 E 13 JAN 89 (SEE NOTE 8)

AMSC- N/A

FSC 5320

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