

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 DODDIS SPECIFIED IN THE SOLICITATION: NONE

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

SWAGED-COLLAR HEADED STRAIGHT FASTENERS (E.G., LOCKBOLTS, HI-SHEAR RIVETS, ETC.) OF THE FLUSH HEAD AND PROTRUDING HEAD STYLES, DESIGNED FOR INSTALLATION, BY EITHER THE PULL GUN METHOD OR THE HAMMER AND BUCKED METHOD, ARE SUBJECT TO THE FOLLOWING USAGE LIMITATIONS:

1. THEY SHALL BE USED ONLY IN ACCORDANCE WITH THE LOAD ALLOWABLES AS SPECIFIED IN MIL-HDBK-5.
2. THEY SHALL NOT BE USED IN APPLICATIONS WHERE THEY WOULD BE SUBJECT TO REMOVAL OR FREQUENT REPLACEMENT DURING ROUTINE SERVICING AND OVERHAUL. FOR THOSE APPLICATIONS WHICH MAY BE SUBJECT TO REPAIR AND REPLACEMENT, ADEQUATE PROVISIONS SHALL BE MADE TO PERMIT THEIR REPLACEMENT BY APPLICABLE STANDARD BOLTS.
3. FLUSH HEAD STYLES SHALL BE USED IN CONJUNCTION WITH EITHER MACHINE COUNTER-SINKING OR MACHINE SUB-COUNTERSINKING, WHEREIN THE SHEET NEXT TO THE HEAD IS DIMPLED. THEY SHALL NOT BE USED IN DOUBLE DIMPLED APPLICATIONS OR IN APPLICATIONS WHERE THE SHEET NEXT TO THE COLLAR IS DIMPLED, EXCEPT WHERE A SPECIAL COLLAR ADAPTABLE TO DOUBLE DIMPLING IS SPECIFIED.
4. THEY SHALL BE INSTALLED IN CONFORMANCE WITH THE MANUFACTURER'S RECOMMENDED PRACTICE, AND SHALL BE INSPECTED IN ACCORDANCE WITH, OR BY A METHOD EQUIVALENT TO, THE PROCEDURE RECOMMENDED BY THE MANUFACTURER.
5. PAINTING PRIOR TO ASSEMBLY IS NOT REQUIRED, BUT EACH END SHALL RECEIVE A COAT OF ZINC CHROMATE PRIMER AS NECESSARY TO COMPLY WITH THE GENERAL AIRCRAFT FINISH SCHEDULE APPLICABLE TO NUTS, BOLTS, AND OTHER ATTACHING PARTS.
6. MAGNETIC INSPECTION OF PULL-GUN DRIVEN TYPES SHALL NOT BE REQUIRED, HOWEVER, THE BUCKED TYPES SHALL BE SUBJECT TO MAGNETIC PARTICLE INSPECTION BY LONGITUDINAL MAGNETIZATION UNDER A RANDOM SAMPLING PLAN IN ACCORDANCE WITH MILITARY STANDARD, MIL-STD-105, INSPECTION LEVEL II WITH AN AQL OF 1.2%.

NOTE: CAUTION SHOULD BE TAKEN DURING COATING PROCESS. THE CONTRACTOR SHALL BE RESPONSIBLE FOR THE SAFE REUTILIZATION AND DISPOSAL OF ALL MATERIAL GENERATED BY THESE PROCESSES IN ACCORDANCE WITH ASTM A380, SECTIONS 8.2 AND 8.7.

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

INCH-POUND

PREPARING ACTIVITY: AIR FORCE - 82 CUSTODIANS: ARMY- NAVY- AS AIR FORCE- 99 DLA- IS REVIEW: DLA - IS USER: PROJECT NUMBER: 5325 0258	TITLE MILITARY SPECIFICATION SHEET FASTENERS, STRAIGHT, HEADED, SWAGED COLLAR LIMITATIONS FOR USE OF	SPECIFICATION SHEET NUMBER MS25420B 5 November 1991 SUPERSEDING MS25420A, 21 JUN 62 AMSC. N/A FSC. 5325
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