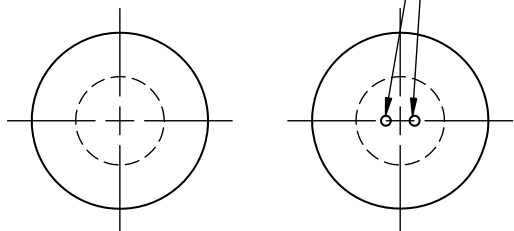


FED. SUPPLY CLASS

5320

TWO (2) RECESSED MATERIAL
IDENTIFICATION MARKS ON
RIVET HEAD WITHIN THE
DIAMETRAL LIMITS OF ØE
Ø.030 MAX x .020 DEEP



COPPER

NICKEL-COPPER
ALLOY (MONEL)

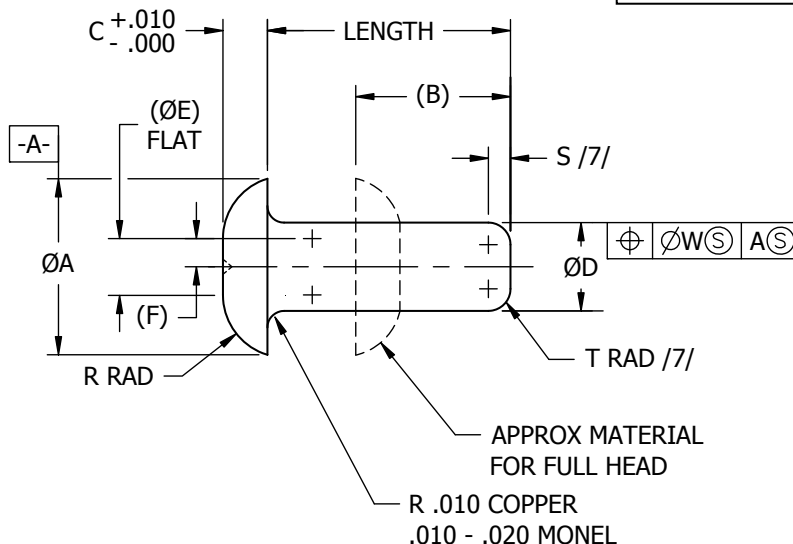


TABLE I – DIMENSIONS

ØD		ØA	(B)	C	(ØE)	F	R RAD	S	T RAD	W
.062	+.003 -.001	.125 ± .006	.094	.027	.031	.015	.054	.016	.019	.020
.094		.187 ± .009	.141	.040	.046	.023	.082	.023	.029	
.125		.250 ± .012	.168	.054	.062	.031	.108	.031	.039	
.156	+.004 -.001	.312 ± .016	.234	.067	.078	.039	.135	.039	.049	.025
.187		.375 ± .019	.281	.080	.093	.046	.164	.047	.059	
.250		.500 ± .025	.375	.107	.125	.062	.217	.062	.078	
.312		.625 ± .031	.469	.133	.156	.078	.272	.078	.098	
.375	+.005 -.001	.750 ± .037	.562	.161	.187	.093	.328	.094	.117	.030
.437		.875 ± .043	.625	.189	.218	.109	.383	.110	.137	

MATERIAL:

COPPER, ASTM B 3, (UNS C11000).
NICKEL-COPPER ALLOY (MONEL), QQ-N-281, CLASS A, (UNS N04400).
BRASS, ASTM B 134/B 134M, ALLOY 270, 1/8 HARD (UNS C27000).

FINISH:

ONLY WHEN SPECIFIED NICKEL-COPPER ALLOY (MONEL) CADMIUM PLATE, AMS-QQ-P-416,
TYPE II, CLASS 2.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS20615 REVISION G. PART NUMBERS REMAIN MS20615.

THIRD ANGLE PROJECTION		CUSTODIAN	REVISION
		NATIONAL AEROSPACE STANDARDS COMMITTEE	5
PROCUREMENT SPECIFICATION	NONE	TITLE	CLASSIFICATION PART STANDARD
			ASM20615

**RIVET, SOLID, UNIVERSAL HEAD, BRASS,
COPPER, NICKEL-COPPER ALLOY**

ASM20615
SHEET 1 OF 4

SHEAR STRENGTH:

COPPER, 17,000 PSI TO 30,000 PSI.
NICKEL-COPPER ALLOY (MONEL), 49,000 PSI TO 59,000 PSI.

CODE:

⑤

THE PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER FROM TABLE II. ADDITIONAL .031 INCREMENTS MAY BE OBTAINED BY ADDING "R" AFTER THE LAST DASH NUMBER. ADD "W" TO THE END OF THE PART NUMBER TO SIGNIFY RIVET END WITH 20° CHAMFER TO THE "S" DIMENSION ONLY. ABSENCE OF "W" SIGNIFIES RIVET END WITH 20° CHAMFER TO THE "S" DIMENSION, END WITH RADIUS TO THE "T" DIMENSION, OR PLAIN END.

EXAMPLE OF PART NUMBER: ⑤

MS20615-2M8 = RIVET, UNIVERSAL HEAD, NICKEL-COPPER ALLOY, .0625 INCH DIA, .500 INCH LONG, WITH A 20° CHAMFERED, RADIUS, OR PLAIN END.
MS20615-2M8R = RIVET, UNIVERSAL HEAD NICKEL-COPPER ALLOY, .0625 INCH DIA, .531 LONG, WITH A 20° CHAMFERED, RADIUS, OR PLAIN END.
MS20615-2M8W = RIVET, UNIVERSAL HEAD, NICKEL-COPPER ALLOY, .0625 INCH DIA, .500 INCH LONG, WITH A 20° CHAMFERED END ONLY.

NOTES:

- (1) DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS ± .010.
- (3) MS20615 PART NUMBERS CAN UNIVERSALLY REPLACE THE INACTIVATED MS20435 RIVETS OF THE SAME MATERIAL, SHANK DIAMETER AND LENGTH; BUT THE INACTIVE MS20435 RIVETS CANNOT REPLACE THE SUPERSEDING MS20615 PART NUMBERED RIVETS.
- (4) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (5) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON THE DATE OF INVITATIONS FOR BID.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- ⑤ /7/ UNLESS OTHERWISE SPECIFIED (SEE CODE), RIVETS MAY BE FURNISHED PLAIN, WITH CHAMFERED ENDS WITH A RADIUS TO THE "T" DIMENSION OR A 20° CHAMFER TO THE "S" DIMENSION.
- (8) RIVETS SHALL DRIVE COLD SATISFACTORILY WITH A FULL HEAD FREE FROM CRACKS.
- (9) RIVETS MUST BE TRUE TO FORM, CONCENTRIC AND FREE FROM INJURIOUS SCALE, FINS, SEAMS AND ALL OTHER INJURIOUS DEFECTS.
- (10) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (11) REMOVE ALL BURRS AND SHARP EDGES.

REVISION

5

NAS20615

SHEET 2



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