

REVISED: CL, IS, MI, MU, ASA  
USER: AS, EL, MC, SW

					FED. SUP CLASS 5320				
TYPE I (FOR USE WITH SPLIT RIVETS)					TYPE II (FOR USE WITH TUBULAR RIVETS)				
DASH NUMBERS			TYPE	RIVET SIZE	A RIVET SHAFT DIAMETER		C OUTSIDE DIAMETERS		
STEEL	BRASS	BRASS (COATED)			MIN.	MAX.	MIN.	MAX.	
S1-6	B1-6	A1-6	I	3/32	0.085	0.092	0.281	0.297	
S1-8	B1-8	A1-8	I	1/8	.113	.125	.281	.328	
S1-9	B1-9	A1-9	I	9/64	.144	.152	.312	.375	
S1-12	B1-12	A1-12	I	1/16	.180	.190	.359	.375	
S2-8	B2-8	A2-8	II	1/8	.116	.123	.250	.266	
S2-9	B2-9	A2-9	II	9/64	.141	.146	.328	.344	
S2-12	B2-12	A2-12	II	1/16	.162	.166	.422	.438	
<p>The design and dimensional detail of the internal construction may vary with each manufacturer depending on the tooling developed for production of the cap and the rivet setting machine requirements.</p> <p><b>NOTES:</b></p> <ol style="list-style-type: none"> <li><b>MATERIAL:</b> Steel, carbon, per Federal Standard No. 66, steel numbers C1006 thru C1023. Brass, per QQ-W-321, composition 260 or 270, quarter hard.</li> <li><b>PROTECTIVE COATING:</b> Steel, carbon, cadmium plated per QQ-P-416, type II, class 2. Brass, uncoated, or oxide or black finish per MIL-F-493.</li> <li><b>DIMENSIONS:</b> All dimensions are in inches.</li> <li><b>PART NUMBERS:</b> The MS part number consists of the MS number plus the code letter and number, plus the dash number. The letter signifies the material and finish, the number following signifies the type, and the last number signifies the size in sixty-fourths of an inch. Example: MS51924S1-6 Cap, Rivet, carbon steel, cadmium plated, (for split rivets) size 3/32 in. MS51924B2-8 Cap, Rivet, brass, uncoated, (for tubular rivets), size 1/8 in. MS51924A1-12 Cap, Rivet, brass, oxide or black finish (for split rivet), size 1/16 in.</li> <li>For design feature purposes, this standard takes precedence over procurement documents referenced herein.</li> <li>Referenced documents shall be of the issue in effect on date of invitations for bid.</li> </ol>									
(A) ENTIRE STANDARD REVISED									
P.A. 6C Other Cost 1D			TITLE CAPS, RIVET			MILITARY STANDARD MS51924			
PROCUREMENT SPECIFICATION FF-N-556			SUPERSEDES ENC11.9			SHEET 1 OF 1			

This military standard is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.