

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODSS SPECIFIED IN THE SOLICITATION FORM

SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE

Form Approved  
DHS No. 0704-0188

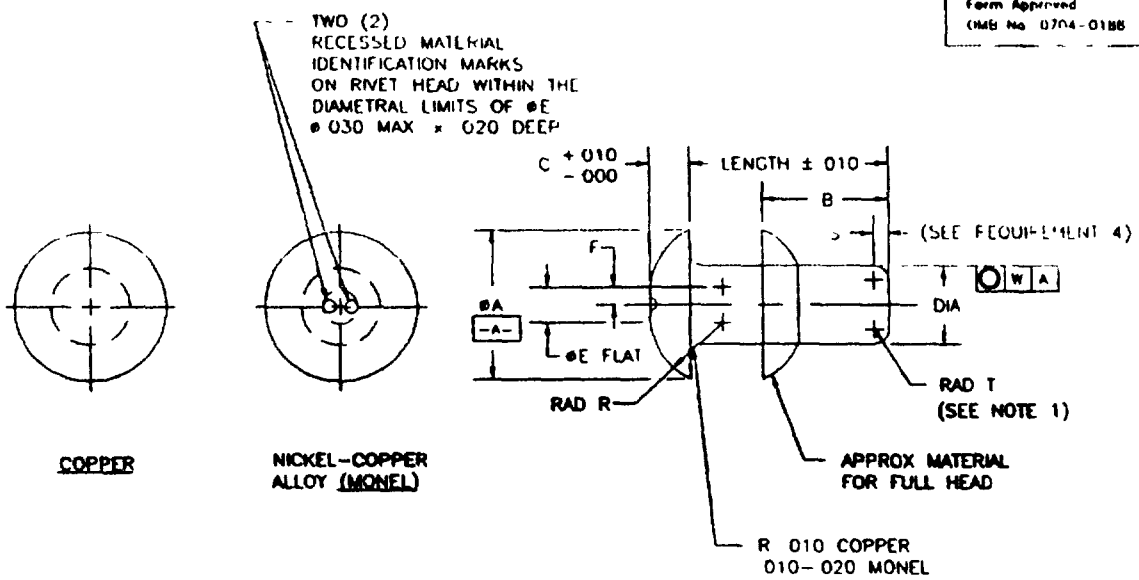


TABLE I DIMENSIONS

NOMI- DIA	DIA	ØA	B REF	C	ØE REF	F	R RAD	S	T RAD	W								
1/16	.062	125 ± .006	.054	.027	.031	.015	.054	.016	.019	.020								
3/32	.094										187 ± .009	.141	.040	.046	.023	.082	.023	.029
1/8	.125										.250 ± .012	.188	.054	.062	.031	.108	.031	.039
5/32	.156	.312 ± .016	.234	.067	.078	.036	.135	.036	.049	.025								
3/16	.187										.375 ± .018	.281	.080	.083	.046	.164	.047	.056
1/4	.250										.500 ± .025	.378	.107	.125	.062	.217	.062	.078
5/16	.312	.625 ± .031	.488	.133	.156	.078	.272	.078	.098	.030								
3/8	.375										.780 ± .037	.562	.161	.187	.083	.328	.094	.117
7/16	.437										.875 ± .043	.625	.189	.216	.109	.383	.110	.137

REQUIREMENTS

- MATERIAL** COPPER, ASTM B3 (UNS C11000)  
NICKEL-COPPER ALLOY (MONEL), OO-N-281 CLASS A, (UNS N04400)  
BRASS, OO-W-321, ALLOY 270, 1/8 HARD (UNS C27000)
- FINISH** ONLY WHEN SPECIFIED NICKEL-COPPER ALLOY (MONEL) CADMIUM PLATE OO-P-416 TYPE II CLASS 2
- SHEAR STRENGTH** COPPER, 17,000 PSI TO 30,000 PSI  
NICKEL-COPPER ALLOY (MONEL), 49,000 PSI TO 59,000 PSI
- RIVETS MAY BE FURNISHED PLAIN OR WITH CHAMFERED ENDS WITH A RADIUS TO THE "T" DIMENSION OR A 20° CHAMFER TO THE "S" DIMENSION
- RIVET SHALL DRIVE COLD SATISFACTORILY WITH A FULL HEAD FREE FROM CRACKS
- RIVETS MUST BE TRUE TO FORM, CONCENTRIC AND FREE FROM INJURIOUS SCALE, FIMS, SEAMS, AND ALL OTHER INJURIOUS DEFECTS.
- PART NUMBER:** THE MS PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER FROM TABLE II. ADDITIONAL 1/32 INCREMENTS MAY BE OBTAINED BY ADDING "K" AFTER THE LAST DASH NUMBER
- EXAMPLE OF PART NUMBER:**  
MS20615-2MB = RIVET, UNIVERSAL HEAD, NICKEL COPPER ALLOY, 1/16 INCH DIA. 1/2 INCH LONG  
MS20615-2MBR = RIVET, UNIVERSAL HEAD NICKEL COPPER ALLOY 1/16 INCH DIA. 531 LONG

ⓐ ENTIRE DOCUMENT REVISED

INCH-POUND

PREPARING ACTIVITY DLA-IS CUSTODIANS ARMY- AV NAVY- AS AIR FORCE- B2 DLA- REVIEW 99 USER CI NUMBER 5320-0528 EDITION STATEMENT	MILITARY SPECIFICATION SHEET TITLE RIVET, SOLID-UNIVERSAL HEAD BRASS, COPPER, NICKEL-COPPER ALLOY	SPECIFICATION SHEET NUMBER 13 FEB 1995 MS20615 REV G SUPERSEDING MS20615F 30 AUG 1990 AMSC N/A FSC 5320
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Form Apr 5  
OMI No 4 0155

NOTE

- 1 DIMENSIONS ARE IN INCHES
  - 2 UNLESS OTHERWISE SPECIFIED TOLERANCES DECIMALS ± 010
  - 3 MS20615 CAN UNIVERSALLY REPLACE THE INACTIVED MS20435 RIVETS OF THE SAME MATERIAL SHANK DIAMETER AND LENGTH BUT THE INACTIVE MS20435 RIVETS CANNOT REPLACE THE SUPERSEDING MS20615 RIVETS
- IN THE EVENT OF A CONFLICT THE TEXT OF THIS DOCUMENT AND THE REFERENCE LISTED HEREIN THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE
- 5 UNLESS OTHERWISE SPECIFIED ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION

TABLE II DASH NUMBERS

BRASS DASH NO	COPPER DASH NO	MONEL DASH NO	MONEL CADMIUM PLATED	DIA	LENGTH	BRASS DASH NO	COPPER DASH NO	MONEL DASH NO	MONEL CADMIUM PLATED	DIA	LENGTH
-2B2	-2CU2	-2M2	-2MP2	1/16	125	-8B4		-8M4	-8MP4	3/16	250
-2B3	-2CU3	-2M3	-2MP3		187	-8B5		-8M5	-8MP5		312
-2B4	-2CU4	-2M4	-2MP4		250	-8B6	-8CU6	-8M6	-8MP6		375
-2B5	-2CU5	-2M5	-2MP5		312	-8B7	-8CU7	-8M7	-8MP7		438
-2B6	-2CU6	-2M6	-2MP6		375	-8B8	-8CU8	-8M8	-8MP8		500
-2B7	-2CU7	-2M7	-2MP7		438	-8B9		-8M9	-8MP9		562
-2B8	-2CU8	-2M8	-2MP8		500	-8B10	-8CU10	-8M10	-8MP10		625
-2B9			-2MP9		562	-8B11		-8M11	-8MP11		688
					625	-8B12		-8M12	-8MP12		750
3E	-3CU3	-3M3	-3MP3	3/32	562	-8B13	-8CU13	-8M13	-8MP13	1/4	812
-3E1	-3CU4	-3M4	-3MP4		625	-8B14	-8CU14	-8M14	-8MP14		875
-3E2	-3CU5	-3M5	-3MP5		688	-8B15		-8M15	-8MP15		938
-3E3	-3CU6	-3M6	-3MP6		750	-8B16	-8CU16	-8M16	-8MP16		1000
-3E4	-3CU7	-3M7	-3MP7		812	-8B17	-8CU17	-8M17	-8MP17		1125
-3E5	-3CU8	-3M8	-3MP8		875	-8B18	-8CU18	-8M18	-8MP18		1250
-3E6		-3M9	-3MP9		938	-8B19		-8M19	-8MP19		1375
-3B10	-3CU10	-3M10	-3MP10		1000	-8B20	-8CU20	-8M20	-8MP20		1500
-3B11		-3M11	-3MP11		1125	-8B21		-8M21	-8MP21		1625
-3B12	-3CU12	-3M12	-3MP12	1250	-8B22	-8CU22	-8M22	-8MP22	1750		
	-3CU14		-3MP14	1375	-8B23	-8CU23	-8M23	-8MP23	1875		
	-3CU16		-3MP16	1500	-8B24	-8CU24	-8M24	-8MP24	2000		
				1625	-8B25	-8CU25	-8M25	-8MP25	2125		
				1750	-8B26	-8CU26	-8M26	-8MP26	2250		
				1875	-8B27	-8CU27	-8M27	-8MP27	2375		
				2000	-8B28	-8CU28	-8M28	-8MP28	2500		
				2125	-8B29	-8CU29	-8M29	-8MP29	2625		
				2250	-8B30	-8CU30	-8M30	-8MP30	2750		
				2375	-8B31	-8CU31	-8M31	-8MP31	2875		
				2500	-8B32	-8CU32	-8M32	-8MP32	3000		
-4B3	-4CU4	-4M3	-4MP3	1/8	187	-10B10	-10CU10	-10M10	-10MP10	5/16	625
-4B4	-4CU5	-4M4	-4MP4		250	-10B11	-10CU11	-10M11	-10MP11		750
-4B5	-4CU6	-4M5	-4MP5		312	-10B12	-10CU12	-10M12	-10MP12		875
-4B6	-4CU7	-4M6	-4MP6		375	-10B13	-10CU13	-10M13	-10MP13		1000
-4B7	-4CU8	-4M7	-4MP7		438	-10B14	-10CU14	-10M14	-10MP14		1125
-4B8	-4CU9	-4M8	-4MP8		500	-10B15	-10CU15	-10M15	-10MP15		1250
-4B9	-4CU10	-4M9	-4MP9		562	-10B16	-10CU16	-10M16	-10MP16		1375
-4B10		-4M10	-4MP10		625	-10B17	-10CU17	-10M17	-10MP17		1500
-4B11		-4M11	-4MP11		688	-10B18	-10CU18	-10M18	-10MP18		1625
-4B12	-4CU12	-4M12	-4MP12	750	-10B19		-10M19	-10MP19	1750		
-4B13		-4M13	-4MP13	812	-10B20	-10CU20	-10M20	-10MP20	1875		
-4B14	-4CU14	-4M14	-4MP14	875	-10B21		-10M21	-10MP21	2000		
-4B15		-4M15	-4MP15	938	-10B22	-10CU22	-10M22	-10MP22	2125		
-4B16	-4CU16	-4M16	-4MP16	1000	-10B23	-10CU23	-10M23	-10MP23	2250		
-4B18		-4M18	-4MP18	1125	-10B24	-10CU24	-10M24	-10MP24	2375		
-4B20		-4M20	-4MP20	1250	-10B25	-10CU25	-10M25	-10MP25	2500		
				1375	-10B26	-10CU26	-10M26	-10MP26	2625		
				1500	-10B27	-10CU27	-10M27	-10MP27	2750		
				1625	-10B28	-10CU28	-10M28	-10MP28	2875		
				1750	-10B29	-10CU29	-10M29	-10MP29	3000		
				1875	-10B30	-10CU30	-10M30	-10MP30	3125		
				2000	-10B31	-10CU31	-10M31	-10MP31	3250		
				2125	-10B32	-10CU32	-10M32	-10MP32	3375		
-5B4		-5M4	-5MP4	5/32	250	-12B12	-12CU12	-12M12	-12MP12	3/8	750
-5B5		-5M5	-5MP5		312	-12B13	-12CU13	-12M13	-12MP13		812
-5B6	-5CU6	-5M6	-5MP6		375	-12B14	-12CU14	-12M14	-12MP14		875
-5B7	-5CU7	-5M7	-5MP7		438	-12B15	-12CU15	-12M15	-12MP15		938
-5B8	-5CU8	-5M8	-5MP8		500	-12B16	-12CU16	-12M16	-12MP16		1000
-5B9		-5M9	-5MP9		562	-12B17	-12CU17	-12M17	-12MP17		1062
-5B10	-5CU10	-5M10	-5MP10		625	-12B18	-12CU18	-12M18	-12MP18		1125
-5B11		-5M11	-5MP11		688	-12B19	-12CU19	-12M19	-12MP19		1187
-5B12	-5CU12	-5M12	-5MP12		750	-12B20	-12CU20	-12M20	-12MP20		1250
-5B13		-5M13	-5MP13	812	-12B21	-12CU21	-12M21	-12MP21	1312		
-5B14	-5CU14	-5M14	-5MP14	875	-12B22	-12CU22	-12M22	-12MP22	1375		
-5B15		-5M15	-5MP15	938	-12B23	-12CU23	-12M23	-12MP23	1437		
-5B16	-5CU16	-5M16	-5MP16	1000	-12B24	-12CU24	-12M24	-12MP24	1500		
		-5M18	-5MP18	1125	-12B25	-12CU25	-12M25	-12MP25	1562		
		-5M20	-5MP20	1250	-12B26	-12CU26	-12M26	-12MP26	1625		
		-5M22	-5MP22	1375	-12B27	-12CU27	-12M27	-12MP27	1687		
		-5M24	-5MP24	1500	-12B28	-12CU28	-12M28	-12MP28	1750		
		-5M26	-5MP26	1625	-12B29	-12CU29	-12M29	-12MP29	1812		
		-5M32	-5MP32	1750	-12B30	-12CU30	-12M30	-12MP30	1875		
				2000	-12B31	-12CU31	-12M31	-12MP31	1937		
				2125	-12B32	-12CU32	-12M32	-12MP32	2000		
-14B16	-14CU16	-14M16	-14MP16	7/16	1000	-14B16	-14CU16	-14M16	-14MP16	7/16	1000
-14B20	-14CU20	-14M20	-14MP20		1250	-14B20	-14CU20	-14M20	-14MP20		1250
-14B24	-14CU24	-14M24	-14MP24		1500	-14B24	-14CU24	-14M24	-14MP24		1500
-14B28	-14CU28	-14M28	-14MP28		1750	-14B28	-14CU28	-14M28	-14MP28		1750
-14B32	-14CU32	-14M32	-14MP32		2000	-14B32	-14CU32	-14M32	-14MP32		2000
					2250						2250

RECORDING ACTIVITY DLA-15  
 US AIR FORCE- 82 DLA-  
 NUMBER 5370 0828  
 DATE 11/11/99

MILITARY SPECIFICATION SHEET  
 TITLE  
 RIVET, SOLID-UNIVERSAL HEAD, BRASS  
 COPPER NICKEL-COPPER ALLOY

SPECIFICATION SHEET NUMBER  
 MS20615  
 SUPERSEDING  
 MS20615F 30 AUG 1990  
 AMSC N/A FSC 5370

THE REQUIREMENTS FOR ANY OF THE PRODUCT(S) DESCRIBED HEREIN SHALL BE THE REQUIREMENTS SPECIFIED IN THE SPECIFICATION LISTED IN PARAGRAPH 5 OF THE DOD'S SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN PARAGRAPH 5 OF THE DOD'S SPECIFICATION SHEET SHALL TAKE PRECEDENCE OVER THE REQUIREMENTS SPECIFIED IN THE SOLICITATION FIGURE  
 THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE

TABLE # INTERCHANGEABILITY TABLE

DASH NUMBERS					
MONEL		MONEL CADMIUM PLATED		COPPER	
INACTIVE	REPLACEMENT	INACTIVE	REPLACEMENT	INACTIVE	REPLACEMENT
MS20435	MS20615	MS20435	MS20615	MS20435	MS20615
M-2	-2M2	-M2C2	-2MP2	-CU2-2	-2CU2
-M2-3	-2M3	-M2C3	-2MP3	-CU2-3	-2CU3
-M2-4	-2M4	-M2C4	-2MP4	-CU2-4	-2CU4
-M2-5	-2M5	-M2C5	-2MP5	-CU2-5	-2CU5
-M2-6	-2M6	-M2C6	-2MP6	-CU2-6	-2CU6
-M2-7	-2M7	-M2C7	-2MP7	-CU2-7	-2CU7
-M2-8	-2M8	-M2C8	-2MP8	-CU2-8	-2CU8
-M3-3	-3M3	-M3C3	-3MP3	-CU3-3	-3CU3
-M3-4	-3M4	-M3C4	-3MP4	-CU3-4	-3CU4
-M3-5	-3M5	-M3C5	-3MP5	-CU3-5	-3CU5
-M3-6	-3M6	-M3C6	-3MP6	-CU3-6	-3CU6
-M3-7	-3M7	-M3C7	-3MP7	-CU3-7	-3CU7
-M3-8	-3M8	-M3C8	-3MP8	-CU3-8	-3CU8
-M3-10	-3M10	-M3C10	-3MP10	-CU3-10	-3CU10
-M3-12	-3M12	-M3C12	-3MP12	-CU3-12	-3CU12
-M3-14	--	--	--	-CU3-14	-3CU14
-M3-16	--	--	--	-CU3-16	-3CU16
-M4-3	-4M3	-M4C3	-4MP3	-CU4-3	-4CU3
-M4-4	-4M4	-M4C4	-4MP4	-CU4-4	-4CU4
-M4-5	-4M5	-M4C5	-4MP5	-CU4-5	-4CU5
-M4-6	-4M6	-M4C6	-4MP6	-CU4-6	-4CU6
-M4-7	-4M7	-M4C7	-4MP7	-CU4-7	-4CU7
-M4-8	-4M8	-M4C8	-4MP8	-CU4-8	-4CU8
-M4-10	-4M10	-M4C10	-4MP10	-CU4-10	-4CU10
-M4-12	-4M12	-M4C12	-4MP12	-CU4-12	-4CU12
-M4-14	-4M14	-M4C14	-4MP14	-CU4-14	-4CU14
-M4-16	-4M16	-M4C16	-4MP16	-CU4-16	-4CU16
-M4-18	-4M18	-M4C18	-4MP18	--	--
-M5-4	-5M4	-M5C4	-5MP4	--	--
-M5-5	-5M5	-M5C5	-5MP5	--	--
-M5-6	-5M6	-M5C6	-5MP6	-CU5-6	-5CU6
-M5-7	-5M7	-M5C7	-5MP7	-CU5-7	-5CU7
-M5-8	-5M8	-M5C8	-5MP8	-CU5-8	-5CU8
-M5-10	-5M10	-M5C10	-5MP10	-CU5-10	-5CU10
-M5-12	-5M12	-M5C12	-5MP12	-CU5-12	-5CU12
-M5-14	-5M14	-M5C14	-5MP14	-CU5-14	-5CU14
-M5-16	-5M16	-M5C16	-5MP16	-CU5-16	-5CU16
-M5-18	-5M18	-M5C18	-5MP18	--	--
-M6-4	-6M4	--	--	--	--
-M6-5	-6M5	--	--	--	--
-M6-6	-6M6	--	--	-CU6-6	-6CU6
-M6-7	-6M7	--	--	-CU6-7	-6CU7
-M6-8	-6M8	--	--	-CU6-8	-6CU8
-M6-10	-6M10	--	--	-CU6-10	-6CU10
-M6-12	-6M12	--	--	-CU6-12	-6CU12
-M6-14	-6M14	--	--	-CU6-14	-6CU14
-M6-16	-6M16	--	--	-CU6-16	-6CU16
-M6-18	-6M18	--	--	-CU6-18	-6CU18
-M6-20	-6M20	--	--	-CU6-20	-6CU20
-M6-22	-6M22	--	--	-CU6-22	-6CU22
-M6-24	-6M24	--	--	-CU6-24	-6CU24
-M8-5	-8M5	--	--	--	--
-M8-6	-8M6	--	--	--	--
-M8-7	-8M7	--	--	--	--
-M8-8	-8M8	--	--	--	--
-M8-10	-8M10	--	--	--	--
-M8-12	-8M12	--	--	--	--
-M8-14	-8M14	--	--	--	--
-M8-16	-8M16	--	--	--	--
-M8-20	-8M20	--	--	--	--
-M8-24	-8M24	--	--	--	--

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFICATION SHEET: THE SOLICITATION NONE

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE

PREF. ENG ACTIVITY DLA-15 CUSTOMERS ARMY- AV NAVY- AS AIR FORCE- 82 DLA- REVIEW 99 USER PROJECT NUMBER 5320-0828 DATE 10/87	MILITARY SPECIFICATION SHEET TITLE RIVET, SOLID-UNIVERSAL HEAD, BRASS, COPPER NICKEL-COPPER ALLOY	SPECIFICATION SHEET NUMBER 13 FEB 1995 <b>MS20615</b> REV G
		SUPERSEDING MS20615F 30 AUG 1990 AMSC- N/A FSC 5320