

FED. SUPPLY CLASS

5315

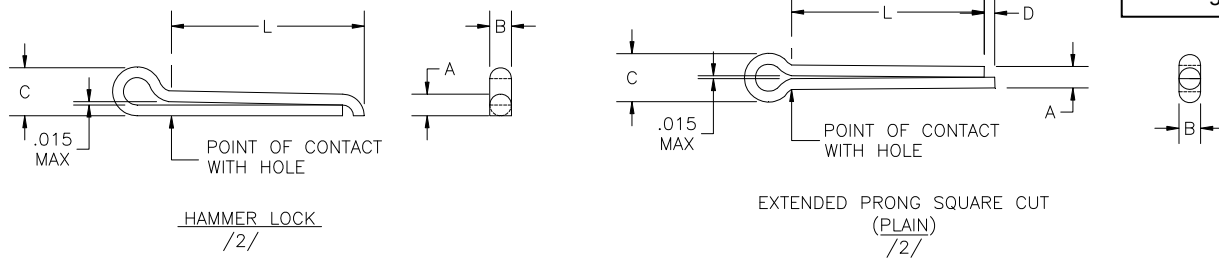


TABLE I – CONFIGURATION DIMENSIONS

SIZE NOMINAL DIAMETER	A		B		C	D	HOLE SIZE RECOMMENDED
	MAX	MIN	MAX	MIN	MIN	MIN	
1/32 - .031	.032	.028	.032	.022	.06	.01	.047
3/64 - .047	.048	.044	.048	.035	.09	.02	.062
1/16 - .062	.060	.056	.060	.044	.12	.03	.078
^{1/1} 5/64 - .078	.076	.072	.076	.057	.16	.04	.094
3/32 - .094	.090	.086	.090	.069	.19	.04	.109
1/8 - .125	.120	.116	.120	.093	.25	.06	.141
5/32 - .156	.150	.146	.150	.116	.31	.07	.172
3/16 - .188	.176	.172	.176	.137	.38	.09	.203
^{1/1} 7/32 - .219	.207	.202	.207	.161	.44	.10	.234
1/4 - .250	.225	.220	.225	.176	.50	.11	.266
5/16 - .312	.280	.275	.280	.220	.62	.14	.312
3/8 - .375	.335	.329	.335	.263	.75	.16	.375
^{1/1} 7/16 - .438	.406	.400	.406	.320	.88	.20	.438
1/2 - .500	.473	.467	.473	.373	1.00	.23	.500
5/8 - .625	.598	.590	.598	.472	1.25	.30	.625
^{1/1} 3/4 - .750	.723	.715	.723	.572	1.50	.36	.750

^{1/1} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN.

REQUIREMENT:

- MATERIAL.** CARBON STEEL, BRASS, CORROSION RESISTANT STEEL, AND NICKEL COPPER ALLOY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- PROTECTIVE COATING.** CARBON STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3 OR PHOSPHATE COATED IN ACCORDANCE WITH MIL-DTL-16232, TYPE Z, CLASS 3 AND THE PROCUREMENT SPECIFICATION. BRASS SHALL BE BLACK CHEMICAL FINISH AS SPECIFIED IN MIL-F-495 AND IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION. CORROSION RESISTANT STEEL SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380 AND THE PROCUREMENT SPECIFICATION.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24665, REVISION F. PART NUMBERS REMAIN MS24665.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
		CLASSIFICATION PART STANDARD MS24665
PROCUREMENT SPECIFICATION ASME B18.8.1	TITLE PIN, COTTER (SPLIT)	SHEET 1 OF 6

3. HARDNESS. CORROSION RESISTANT STEEL COTTER PINS SHALL HAVE A HARDNESS AS FOLLOWS:

NOMINAL COTTER PIN DIA	VICKERS (10 Kg LOAD)	ROCKWELL 15N
1/16 - .062 AND LESS	200 TO 350 HV10	65 TO 78 HR15N
5/64 - .078 AND 3/32 - .094	170 TO 245 HV10	60 TO 70 HR15N
1/8 - .125 AND LARGER	140 TO 220 HV10	55 TO 67 HR15N

CORROSION RESISTANT STEEL COTTER PINS SHALL BE TESTED FOR HARDNESS IN ACCORDANCE WITH NASM1312 TEST NO. 6.

4. LENGTH TOLERANCE. THE COTTER PINS SHALL MEET THE LENGTH TOLERANCE AS SPECIFIED IN THE PROCUREMENT SPECIFICATION.

5. PART NUMBER. THE PART NUMBER SHALL CONSIST OF MS, FOLLOWED BY THE BASIC NUMBER OF THIS DOCUMENT, PLUS THE DASH NUMBER TAKEN FROM TABLES II, III, IV, V AND VI AS APPLICABLE.

EXAMPLE: MS24665-39

DASH NUMBER

MS PLUS THE BASIC NUMBER OF THIS DOCUMENT

MS24665-39 INDICATES - PIN, COTTER (SPLIT), BRASS WITH BLACK CHEMICAL FINISH NOMINAL DIAMETER 1/32 INCH, LENGTH 1/2 INCH.

6. QUALITY ASSURANCE PROVISIONS: QUALITY ASSURANCE PROVISIONS SHALL BE IN ACCORDANCE WITH ASME B18.18.1.

7. PACKAGING. PACKAGING SHALL BE IN ACCORDANCE WITH ASTM D 3951.

NOTES:

- ALL DIMENSIONS ARE IN INCHES AND AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- PREFERRED POINT TYPES SHALL BE THE EXTENDED PRONG SQUARE (PLAIN) CUT OR HAMMER LOCK TYPES AS DEPICTED HEREIN. OTHER OPTIONAL COTTER PIN DESIGN SHALL BE IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
- REFERENCED GOVERNMENT (OR NONGOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
- DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

REVISION

1

NASM24665

SHEET 2



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