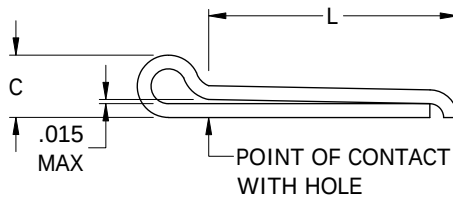
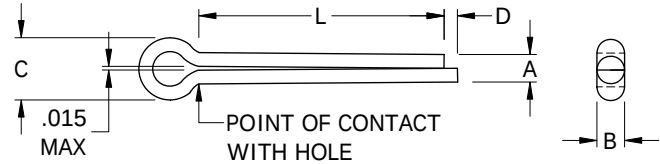


FED. SUPPLY CLASS

5315



HAMMER LOCK /2/



EXTENDED PRONG
SQUARE CUT (PLAIN) /2/

TABLE I – CONFIGURATION DIMENSIONS

NOMINAL DIAMETER	A		B		C	D	HOLE SIZE RECOMMENDED
	MAX	MIN	MAX	MIN	MIN	MIN	
/8/	.031	.032	.028	.032	.022	.06	.047
	.047	.048	.044	.048	.035	.09	.062
	.062	.060	.056	.060	.044	.12	.078
	.078	.076	.072	.076	.057	.16	.094
	.094	.090	.086	.090	.069	.19	.109
/8/	.125	.120	.116	.120	.093	.25	.141
	.156	.150	.146	.150	.116	.31	.172
	.188	.176	.172	.176	.137	.38	.203
	.219	.207	.202	.207	.161	.44	.234
	.250	.225	.220	.225	.176	.50	.266
/8/	.312	.280	.275	.280	.220	.62	.312
	.375	.335	.329	.335	.263	.75	.375
	.438	.406	.400	.406	.320	.88	.438
	.500	.473	.467	.473	.373	1.00	.500
	.625	.598	.590	.598	.472	1.25	.625
/8/	.750	.723	.715	.723	.572	1.50	.750

MATERIAL: CARBON STEEL, BRASS, CORROSION RESISTANT STEEL, AND NICKEL COPPER ALLOY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

FINISH: CARBON STEEL - 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 - BLACK CHEMICAL FINISH AS SPECIFIED IN MIL-F-495 AND IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.

CRES - CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380/A380M AND THE PROCUREMENT SPECIFICATION, OR
- PASSIVATED PER AMS2700, METHOD 1, TYPE 8, CLASS 4 – NO POST TREATMENT, OR
- PASSIVATED PER AMS2700, METHOD 2 – NO POST TREATMENT.

② COMPLETELY REVISED

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



PROCUREMENT
SPECIFICATION

ASME B18.8.1

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

2

TITLE

PIN, COTTER (SPLIT)

CLASSIFICATION
PART STANDARD

NASM24665
SHEET 1 OF 6



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HARDNESS:

CORROSION RESISTANT STEEL COTTER PINS SHALL HAVE A HARDNESS AS LISTED IN TABLE II:

TABLE II – HARDNESS FOR CORROSION RESISTANT STEEL COTTER PINS

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

CORROSION RESISTANT STEEL COTTER PINS SHALL BE TESTED FOR HARDNESS IN ACCORDANCE WITH NASM1312-6.

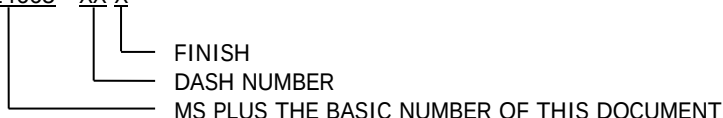
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THE PART NUMBER SHALL CONSIST OF MS, FOLLOWED BY THE BASIC NUMBER OF THIS DOCUMENT, PLUS THE DASH NUMBER TAKEN FROM TABLES II, III, IV, V AND VI AS APPLICABLE.

"M" AFTER DASH NUMBER INDICATES PASSIVATION PER AMS2700, METHOD 1, TYPE 8, CLASS 4 – NO POST TREATMENT.

"B" AFTER DASH NUMBER INDICATES PASSIVATION PER AMS2700, METHOD 2 – NO POST TREATMENT.

MS24665 - XX X



EXAMPLE OF PART NUMBER:

MS24665-39 = PIN, COTTER (SPLIT), BRASS WITH BLACK CHEMICAL FINISH, .031 NOMINAL DIAMETER, .500 LONG.

MS24665-22B = PIN, COTTER (SPLIT), CORROSION RESISTANT STEEL, PASSIVATED PER AMS2700, METHOD 2 – NO POST TREATMENT, .031 NOMINAL DIAMETER, .500 LONG.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /2/ 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.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (4) FOR DESCRIPTION OF STATUS NOTES SEE NAS380.
- (5) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (7) 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.

REVISION

2

NASM24665

SHEET 2



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② COMPLETELY REVISED