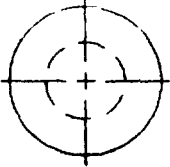


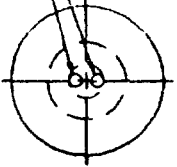
THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE IF THE DODSS SPECIFIED IN THE SOLICITATION FICHS

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

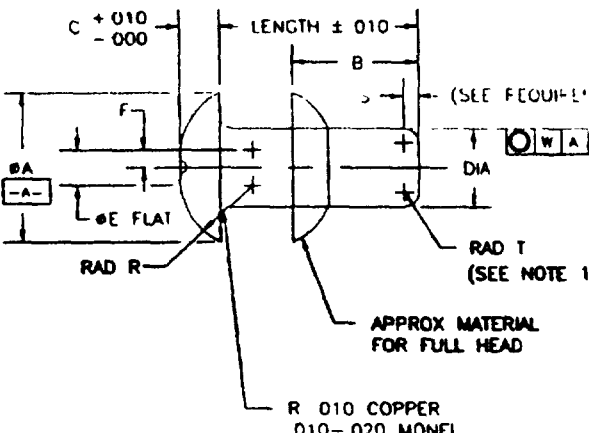
Form Approved
(MIL-STD-883C-1)



COPPER



**NICKEL-COPPER
ALLOY (MONEL)**



TWO (2) RECESSED MATERIAL IDENTIFICATION MARKS ON RIVET HEAD WITHIN THE DIAMETRAL LIMITS OF ØE
Ø 030 MAX x 020 DEEP

(SEE REQUIREMENT 4)

(SEE NOTE 1)

APPROX MATERIAL FOR FULL HEAD

R 010 COPPER
010-020 MONEL

TABLE 1 DIMENSIONS

NOMINAL DIA	DIA	CA	B REF	C	ØE REF	F	R RAD	S	T RAD	W	
1/16	.062	+ .003 - .001	125 ± .006	.054	.027	.031	.015	.054	.016	.019	.020
3/32	.084		167 ± .009	.141	.040	.046	.023	.082	.023	.029	
1/8	.125		250 ± .012	.188	.054	.062	.031	.108	.031	.039	
5/32	.156		312 ± .016	.234	.067	.078	.039	.135	.039	.049	
3/16	.187	+ .004 - .001	375 ± .018	.281	.080	.083	.048	.164	.047	.059	.025
1/4	.250		500 ± .025	.375	.107	.125	.062	.217	.062	.078	
5/16	.312		625 ± .031	.469	.133	.156	.078	.272	.078	.098	
3/8	.375		750 ± .037	.562	.161	.187	.083	.328	.094	.117	
7/16	.437	+ .005 - .001	875 ± .043	.625	.189	.218	.108	.383	.110	.137	.030

REQUIREMENTS

- MATERIAL** COPPER, ASTM B3 (UNS C11000)
NICKEL-COPPER ALLOY (MONEL), QQ-N-281 CLASS A, (UNS N04400)
BRASS, QQ-W-321, ALLOY 270, 1/8 HARD (UNS C27000)
- FINISH** ONLY WHEN SPECIFIED NICKEL-COPPER ALLOY (MONEL) CADMIUM PLATE QQ-P-416 TYPE II CLASS 2
- SHEAR STRENGTH** COPPER, 17,000 PSI TO 30,000 PSI
NICKEL-COPPER ALLOY (MONEL), 49,000 PSI TO 59,000 PSI
- RIVETS MAY BE FURNISHED FLAT OR WITH CHAMFERED ENDS WITH A RADIUS TO THE "T" DIMENSION OR A 20° CHAMFER TO THE "S" DIMENSION
- RIVET SHALL DRIVE COLD SATISFACTORILY WITH A FULL HEAD FREE FROM CRACKS
- RIVETS MUST BE TRUE TO FORM, CONCENTRIC AND FREE FROM INJURIOUS SCALE, FIMS, SEAMS, AND ALL OTHER INJURIOUS DEFECTS.
- PART NUMBER:** THE MS PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER FROM TABLE II. ADDITIONAL 1/32 INCREMENTS MAY BE OBTAINED BY ADDING "R" AFTER THE LAST DASH NUMBER
- EXAMPLE OF PART NUMBER:**
MS20615-2MB = RIVET, UNIVERSAL HEAD, NICKEL COPPER ALLOY, 1/16 INCH DIA. 1/2 INCH LONG
MS20615-2MBR = RIVET, UNIVERSAL HEAD NICKEL COPPER ALLOY 1/16 INCH DIA. 1/2 INCH LONG

(G) ENTIRE DOCUMENT REVISED

PREPARING ACTIVITY DLA-IS
CUSTODIANS ARMY- AV NAVY- AS
AIR FORCE- B2 DLA-

REVIEW 99
USER

FIGURE NUMBER 5320-0528

EDITION STATEMENT

MILITARY SPECIFICATION SHEET

TITLE

RIVET, SOLID-UNIVERSAL HEAD BRASS,
COPPER, NICKEL-COPPER ALLOY

INCH-POUND

SPECIFICATION SHEET NUMBER 13 FEB 1995
MS20615 REV G

SUPERSEDING
MS20615F 30 AUG 1990

AMSC N/A FSC 5320

approved for public release date 12-10-2010

Form App 1
OMI No 4 0155

NOTES

1. DIMENSIONS ARE IN INCHES.
2. UNLESS OTHERWISE SPECIFIED TOLERANCES DECIMALS $\pm .010$.
3. MS20615 CAN UNIVERSALLY REPLACE THE INACTIVE MS20435 RIVETS OF THE SAME MATERIAL SHANK DIAMETER AND LENGTH BUT THE INACTIVE MS20435 RIVETS CANNOT REPLACE THE SUPERSEDING MS20615 RIVETS.

IN THE EVENT OF A CONFLICT THE TEXT OF THIS DOCUMENT AND THE REFERENCE LISTED HEREIN THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.

5. UNLESS OTHERWISE SPECIFIED ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION.

TABLE II DASH NUMBERS

BRASS DASH NO	COPPER DASH NO	MONEL DASH NO	MONEL CADMIUM PLATED	DIA	LENGTH	BRASS DASH NO	COPPER DASH NO	MONEL DASH NO	MONEL CADMIUM PLATED	DIA	LENGTH
-2B2	-2CU2	-2M2	-2MP2	1/16	125	-6B4	-6CU4	-6M4	-6MP4	3/16	250
-2B3	-2CU3	-2M3	-2MP3		187	-6B5	-6CU5	-6M5	-6MP5		125
-2B4	-2CU4	-2M4	-2MP4		250	-6B6	-6CU6	-6M6	-6MP6		125
-2B5	-2CU5	-2M5	-2MP5		312	-6B7	-6CU7	-6M7	-6MP7		250
-2B6	-2CU6	-2M6	-2MP6		375	-6B8	-6CU8	-6M8	-6MP8		250
-2B7	-2CU7	-2M7	-2MP7		438	-6B9	-6CU9	-6M9	-6MP9		250
-2B8	-2CU8	-2M8	-2MP8		500	-6B10	-6CU10	-6M10	-6MP10		250
-2B9			-2MP9		562	-6B11		-6M11	-6MP11		250
						-6B12	-6CU12	-6M12	-6MP12		250
-3B1	-3CU1	-3M1	-3MP1	3/32	250	-6B13		-6M13	-6MP13	1/4	312
-3B2	-3CU2	-3M2	-3MP2		312	-6B14	-6CU14	-6M14	-6MP14		312
-3B3	-3CU3	-3M3	-3MP3		375	-6B15		-6M15	-6MP15		312
-3B4	-3CU4	-3M4	-3MP4		438	-6B16	-6CU16	-6M16	-6MP16		312
-3B5	-3CU5	-3M5	-3MP5		500	-6B17	-6CU17	-6M17	-6MP17		312
-3B6	-3CU6	-3M6	-3MP6		562	-6B18	-6CU18	-6M18	-6MP18		312
-3B7	-3CU7	-3M7	-3MP7		625	-6B19	-6CU19	-6M19	-6MP19		312
-3B8	-3CU8	-3M8	-3MP8		688	-6B20	-6CU20	-6M20	-6MP20		312
-3B9		-3M9	-3MP9		750	-6B21	-6CU21	-6M21	-6MP21		312
-3B10	-3CU10	-3M10	-3MP10	1/8	812	-6B22	-6CU22	-6M22	-6MP22	5/16	375
-3B11		-3M11	-3MP11		875	-6B23	-6CU23	-6M23	-6MP23		438
-3B12	-3CU12	-3M12	-3MP12		938	-6B24	-6CU24	-6M24	-6MP24		500
	-3CU14		-3MP14		1000	-6B25		-6M25	-6MP25		562
	-3CU16		-3MP16		1062	-6B26		-6M26	-6MP26		625
-4B3	-4CU3	-4M3	-4MP3		187	-6B27	-6CU27	-6M27	-6MP27		688
-4B4	-4CU4	-4M4	-4MP4		250	-6B28	-6CU28	-6M28	-6MP28		750
-4B5	-4CU5	-4M5	-4MP5		312	-6B29	-6CU29	-6M29	-6MP29		812
-4B6	-4CU6	-4M6	-4MP6		375	-6B30	-6CU30	-6M30	-6MP30		875
-4B7	-4CU7	-4M7	-4MP7	5/32	438	-6B31		-6M31	-6MP31	3/8	938
-4B8	-4CU8	-4M8	-4MP8		500	-6B32		-6M32	-6MP32		1000
-4B9		-4M9	-4MP9		562	-10B10	-10CU10	-10M10	-10MP10		1062
-4B10	-4CU10	-4M10	-4MP10		625	-10B11	-10CU11	-10M11	-10MP11		1125
-4B11		-4M11	-4MP11		688	-10B12	-10CU12	-10M12	-10MP12		1188
-4B12	-4CU12	-4M12	-4MP12		750	-10B13	-10CU13	-10M13	-10MP13		1250
-4B13		-4M13	-4MP13		812	-10B14	-10CU14	-10M14	-10MP14		1312
-4B14	-4CU14	-4M14	-4MP14		875	-10B15	-10CU15	-10M15	-10MP15		1375
-4B15		-4M15	-4MP15		938	-10B16	-10CU16	-10M16	-10MP16		1438
-4B16	-4CU16	-4M16	-4MP16	5/16	1000	-10B17	-10CU17	-10M17	-10MP17	7/16	1500
-4B17		-4M17	-4MP17		1062	-10B18	-10CU18	-10M18	-10MP18		1562
-4B18		-4M18	-4MP18		1125	-10B19	-10CU19	-10M19	-10MP19		1625
-4B19		-4M19	-4MP19		1188	-10B20	-10CU20	-10M20	-10MP20		1688
-4B20		-4M20	-4MP20		1250	-10B21	-10CU21	-10M21	-10MP21		1750
-5B4		-5M4	-5MP4		250	-10B22	-10CU22	-10M22	-10MP22		1812
-5B5		-5M5	-5MP5		312	-10B23	-10CU23	-10M23	-10MP23		1875
-5B6	-5CU6	-5M6	-5MP6		375	-10B24	-10CU24	-10M24	-10MP24		1938
-5B7	-5CU7	-5M7	-5MP7		438	-10B25	-10CU25	-10M25	-10MP25		2000
-5B8	-5CU8	-5M8	-5MP8	3/4	500	-10B26	-10CU26	-10M26	-10MP26	1	2062
-5B9		-5M9	-5MP9		562	-10B27	-10CU27	-10M27	-10MP27		2125
-5B10	-5CU10	-5M10	-5MP10		625	-10B28	-10CU28	-10M28	-10MP28		2188
-5B11		-5M11	-5MP11		688	-10B29	-10CU29	-10M29	-10MP29		2250
-5B12	-5CU12	-5M12	-5MP12		750	-10B30	-10CU30	-10M30	-10MP30		2312
-5B13		-5M13	-5MP13		812	-10B31	-10CU31	-10M31	-10MP31		2375
-5B14	-5CU14	-5M14	-5MP14		875	-10B32	-10CU32	-10M32	-10MP32		2438
-5B15		-5M15	-5MP15		938	-12B12	-12CU12	-12M12	-12MP12	1 1/8	2500
-5B16	-5CU16	-5M16	-5MP16		1000	-12B13	-12CU13	-12M13	-12MP13		2562
-5B17		-5M17	-5MP17		1062	-12B14	-12CU14	-12M14	-12MP14		2625
-5B18		-5M18	-5MP18		1125	-12B15	-12CU15	-12M15	-12MP15		2688
-5B19		-5M19	-5MP19		1188	-12B16	-12CU16	-12M16	-12MP16		2750
-5B20		-5M20	-5MP20		1250	-12B17	-12CU17	-12M17	-12MP17		2812
-5B21		-5M21	-5MP21		1312	-12B18	-12CU18	-12M18	-12MP18		2875
-5B22		-5M22	-5MP22		1375	-12B19	-12CU19	-12M19	-12MP19		2938
-5B23		-5M23	-5MP23		1438	-12B20	-12CU20	-12M20	-12MP20		3000
-5B24		-5M24	-5MP24	1 1/4	1500	-12B21	-12CU21	-12M21	-12MP21	1 1/4	3062
-5B25		-5M25	-5MP25		1562	-12B22	-12CU22	-12M22	-12MP22		3125
-5B26		-5M26	-5MP26		1625	-12B23	-12CU23	-12M23	-12MP23		3188
-5B27		-5M27	-5MP27		1688	-12B24	-12CU24	-12M24	-12MP24		3250
-5B28		-5M28	-5MP28		1750	-12B25	-12CU25	-12M25	-12MP25		3312
-5B29		-5M29	-5MP29		1812	-12B26	-12CU26	-12M26	-12MP26		3375
-5B30		-5M30	-5MP30		1875	-12B27	-12CU27	-12M27	-12MP27		3438
-5B31		-5M31	-5MP31		1938	-12B28	-12CU28	-12M28	-12MP28		3500
-5B32		-5M32	-5MP32		2000	-12B29	-12CU29	-12M29	-12MP29		3562

FEDERATION ACTIVITY DLA-15

DIAGNOSIS ARMY- AV NAVY- AS

AIR FORCE- B2 DLA-

RE 24 99

US

NUMBER 5370 0828

FORM 12/19/99

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MILITARY SPECIFICATION SHEET

TITLE
RIVET, SOLID-UNIVERSAL HEAD, BRASS
COPPER NICKEL-COPPER ALLOY

SPECIFICATION SHEET NUMBER

MS20615

13 FEB 1995

REV 1

SUPERSEDING

MS20615F 30 AUG 1990

AMSC N/A

FSC 5370

Page 1

FORM 12/19/99 MAY 98

THE REQUIREMENTS FOR ACHIEVING THE PRODUCT(S) DESCRIBED HEREIN SHALL BE THE DOD-5 SPECIFICATION SHEET AND THE ISSUE OF THIS FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DOD-5 SPECIFICATION SHEET.

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

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 SPECIFICATION SHEET. THE SOLICITATION NONE

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

Form Approved
OMB No 0704-0188

TABLE # INTERCHANGEABILITY TABLE

DASH NUMBERS					
MONEL		MONEL CADMIUM PLATED		COPPER	
INACTIVE	REPLACEMENT	INACTIVE	REPLACEMENT	INACTIVE	REPLACEMENT
MS20435	MS20615	MS20435	MS20615	MS20435	MS20615
-M2-2	-2M2	-M2C2	-2MP2	-CU2-2	-2CU2
-M2-3	-2M3	-M2C3	-2MP3	-CU2-3	-2CU3
-M2-4	-2M4	-M2C4	-2MP4	-CU2-4	-2CU4
-M2-5	-2M5	-M2C5	-2MP5	-CU2-5	-2CU5
-M2-6	-2M6	-M2C6	-2MP6	-CU2-6	-2CU6
-M2-7	-2M7	-M2C7	-2MP7	-CU2-7	-2CU7
-M2-8	-2M8	-M2C8	-2MP8	-CU2-8	-2CU8
-M3-3	-3M3	-M3C3	-3MP3	-CU3-3	-3CU3
-M3-4	-3M4	-M3C4	-3MP4	-CU3-4	-3CU4
-M3-5	-3M5	-M3C5	-3MP5	-CU3-5	-3CU5
-M3-6	-3M6	-M3C6	-3MP6	-CU3-6	-3CU6
-M3-7	-3M7	-M3C7	-3MP7	-CU3-7	-3CU7
-M3-8	-3M8	-M3C8	-3MP8	-CU3-8	-3CU8
-M3-10	-3M10	-M3C10	-3MP10	-CU3-10	-3CU10
-M3-12	-3M12	-M3C12	-3MP12	-CU3-12	-3CU12
-M3-14	--	--	--	-CU3-14	-3CU14
-M3-16	--	--	--	-CU3-16	-3CU16
-M4-3	-4M3	-M4C3	-4MP3	-CU4-3	-4CU3
-M4-4	-4M4	-M4C4	-4MP4	-CU4-4	-4CU4
-M4-5	-4M5	-M4C5	-4MP5	-CU4-5	-4CU5
-M4-6	-4M6	-M4C6	-4MP6	-CU4-6	-4CU6
-M4-7	-4M7	-M4C7	-4MP7	-CU4-7	-4CU7
-M4-8	-4M8	-M4C8	-4MP8	-CU4-8	-4CU8
-M4-10	-4M10	-M4C10	-4MP10	-CU4-10	-4CU10
-M4-12	-4M12	-M4C12	-4MP12	-CU4-12	-4CU12
-M4-14	-4M14	-M4C14	-4MP14	-CU4-14	-4CU14
-M4-16	-4M16	-M4C16	-4MP16	-CU4-16	-4CU16
-M4-18	-4M18	-M4C18	-4MP18	--	--
-M5-4	-5M4	-M5C4	-5MP4	--	--
-M5-5	-5M5	-M5C5	-5MP5	--	--
-M5-6	-5M6	-M5C6	-5MP6	-CU5-6	-5CU6
-M5-7	-5M7	-M5C7	-5MP7	-CU5-7	-5CU7
-M5-8	-5M8	-M5C8	-5MP8	-CU5-8	-5CU8
-M5-10	-5M10	-M5C10	-5MP10	-CU5-10	-5CU10
-M5-12	-5M12	-M5C12	-5MP12	-CU5-12	-5CU12
-M5-14	-5M14	-M5C14	-5MP14	-CU5-14	-5CU14
-M5-16	-5M16	-M5C16	-5MP16	-CU5-16	-5CU16
-M5-18	-5M18	-M5C18	-5MP18	--	--
-M6-4	-6M4	--	--	--	--
-M6-5	-6M5	--	--	--	--
-M6-6	-6M6	--	--	-CU6-6	-6CU6
-M6-7	-6M7	--	--	-CU6-7	-6CU7
-M6-8	-6M8	--	--	-CU6-8	-6CU8
-M6-10	-6M10	--	--	-CU6-10	-6CU10
-M6-12	-6M12	--	--	-CU6-12	-6CU12
-M6-14	-6M14	--	--	-CU6-14	-6CU14
-M6-16	-6M16	--	--	-CU6-16	-6CU16
-M6-18	-6M18	--	--	-CU6-18	-6CU18
-M6-20	-6M20	--	--	-CU6-20	-6CU20
-M6-22	-6M22	--	--	-CU6-22	-6CU22
-M6-24	-6M24	--	--	-CU6-24	-6CU24
-M8-5	-8M5	--	--	--	--
-M8-6	-8M6	--	--	--	--
-M8-7	-8M7	--	--	--	--
-M8-8	-8M8	--	--	--	--
-M8-10	-8M10	--	--	--	--
-M8-12	-8M12	--	--	--	--
-M8-14	-8M14	--	--	--	--
-M8-16	-8M16	--	--	--	--
-M8-20	-8M20	--	--	--	--
-M8-24	-8M24	--	--	--	--

PREF-ENG ACTIVITY DLA-15

CUSTOMERS ARMY- AV NAVY- AS

AIR FORCE- 82 DLA-

REVIEW 99

USER

PROJ NUMBER 5320-0828

FIG 1-1000 1000

MILITARY SPECIFICATION SHEET

TITLE

RIVET, SOLID-UNIVERSAL HEAD, BRASS,
COPPER NICKEL-COPPER ALLOY

SPECIFICATION SHEET NUMBER 13 FEB 1995

MS20615

REV C

SUPERSEDING

MS20615F 30 AUG 1990

AMSC- N/A

FSC 5320

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Page 3 of 3

DD Form 672 MAY 88

FORM 672