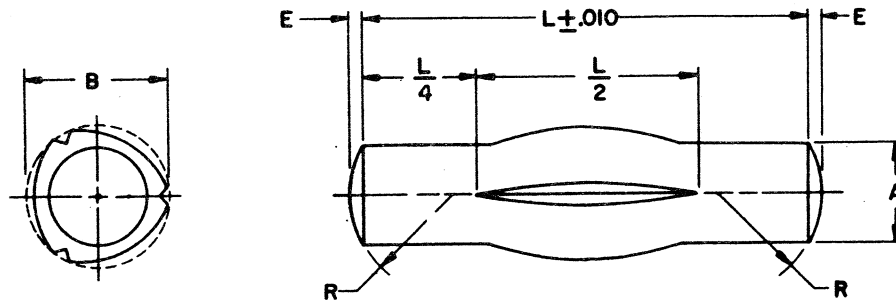


REVIEWER: MI, MO, MU, WC, SH, WP, 69, IS  
USER: MC, YD, NSA

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FED. SUP CLASS  
5315



| NOMINAL SIZE                |          | 1/16         | 5/64     | 3/32         | 1/8      | 5/32         |
|-----------------------------|----------|--------------|----------|--------------|----------|--------------|
| A DIAMETER                  | MAX      | .0625        | .0781    | .0938        | .1250    | .1563        |
|                             | MIN      | .0615        | .0771    | .0928        | .1230    | .1543        |
| E *CROWN HEIGHT             | REF      | .0065        | .0087    | .0091        | .0130    | .0170        |
| R RADIUS                    | MAX      | .0881        | .1037    | .1350        | .1662    | .1975        |
|                             | MIN      | .0681        | .0837    | .1150        | .1462    | .1775        |
| RECOMMENDED HOLE SIZE       | MAX      | .0640        | .0798    | .0956        | .1271    | .1587        |
|                             | MIN      | .0625        | .0781    | .0938        | .1250    | .1563        |
| SINGLE SHEAR STRENGTH - LBS | MIN      | 200          | 310      | 440          | 790      | 1230         |
| L LENGTH                    | DASH NO. | B DIA. ±.001 | DASH NO. | B DIA. ±.001 | DASH NO. | B DIA. ±.002 |
|                             |          |              |          |              |          |              |
| 1/4                         | 1        | .068         |          |              |          |              |
| 3/8                         | 2        | .068         | 6        | .084         | 10       | .101         |
| 1/2                         | 3        | .068         | 7        | .084         | 11       | .101         |
| 5/8                         | 4        | .068         | 8        | .084         | 12       | .101         |
| 3/4                         | 5        | .068         | 9        | .084         | 13       | .101         |
| 1                           |          |              |          |              | 14       | .101         |
| 1-1/4                       |          |              |          |              | 20       | .134         |
| 1-1/2                       |          |              |          |              | 21       | .134         |

For additional sizes see sheet 2.

**MATERIAL:** Steel, cold-drawn, B1112 or 1212, in accordance with the procurement specification.

**PROTECTIVE COATING:** Cadmium plate in accordance with the procurement specification.

**APPLICATION:** Grooved pins are locked securely in place by elastic deformation eliminating the need for tapping or reaming of tapered or sized holes.

**DIMENSIONS:** All dimensions are in inches unless otherwise specified.

**PART NUMBER:** The MS part number consists of the MS number plus the dash number. Example: MS35677-1.

**NOTES:** (1) Dash numbers for cadmium plated pins as shown on this revised standard are the same as the dash numbers for the cadmium or zinc plated (optional) pins shown on the original standard.

(2) Diameter "B" is the expanded diameter as measured with a ring gage.

(3) Ends of pins may be square with .01-inch to .02-inch radius on the edges.

(4) For design feature purposes, this standard takes precedence over procurement documents referenced herein.

(5) Referenced documents shall be of the issue in effect on date of invitations for bid.

(A) ENTIRE STANDARD REVISED

|  |  |                               |
|--|--|-------------------------------|
| P.A. WC<br>Other Cust WP<br>69           | TITLE<br>PIN, GROOVED, HEADLESS- LONGITUDINAL<br>CENTER GROOVE, CARBON STEEL | MILITARY STANDARD<br>MS 35677 |
| PROCUREMENT SPECIFICATION<br>MIL-P-20700 | SUPERSEDES:<br>BFCX4.1 and in part AEGX2                                     | SHEET 1 OF 2                  |

REVIEWER: MI, MO, MU, WC, SH, WP, 69, IS  
USER: MC, YD, NSA

| FED. SUP CLASS<br>5315   |               |   |              |          |              |          |              |                               |              |          |              |
|--|---------------|---|--------------|----------|--------------|----------|--------------|-------------------------------|--------------|----------|--------------|
| NOMINAL SIZE   |               | 3/16  |              | 7/32     |              | 1/4      |              | 3/8                           |              |          |              |
| A  | DIAMETER      | MAX   | .1875        |          | .2188        |          | .2500        |                               | .3750        |          |              |
|  |               | MIN   | .1855        |          | .2168        |          | .2480        |                               | .3730        |          |              |
| E  | *CROWN HEIGHT | REF   | .0180        |          | .0220        |          | .0260        |                               | .0390        |          |              |
| R  | RADIUS        | MAX   | .2600        |          | .2912        |          | .3225        |                               | .4787        |          |              |
|  |               | MIN   | .2400        |          | .2712        |          | .3025        |                               | .4587        |          |              |
| RECOMMENDED HOLE SIZE  |               | MAX   | .1903        |          | .2219        |          | .2534        |                               | .3797        |          |              |
|  |               | MIN   | .1875        |          | .2188        |          | .2500        |                               | .3750        |          |              |
| SINGLE SHEAR STRENGTH - LBS  |               | MIN   | 1770         |          | 2400         |          | 3140         |                               | 7070         |          |              |
| L  | LENGTH        | DASH NO.  | B DIA. ±.002 | DASH NO. | B DIA. ±.002 | DASH NO. | B DIA. ±.002 | DASH NO.                      | B DIA. ±.002 | DASH NO. | B DIA. ±.002 |
|  | 1/2           | 28  | .198         |          |              |          |              |                               |              |          |              |
|  | 5/8           | 29  | .198         | 36       | .230         | 43       | .263         |                               |              |          |              |
|  | 3/4           | 30  | .198         | 37       | .230         | 44       | .263         | 51                            | .394         |          |              |
|  | 1             | 31  | .198         | 38       | .230         | 45       | .263         | 52                            | .394         |          |              |
|  | 1-1/4         | 32  | .198         | 39       | .230         | 46       | .263         | 53                            | .394         |          |              |
|  | 1-1/2         | 33  | .198         | 40       | .230         | 47       | .263         | 54                            | .394         |          |              |
|  | 1-3/4         | 34  | .198         | 41       | .230         | 48       | .263         | 55                            | .394         |          |              |
|  | 2             | 35  | .198         | 42       | .230         | 49       | .263         | 56                            | .394         |          |              |
|  | 2-1/4         |   |              |          |              | 50       | .263         | 57                            | .394         |          |              |
|  | 2-1/2         |   |              |          |              |          |              | 58                            | .394         |          |              |
|  | 2-3/4         |   |              |          |              |          |              | 59                            | .394         |          |              |
| <p>*See Note (3), sheet 1.<br/>For illustration, material, protective coating, and other pertinent data see sheet 1.</p> |               |   |              |          |              |          |              |                               |              |          |              |
| P.A. WC<br>Other Cust WP<br>69   |               | TITLE<br>PIN, GROOVED, HEADLESS - LONGITUDINAL<br>CENTER GROOVE, CARBON STEEL |              |          |              |          |              | MILITARY STANDARD<br>MS 35677 |              |          |              |
| PROCUREMENT SPECIFICATION<br>MIL-P-20700   |               | SUPERSEDES:<br>BFCX4.1 and in part AEGX2                                      |              |          |              |          |              | SHEET 2 OF                    |              |          |              |

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APPROVED 11 JAN 56 REVISED (A) FOR CHANGES SEE SHEET 1.