

FED SUP CLASS
5320

OPTIONAL DESIGNS

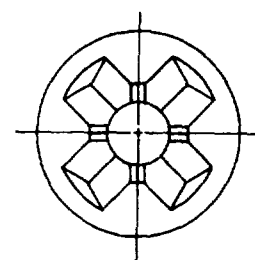
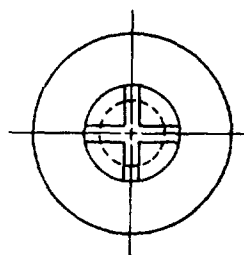
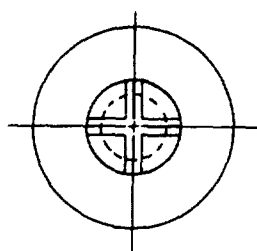
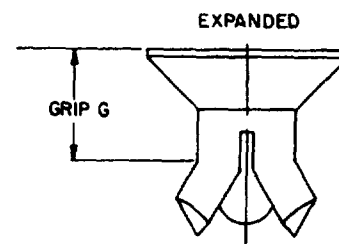
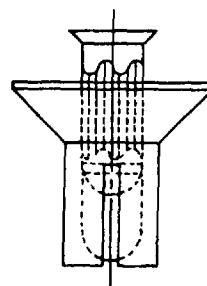
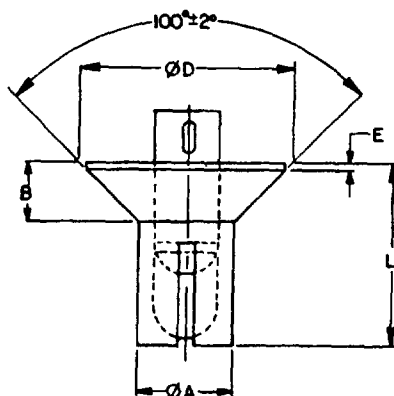


TABLE I DASH NUMBERS AND DIMENSIONS

ALUMINUM ALLOY		CARBON STEEL	Ø A		B	Ø D	E		G		L
2117-T4	5056-H132		ALUMINUM ALLOY	CARBON STEEL	HEAD HEIGHT REF	HEAD	ALUMINUM ALLOY	CARBON STEEL	RECOMMENDED DRILL SIZE	GRIP LENGTH MIN MAX	LENGTH +.030 - .010
DASH NUMBER											
-5	-168	-6								078 109	188
-7	-169	-8								110 140	219
-9	-170	-10								141 171	250
-11	-171	-12								172 203	281
-13	-172	-14								204 234	312
-15	-173	-16	.25	.25	040	229	006	0.1	30	235 265	344
-17	-174	-18	+ .002	+ .002		22	002	005	(128)	266 296	375
-19	-175	-20	- .001	- .004						297 328	406
-21	-176	-22								329 359	438
-23	-177	-24								360 390	469
-25	-178	-26								391 421	500
-31	-179	-32								109 140	250
-33	-180	-34								141 171	281
-35	-181	-36								172 203	312
-37	-182	-38								204 234	344
-39	-183	-40								235 265	375
-41	-184	-42								266 296	406
-43	-185	-44								297 328	438
-45	-186	-46	.56	.56	055	290	007	0.3	20	329 359	469
-47	-187	-48	+ .002	+ .002		281	003	007	(161)	360 390	500
-49	-188	-50	- .001	- .004						391 421	531
-51	-189	-52								422 453	562
-53	-190	-54								454 484	594
-55	-191	-56								485 515	625
-57	-192	-58								516 546	656
-59	-193	-60								547 578	688
-61	-194	-61								579 609	719
-63	-195	-64								610 640	750

© ENTIRE STANDARD REVISED

ARMY-AR Other Cost	INTERNATIONAL INTEREST	TITLE RIVET, BLIND-COUNTERSUNK HEAD, DRIVE TYPE	MILITARY STANDARD MS24661
AIR FORCE-82			
PROCUREMENT SPECIFICATION MIL-R-27384	SUPERSEDES MS20605, IN PART	PAGE 1 OF 3	

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0627

USER ACTIVITIES
ARMY-ER, GL
NAVY-AS, MC, SHREVIEWER ACTIVITIES
ARMY-AT, AV, ME, MI
AIR FORCE-
DLA-IS
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AMSC N/A

APPROVED 29 FEB 60 REVISED A 30 JUN 65 B 28 OCT 70 C 12 MAR 87

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TABLE 1. DASH NUMBERS AND DIMENSIONS - CONTINUED

ALUMINUM ALLOY		CARBON STEEL	ϕ A		B	ϕ D	E		RECOMMENDED DRILL SIZE	G		L
2117-T4	5056-H32		ALUMINUM ALLOY	CARBON STEEL	HEAD HEIGHT REF	HEAD	ALUMINUM ALLOY	CARBON STEEL		GRIP LENGTH		LENGTH + .030 - .010
DASH NUMBER										MIN	MAX	
-150	-196	-214								.109	.171	.281
-151	-197	-215								.172	.234	.344
-152	-198	-216								.235	.296	.406
-153	-199	-217								.297	.359	.469
-154	-200	-218	.188 +.002	.188 +.002	.070	.357 .349	.009 .003	.013 .007	11 (.191)	.360	.421	.531
-155	-201	-219	-.003	-.004						.422	.484	.594
-156	-202	-220								.485	.546	.656
-157	-203	-221								.547	.609	.719
-158	-204	-222								.610	.671	.781
-159	-205	-223								.109	.171	.281
-160	-206	-224								.172	.234	.344
-161	-207	-225								.235	.296	.406
-162	-208	-226								.297	.359	.469
-163	-209	-227	.250 +.002	.250 +.002	.095	.480 .472	.011 .005	.015 .009	F (.257)	.360	.421	.531
-164	-210	-228	-.003	-.004						.422	.484	.594
-165	-211	-229								.485	.546	.656
-166	-212	-230								.547	.609	.719
-167	-213	-231								.610	.671	.781

REQUIREMENTS

- MATERIAL.** BODY, ALUMINUM ALLOY, GRADE 2117-T4 (UNS A92117) OR GRADE 5056-H32 (UNS A95056), IN ACCORDANCE WITH QQ-A-430.
BODY, CARBON STEEL, GRADES C1006 (UNS G10060) THROUGH C1041 (UNS G10410), IN ACCORDANCE WITH ASTM A545
PIN, CRES, TYPES 302 (UNS S30200) OR 305 (UNS S30500), IN ACCORDANCE WITH ASTM A580 (FOR BODY, ALUMINUM ALLOY, GRADE 2117-T4 (UNS A92117)).
PIN, CRES, TYPE 305 (UNS S30500), IN ACCORDANCE WITH ASTM A580 (FOR BODY, ALUMINUM ALLOY, GRADE 5056-H32 (UNS A95056)).
PIN, CRES, TYPES 302 (UNS S30200) OR 305 (UNS S30500) OR CARBON STEEL, GRADES C1006 (UNS G10060) THROUGH C1041 (UNS G10410), (FOR BODY, CARBON STEEL).
- PROTECTIVE COATING AND SURFACE TREATMENT:** CARBON STEEL BODY AND PINS SHALL BE CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 2.
ALUMINUM ALLOY BODIES, GRADE 2117-T4 (UNS A92117), SHALL BE ANODIZED IN ACCORDANCE WITH MIL-A-8625 OR CHEMICALLY SURFACE TREATED IN ACCORDANCE WITH MIL-C-5541.
IT IS NOT NECESSARY TO ANODIZE ALUMINUM ALLOY BODIES GRADE 5056-H32 (UNS A95056)
CRES PINS SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380
- HEAT TREATMENT** RIVETS SHALL BE HEAT TREATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION
- PART NUMBER.** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1

EXAMPLE MS24661-5

DASH NUMBER

BASIC MS NUMBER

MS24661-5 INDICATES RIVET, BLIND - COUNTERSUNK HEAD, DRIVE TYPE; ALUMINUM ALLOY 2117-T4 (UNS A92117), DIAMETER .125, LENGTH .188.

NOTES:

- ALL DIMENSIONS ARE IN INCHES
- THE SLOTTED SHANKS OF .125 INCH RIVETS MAY PRODUCE TWO (2) THROUGH FOUR (4) EXPANDING SEGMENTS. SLOTTED RIVET SHANKS ABOVE .125 INCH MAY PRODUCE THREE (3) OR FOUR (4) EXPANDING SEGMENTS.
- ILLUSTRATIONS ARE FOR IDENTIFICATION AND ARE NOT INTENDED TO RESTRICT DESIGN AND SHAPE OF RIVETS WHICH OTHERWISE CONFORM TO REQUIREMENTS
- FOR BLIND SIDE PROTRUSION, THE MAXIMUM OVERALL LENGTH, LESS MAXIMUM PANEL THICKNESS, SHALL BE USED
- 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.
- REFERENCED GOVERNMENT (OR NONGOVERNMENT) 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.

P A ARMY-AR Other Cust	INTERNATIONAL INTEREST	TITLE RIVET, BLIND-COUNTERSUNK HEAD, DRIVE TYPE	MILITARY STANDARD MS24661
AIR FORCE-82			
PROCUREMENT SPECIFICATION MIL-R-27384	SUPERSEDES: MS20605, IN PART	PAGE 2 OF 3	

DD FORM 672-1 (COORDINATED)
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USER ACTIVITIES:
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TABLE 11 INTERCHANGEABILITY

THE RIVETS COVERED BY DASH NUMBERS GIVEN IN REVISION A OF THIS STANDARD AND MS20605 IN PART, ARE CANCELLED AFTER 28 OCT 1970. USE THE DASH NUMBERS GIVEN IN THE PRECEDING SHEETS OF THIS REVISION. THE CANCELLED RIVETS CANNOT ALWAYS REPLACE THE NEW RIVETS AND SHOULD BE USED UNTIL EXISTING STOCKS ARE DEPLETED. USE ONLY THE NEW RIVETS FOR DESIGN AND REPLACEMENT. REPLACEMENT SHALL BE IN ACCORDANCE WITH THIS TABLE.

DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER	
CANCELLED	NEW	CANCELLED	NEW	CANCELLED	NEW	CANCELLED	NEW	CANCELLED	NEW
MS24661	MS24661	MS24661	MS24661	MS20605	MS24661	MS20605	MS24661	MS20605	MS24661
"A" REV	"B" REV	"A" REV	"B" REV	"A" REV	"B" REV	"A" REV	"B" REV	"A" REV	"B" REV
1	1/	114	224	AD5H6	39	B4H6	175	MAH1	2/
2	1/	115	161	AD5H6	41	B4H6	176	MAH2	2/
3	1/	116	225	AD5H6	43	B4H6	177	MAH3	2/
4	1/	117	161	AD5H6	45	B4H7	177	MAH4	2/
27	1/	118	225	AD5H6	47	B4H7	178	MAH5	2/
28	1/	119	162	AD5H8	47	B4H8	1/	MAH6	2/
29	1/	120	226	AD5H8	49	B5H2	179	MAH7	2/
30	1/	121	162	AD5H8	51	B5H4	179	MAH8	2/
65	1/	122	226	AD5H8	53	B5H4	180	MSH2	2/
66	1/	123	163	AD5H8	55	B5H4	181	MSH4	2/
67	1/	124	227	AD6H2	150	B5H4	182	MSH6	2/
68	1/	125	163	AD6H4	150	B5H4	183	MSH8	2/
69	150	126	227	AD6H4	151	B5H6	183	MSH2	2/
70	214	127	164	AD6H4	152	B5H6	184	MSH4	2/
71	150	128	228	AD6H6	152	B5H6	185	MSH6	2/
72	214	129	164	AD6H6	153	B5H6	186	MSH8	2/
73	151	130	228	AD6H6	154	B5H6	187	MSH10	2/
74	215	131	165	AD6H8	154	B5H8	187	MSH12	2/
75	151	132	229	AD6H8	155	B5H8	188	MSH14	2/
76	215	133	165	AD6H8	156	B5H8	189	MSH4	2/
77	152	134	229	AD6H10	156	B5H8	190	MSH6	2/
78	216	135	166	AD6H10	157	B5H8	191	MSH8	2/
79	152	136	230	AD6H10	158	B6H2	196	MSH10	2/
80	216	137	166	AD6H12	158	B6H4	196	MSH12	2/
81	153	138	230	AD6H14	1/	B6H4	197	MSH14	2/
82	217	139	167	AD8H4	159	B6H4	198	MSH16	2/
83	153	140	231	AD8H4	160	B6H6	198		
84	217			AD8H4	161	B6H6	199	MP3H1	2/
85	154	MS20605		AD8H6	161	B6H6	200	MP3H2	2/
86	218	AD3H1	1/	AD8H6	162	B6H8	200	MP3H3	2/
87	154	AD3H2	1/	AD8H6	163	B6H8	201	MP3H4	2/
88	218	AD3H3	1/	AD8H8	163	B6H8	202	MP4H1	2/
89	155	AD3H4	1/	AD8H8	164	B6H10	202	MP4H2	2/
90	219	AD4H1	1/	AD8H8	165	B6H10	203	MP4H3	2/
91	155	AD4H2	5	AD8H10	165	B6H10	204	MP4H4	2/
92	219	AD4H2	7	AD8H10	166	B6H12	204	MP4H5	2/
93	156	AD4H3	7	AD8H10	167	B6H14	1/	MP4H6	2/
94	220	AD4H3	9	AD8H12	167	B8H4	205	MP4H7	2/
95	156	AD4H3	11	AD8H14	1/	B8H4	206	MP4H8	2/
96	220	AD4H4	11	AD8H16	1/	B8H4	207	MP5H2	2/
97	157	AD4H4	13			B8H6	207	MP5H4	2/
98	221	AD4H4	15	B3H1	1/	B8H6	208	MP5H6	2/
99	157	AD4H5	15	B3H2	1/	B8H6	209	MP5H8	2/
100	221	AD4H5	17	B3H3	1/	B8H8	209	MP6H2	2/
101	158	AD4H5	19	B3H4	1/	B8H8	210	MP6H4	2/
102	222	AD4H6	19	B4H1	1/	B8H8	211	MP6H6	2/
103	1/	AD4H6	21	B4H2	168	B8H10	211	MP6H8	2/
104	1/	AD4H6	23	B4H2	169	B8H10	212	MP6H10	2/
105	1/	AD4H7	23	B4H3	169	B8H10	213	MP6H12	2/
106	1/	AD4H7	25	B4H3	170	B8H12	213	MP6H14	2/
107	159	AD4H8	1/	B4H3	171	B8H14	1/	MP8H4	2/
108	223	AD5H2	31	B4H4	171	B8H16	1/	MP8H6	2/
109	159	AD5H4	31	B4H4	172			MP8H8	2/
110	223	AD5H4	33	B4H4	173	MDH1	2/	MP8H10	2/
111	160	AD5H4	35	B4H5	173	MDH2	2/	MP8H12	2/
112	224	AD5H4	37	B4H5	174	MDH3	2/	MP8H14	2/
113	160	AD5H4	39	B4H5	175	MDH4	2/	MP8H16	2/

1/ NO REPLACEMENT
2/ NOT MANUFACTURED

P A ARMY-AR Other Cost		TITLE RIVET, BLIND-COUNTERSUNK HEAD, DRIVE TYPE	MILITARY STANDARD	
AIR FORCE-82			MS24661	
PROCUREMENT SPECIFICATION MIL-R-27384		SUPERSEDES: MS20605, IN PART		PAGE 3 OF 3

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