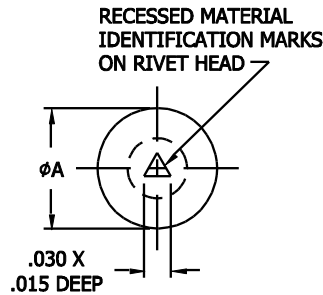


**CORROSION
RESISTANT STEEL
(NO HEAD MARKING
REQUIRED)**



**CARBON
STEEL**

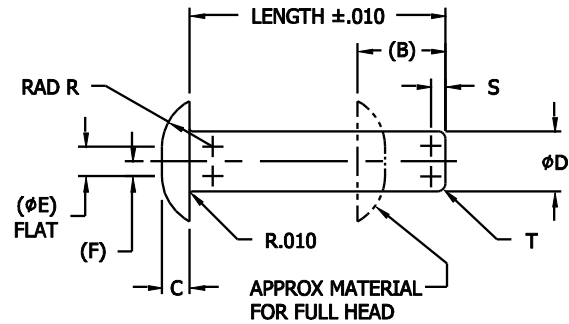


TABLE I – DIMENSIONS ^④

NOM DIA	ØD		ØA		(B)	C		(ØE)	(F)	R RAD	S	T RAD
	MIN	MAX	MIN	MAX		MIN	MAX					
.062	.061	.065	.119	.131	.094	.027	.037	.031	.016	.054	.016	.019
.094	.093	.097	.178	.196	.141	.040	.050	.047	.023	.082	.023	.029
.125	.124	.128	.238	.262	.188	.054	.064	.062	.031	.108	.031	.039
.156	.155	.160	.296	.328	.234	.067	.077	.078	.039	.135	.039	.049
.188	.186	.191	.356	.394	.281	.080	.090	.094	.047	.164	.047	.059
.250	.249	.254	.475	.525	.375	.107	.117	.125	.062	.217	.062	.078
.312	.311	.316	.594	.656	.469	.133	.143	.156	.078	.272	.078	.098
.375	.374	.379	.713	.787	.562	.161	.171	.188	.094	.328	.094	.117
.438	.436	.442	.832	.918	.625	.189	.199	.219	.109	.383	.110	.137

MATERIAL: STEEL, CARBON, COMPOSITION C1005 THRU C1015 (UNS G10050 THRU UNS G10150) IN ACCORDANCE WITH ASTM A29/A29M ANNEALED AFTER HEADING.

^④ **STEEL, CORROSION RESISTANT, CLASS 300 SERIES, IN ACCORDANCE WITH ASTM A580/A580M, ANNEALED AFTER HEADING.**

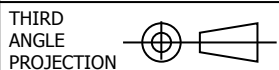
FINISH: STEEL, CARBON, CADMIUM PLATED PER AMS-QQ-P-416 TYPE II, CLASS 2.

STEEL, CORROSION RESISTANT, CLEAN, DESCALE AND PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

SHEAR STRENGTH: CARBON STEEL, 38,000 TO 48,000 PSI.

CORROSION RESISTANT STEEL, 65,000 TO 85,000 PSI.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS20613, REVISION F. PART NUMBERS REMAIN MS20613.



THIRD
ANGLE
PROJECTION

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

4

PROCUREMENT
SPECIFICATION
NONE

TITLE

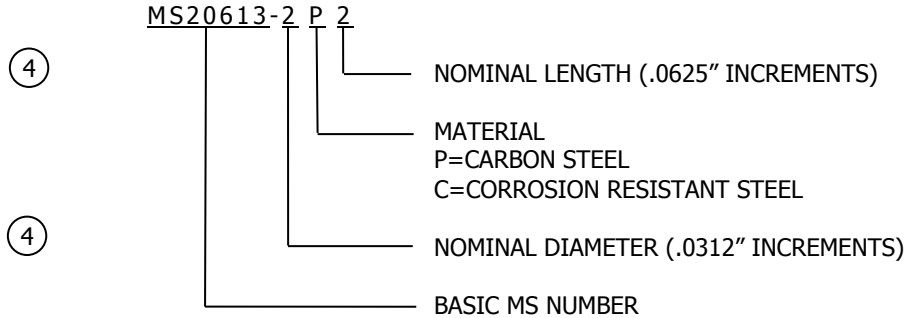
**RIVET, SOLID, UNIVERSAL HEAD, STEEL, CARBON
AND STEEL, CORROSION-RESISTANT**

CLASSIFICATION
PART STANDARD

NASM20613
SHEET 1 OF 4

CODE: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER, FOLLOWED BY A DASH NUMBER SIGNIFYING THE NOMINAL DIAMETER IN THIRTY-SECONDS OF AN INCH INCREMENTS, FOLLOWED BY A LETTER INDICATING THE REQUIRED MATERIAL AND AN ADDITIONAL NUMBER SIGNIFYING THE NOMINAL LENGTH IN SIXTEENTH OF AN INCH INCREMENTS.

EXAMPLE OF PART NUMBER:



MS20613-2P2 – INDICATES RIVET, SOLID-UNIVERSAL HEAD, CARBON STEEL, CADMIUM PLATED, .062" NOMINAL DIAMETER, .125" NOMINAL LENGTH.

NOTES: (4)

- (1) DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) RIVETS MAY BE FURNISHED WITH PLAIN ENDS, OR WITH CHAMFERED END WITH A RADIUS TO THE "T" DIMENSIONS, OR A 20° CHAMFER TO THE "S" DIMENSION.
- (3) ILLUSTRATIONS ARE FOR IDENTIFICATION AND ARE NOT INTENDED TO RESTRICT DESIGNS AND SHAPES OF RIVETS WHICH OTHERWISE CONFORM TO REQUIREMENTS.
- (4) UNPLATED CARBON STEEL RIVETS AND ZINC PLATED RIVETS, INACTIVE FOR DESIGN AFTER 23 DECEMBER 1960. MS20613 REPLACED THE INACTIVE MS20435 RIVETS OF THE SAME DIAMETER, LENGTH AND MATERIAL ON 23 DECEMBER 1960. FOR DESCRIPTION OF STATUS NOTES SEE NAS380.
- (5) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (6) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (7) NASM20613 SUPERSEDES MS20435 IN PART.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (9) TOLERANCE: UNLESS OTHERWISE SPECIFIED, DECIMALS $\pm .010$.
- (10) CONCENTRICITY: SHANK AND HEAD DIAMETERS SHALL BE CONCENTRIC WITHIN: .010 FIM FOR RIVET SIZES .062 THRU .125, .015 FIM FOR RIVET SIZES .156 AND .188 AND .020 FIM FOR RIVET SIZES .250 THRU .438.
- (11) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

4

NASM20613
SHEET 2



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