

FED. SUPPLY CLASS

5325

**1. SCOPE**

- 1.1 Scope. This document covers the general requirements for commercial metallic eyelets and washers.
- 1.2 Classification. The types, sizes, materials, and finishes shall be as designated on the detail document sheet which is part of this general document.

**2. APPLICABLE DOCUMENTS**

- 2.1 Government documents. Unless otherwise specified, the following documents of the issue in effect on the date of invitation for bids or request for proposal form a part of this document to the extent specified herein.

**SPECIFICATIONS**

Federal

QQ-B-613 Brass, Leaded and Nonleaded: Flat Products (Plate, Bar, Sheet and Strip)  
PPP-B-636 Boxes, Shipping, Fiberboard  
P-S-1792 Soap, Laundry (Neutral and Built)

Military

MIL-F-495 Finish, Chemical, Black, for Copper Alloys  
MIL-DTL-5541 Chemical Conversion Coatings on Aluminum and Aluminum Alloys

**STANDARDS**

Federal

FED-STD-595 Colors Used in Government Procurement

Military

MIL-STD-129 Marking for Shipment and Storage  
MIL-STD-147 Palletized Unit Loads

Copies can be obtained from the Department of Defense Single Stock Point (DODSSP). <http://dodssp.daps.dla.mil>

- 2.2 Other publications. Unless otherwise specified, the following documents of the issue in effect on the date of invitation for bids or request for approval form a part of this document to the extent specified herein.

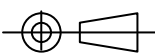
ASTM International

ASTM B36/B36M Standard Specification for Brass Plate, Sheet, Strip, and Rolled Bar  
ASTM D1974/D1974M Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes  
ASTM D3951 Standard Practice for Commercial Packaging  
ASTM D5118/D5118M Standard Practice for Fabrication of Fiberboard Shipping Boxes

Copies can be obtained from ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959. [www.astm.org](http://www.astm.org)

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-E-20652, REVISION F, AMENDMENT 1.

|                                                                                                            |                                                                         |                                                                      |
|------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------|----------------------------------------------------------------------|
| THIRD ANGLE PROJECTION  | CUSTODIAN<br>NATIONAL AEROSPACE STANDARDS COMMITTEE                     | REVISION<br><b>1</b>                                                 |
| PROCUREMENT SPECIFICATION<br><br>NONE                                                                      | TITLE<br><br><b>EYELETS, METALLIC,<br/>AND EYELET WASHERS, METALLIC</b> | CLASSIFICATION SPECIFICATION<br><br><b>NAS 20652</b><br>SHEET 1 OF 6 |

American Society for Quality

ANSI/ASQ Z1.4

Sampling Procedures and Tables for Inspection by Attributes

Copies can be obtained from the American Society for Quality, 600 North Plankinton Ave., Milwaukee, WI 53203.

[www.asq.org](http://www.asq.org)

- 2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document shall take precedence.

### 3. REQUIREMENTS

- 3.1 Part standards. The individual detailed specifications shall be as specified herein and in accordance with the applicable part standards.
- 3.2 Materials and components. The materials and components shall be as specified herein. Materials and components not definitely specified shall be of the quality normally used by the manufacturer provided the completed end item complies with all the provisions of this document.
- 3.2.1 Brass. Brass shall conform to copper alloy numbers 260 (UNS C26000) or 268 (UNS C26800) sheet or strip of ~~QQ-B-613~~ ASTM B36/B36M. Brass for eyelets shall be annealed suitable for forming. Brass for flat washers shall be tempered, minimum half-hard.
- 3.2.2 Aluminum. Aluminum for eyelets and washers shall be of the quality used by the manufacturer for eyelets.
- 3.3 Design and construction. The design and construction of the eyelets and washers shall be as specified herein and as shown on the applicable part standards. Eyelet metal shall not crack when clinched as specified in 4.2.2.3.
- 3.4 Finish
- 3.4.1 Enamel finish
- 3.4.1.1 Pretreatment. Aluminum eyelets and washers that require an enamel finish shall be given a chemical treatment in accordance with Class 1A of MIL-DTL-5541, prior to the application of the enamel. Brass eyelets that require enameling shall have a dark oxide pretreatment applied in accordance with commercial practice and shall be thoroughly rinsed before enameling.
- 3.4.1.2 Enameling. Following pretreatment, eyelets and washers requiring enamel shall be given two coats of the color enamel as specified in the contract or purchase order (see 6.2). Enamel shall be applied and baked. The dried enamel shall be semi-gloss. The white color shall approximate No. 27875 of FED-STD-595. The enamel shall show not more than a slight discoloration and shall resist thumbnail penetration when tested for resistance to hot soap solution as specified in 4.3.1. The enamel shall not crack or flake when tested as specified in 4.2.2.3 for clinching.
- 3.4.2 Black chemical finish. Brass eyelets and washers requiring a black chemical finish shall be finished in accordance with MIL-F-495.
- 3.4.3 Anodized finish. Anodized aluminum eyelets shall have a non-dyed (natural) anodic coating.
- 3.4.4 Brass natural finish. Natural brass finish shall be as normally furnished by the supplier.
- 3.5 Workmanship. The finished eyelets and washers shall be free from fracture, malformation, burrs, and rough or sharp edges. Flat washers shall be smooth and free of any bend. Finish shall be smooth and free of foreign imbedded matter, any discoloration, and areas of no film.

① COMPLETELY REVISED

REVISION

1

**NAS** Documents

SHEET 2



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America Inc. MS PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF  
Provided by IHS under license with AIA/NAS Licensee= www.sepana.ir/5991803002, User=sam, albert  
No reproduction or networking permitted without license from IHS Not for Resale, 01/04/2016 11:29:20 MST TRADEMARKS RIGHTS.

Full document details: AIA NASM20652 2012