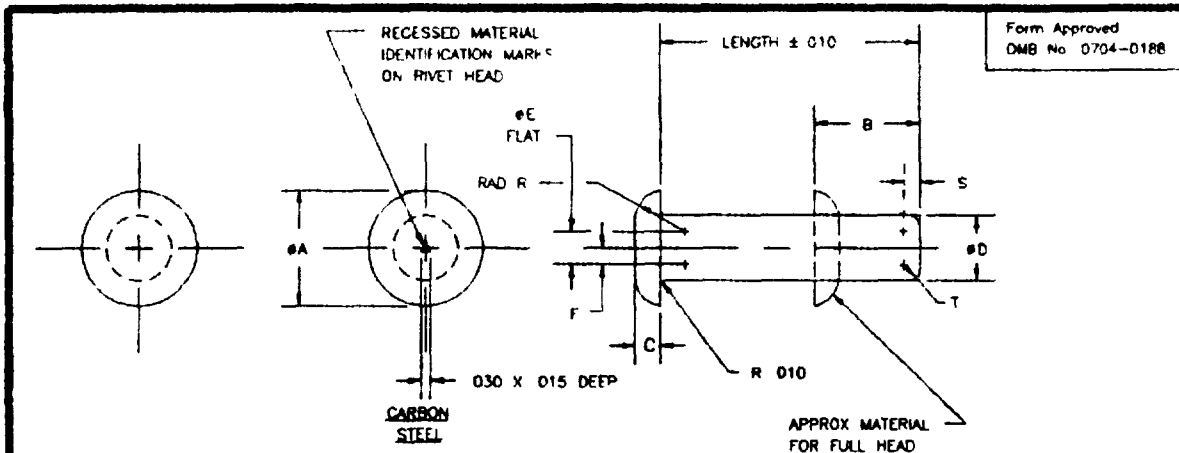


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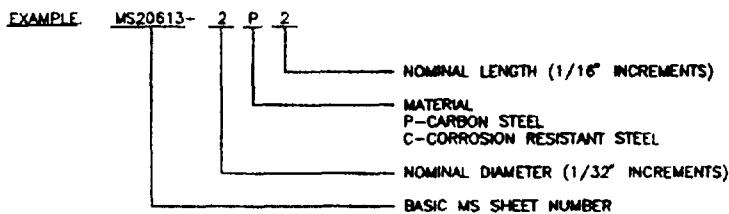


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OMB No 0704-0188

NOM DIA	#D		#A		B REF	C		E REF	F REF	R RAD	S	T RAD
	MIN	MAX	MIN	MAX		MIN	MAX					
1/16	061	065	119	131	094	027	037	031	016	054	016	019
3/32	093	097	178	196	141	040	050	047	023	082	023	029
1/8	124	128	238	262	188	054	064	062	031	108	031	039
5/32	155	160	296	328	234	067	077	078	039	135	039	049
3/16	186	191	356	394	281	080	090	094	047	164	047	059
1/4	249	254	475	525	375	107	117	125	062	217	062	078
5/16	311	316	594	658	469	133	143	156	078	272	078	098
3/8	374	379	713	787	562	161	171	188	094	328	094	117
7/16	436	442	832	918	625	189	199	219	109	383	110	137

**REQUIREMENTS**

- MATERIAL** STEEL, CARBON COMPOSITION C1005 THRU C1015, (UNSG10050 THRU UNS G10150) IN ACCORDANCE WITH ASTM A29/A29M ANNEALED AFTER HEADING STEEL, CORROSION RESISTANT, CLASS 300 SERIES, IN ACCORDANCE WITH ASTM A580, ANNEALED AFTER HEADING
- PROTECTIVE COATING** STEEL, CARBON CADMIUM PLATED PER QQ-P-416, TYPE II, CLASS 2 STEEL, CORROSION RESISTANT, CLEANED DESCALE AND PASSIVATE IN ACCORDANCE WITH QQ-P-35
- SHEAR STRENGTH** CARBON STEEL, 38,000 TO 48,000 PSI  
CORROSION RESISTANT STEEL, 65,000 TO 85,000 PSI
- TOLERANCES** UNLESS OTHERWISE SPECIFIED DECIMALS ± 0.10
- CONCENTRICITY** SHANK AND HEAD DIAMETERS SHALL BE CONCENTRIC WITHIN  
0.10 FIM FOR RIVET SIZES .062 THRU .125  
0.15 FIM FOR RIVET SIZES .156 AND .188  
0.20 FIM FOR RIVET SIZES .250 THRU .438
- PART NUMBER** THE PART NUMBER SHALL CONSIST OF THE BASIC MS SHEET NUMBER FOLLOWED BY A DASH NUMBER SIGNIFYING THE NOMINAL DIAMETER IN THIRTY-SECONDS OF AN INCH INCREMENTS FOLLOWED BY A LETTER INDICATING THE REQUIRED MATERIAL AND AN ADDITIONAL NUMBER SIGNIFYING THE NOMINAL LENGTH IN SIXTEENTH OF AN INCH INCREMENTS



MS20613-2P2 - INDICATES RIVET SOLID-UNIVERSAL HEAD CARBON STEEL, CADMIUM PLATED 1/16" NOMINAL DIAMETER 1/8" NOMINAL LENGTH

ENTIRE STANDARD REVISED

INCH-POUND

PREPARING ACTIVITY DLA-IS CUSTODIANS ARMY- AR NAVY- OS AIR FORCE- 99 DLA- REVIEW USER PROJECT NUMBER 5320-0813 DISTRIBUTION STATEMENT	MILITARY SPECIFICATION SHEET TITLE RIVET, SOLID-UNIVERSAL HEAD, STEEL, CARBON AND STEEL, CORROSION-RESISTANT	SPECIFICATION SHEET NUMBER <b>MS20613</b>	8 FEB 94 REV F
		SUPERSEDING MS20613 E 13 JAN 89 (SEE NOTE B)	
		ANSC- N/A	FSC 5320

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NOTES

- 1 DIMENSIONS DIMENSIONS ARE IN INCHES
- 2 RIVETS MAY BE FURNISHED WITH PLAIN ENDS OR WITH CHAMFERED END WITH A RADIUS TO THE "T" DIMENSIONS OR A 20° CHAMFER TO THE "S" DIMENSION
- 3 ILLUSTRATIONS ARE FOR IDENTIFICATION AND ARE NOT INTENDED TO RESTRICT DESIGNS AND SHAPES OF RIVETS WHICH OTHERWISE CONFORM TO REQUIREMENTS
- 4 UNPLATED CARBON STEEL RIVETS AND ZINC PLATED RIVETS INACTIVE FOR DESIGN AFTER 23 DECEMBER 1960 MS20613 REPLACED THE INACTIVE MS20435 RIVETS OF THE SAME DIAMETER LENGTH AND MATERIAL ON 23 DECEMBER 1960
- 5 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
- 6 REFERENCED GOVERNMENT (OR NON-GOVERNMENT) 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
- 7 FOR THE DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER ACQUISITIONS DOCUMENTS REFERENCED HEREIN
- 8 MS20613 SUPERSEDES MS20435 IN PART

TABLE II DASH NUMBERS AND DIMENSIONS

LENGTH		CARBON STEEL												
		NOMINAL DIAMETERS												
		062	094	125	156	188	250	312	375	438				
		DASH NUMBERS												
1/8	125	2P2												
3/16	188	2P3	3P3	4P3										
1/4	250	2P4	3P4	4P4	5P4	6P4								
5/16	312	2P5	3P5	4P5	5P5	6P5	8P5							
3/8	375	2P6	3P6	4P6	5P6	6P6	8P6							
7/16	438	2P7	3P7	4P7	5P7	6P7	8P7							
1/2	500	2P8	3P8	4P8	5P8	6P8	8P8							
9/16	562													
5/8	625		3P10	4P10	5P10	6P10	8P10	10P10						
3/4	750		3P12	4P12	5P12	6P12	8P12	10P12						
7/8	875		3P14	4P14	5P14	6P14	8P14	10P14						
1	1 000		3P16	4P16	5P16	6P16	8P16	10P16	12P16					
1-1/8	1 125													
1-1/4	1 250			4P20	5P20	6P20	8P20	10P20	12P20					
1-3/8	1 375													
1-1/2	1 500			4P24	5P24	6P24	8P24	10P24	12P24					
1-3/4	1 750				5P28	6P28	8P28	10P28	12P28					
2	2 000				5P32	6P32	8P32	10P32	12P32					

TABLE III DASH NUMBERS AND DIMENSIONS

LENGTH		CARBON STEEL												
		NOMINAL DIAMETERS												
		062	094	125	156	188	250	312	375	438				
		DASH NUMBERS												
1/8	125	2C2												
3/16	188	2C3	3C3	4C3										
1/4	250	2C4	3C4	4C4	5P4	6P4								
5/16	312	2C5	3C5	4C5	5C5	6C5	8C5							
3/8	375	2C6	3C6	4C6	5C6	6C6	8C6							
7/16	438	2C7	3C7	4C7	5C7	6C7	8C7							
1/2	500	2C8	3C8	4C8	5C8	6C8	8C8							
9/16	562													
5/8	625		3C10	4C10	5C10	6C10	8C10	10C10						
3/4	750		3C12	4C12	5C12	6C12	8C12	10C12						
7/8	875		3C14	4C14	5C14	6C14	8C14	10C14						
1	1 000		3C16	4C16	5C16	6C16	8C16	10C16	12C16					
1-1/8	1 125													
1-1/4	1 250			4C20	5C20	6C20	8C20	10C20	12C20					
1-3/8	1 375													
1-1/2	1 500			4C24	5C24	6C24	8C24	10C24	12C24					
1-3/4	1 750				5C28	6C28	8C28	10C28	12C28					
2	2 000				5C32	6C32	8C32	10C32	12C32					

PREPARING ACTIVITY DLA-IS	MILITARY SPECIFICATION SHEET	SPECIFICATION SHEET NUMBER
CUSTODIANS ARMY- AR NAVY- OS	TITLE	MS20613 8 FEB 94 REV F
AIR FORCE- 99 DLA-	RIVET, SOLID-UNIVERSAL HEAD STEEL, CARBON AND STEEL, CORROSION-RESISTANT	SUPERSEDING MS20613 E 13 JAN 89 (SEE NOTE B)
REVIEW USER		AMSC- N/A FSC 5320
PROJECT NUMBER 5320-0813		
DISTRIBUTION STATEMENT	A Approved for public release distribution is unlimited	Page 2 of 3

TABLE IV - INACTIVE RIVETS OF MS20435 IN PART, AND UNPLATED AND ZINC PLATED PLATED OF MS20613 ARE AS SHOWN IN NOTE 4 REPLACEMENT SHALL BE IN ACCORDANCE WITH THIS TABLE

MS20435 MS20613		MS20435		MS20613		MS20435		MS20613		MS20435		MS20613											
INACTIVE				NEW				INACTIVE				NEW											
CARBON STEEL								CORROSION RESISTANT STEEL				CARBON STEEL								CORROSION RESISTANT STEEL			
UN-PLATED	ZINC PLATED	CADMIUM PLATED	CADMIUM PLATED	CORROSION RESISTANT STEEL				UN-PLATED	ZINC PLATED	CADMIUM PLATED	CADMIUM PLATED	CORROSION RESISTANT STEEL											
DASH NUMBER				DASH NUMBER				DASH NUMBER				DASH NUMBER											
2-2	222	2C2	2P2	F2-2	2C2	6-6	6Z6	6C6	6P6	F6-6	6C6	6C6	6C6										
2-3	223	2C3	2P3	F2-3	2C3	6-7	6Z7	6C7	6P7	F6-7	6C7	6C7	6C7										
2-4	224	2C4	2P4	F2-4	2C4	6-8	6Z8	6C8	6P8	F6-8	6C8	6C8	6C8										
2-5	225	2C5	2P5	F2-5	2C5	6-10	6Z10	6C10	6P10	F6-10	6C10	6C10	6C10										
2-6	226	2C6	2P6	F2-6	2C6	6-12	6Z12	6C12	6P12	F6-12	6C12	6C12	6C12										
2-7	227	2C7	2P7	F2-7	2C7	6-14	6Z14	6C14	6P14	F6-14	6C14	6C14	6C14										
2-8	228	2C8	2P8	F2-8	2C8	6-16	6Z16	6C16	6P16	F6-16	6C16	6C16	6C16										
						6-18	6Z18	6C18	6P18	F6-18	6C18	6C18	6C18										
3-3	323	3C3	3P3	F3-3	3C3	6-20	6Z20	6C20	6P20	F6-20	6C20	6C20	6C20										
3-4	324	3C4	3P4	F3-4	3C4	6-22	6Z22	6C22	6P22	F6-22	6C22	6C22	6C22										
3-5	325	3C5	3P5	F3-5	3C5	6-24	6Z24	6C24	6P24	F6-24	6C24	6C24	6C24										
3-6	326	3C6	3P6	F3-6	3C6	6-28	6Z28	6C28	6P28	F6-28	6C28	6C28	6C28										
3-7	327	3C7	3P7	F3-7	3C7	6-32	6Z32	6C32	6P32	F6-32	6C32	6C32	6C32										
3-8	328	3C8	3P8	F3-8	3C8																		
3-10	3210	3C10	3P10	F3-10	3C10	8-5	8Z5	8C5	8P5	F8-5	8C5	8C5	8C5										
3-12	3212	3C12	3P12	F3-12	3C12	8-6	8Z6	8C6	8P6	F8-6	8C6	8C6	8C6										
3-14	3214	3C14	3P14	F3-14	3C14	8-7	8Z7	8C7	8P7	F8-7	8C7	8C7	8C7										
3-16	3216	3C16	3P16	F3-16	3C16	8-8	8Z8	8C8	8P8	F8-8	8C8	8C8	8C8										
						8-10	8Z10	8C10	8P10	F8-10	8C10	8C10	8C10										
4-3	423	4C3	4P3	F4-3	4C3	8-12	8Z12	8C12	8P12	F8-12	8C12	8C12	8C12										
4-4	424	4C4	4P4	F4-4	4C4	8-14	8Z14	8C14	8P14	F8-14	8C14	8C14	8C14										
4-5	425	4C5	4P5	F4-5	4C5	8-16	8Z16	8C16	8P16	F8-16	8C16	8C16	8C16										
4-6	426	4C6	4P6	F4-6	4C6	8-20	8Z20	8C20	8P20	F8-20	8C20	8C20	8C20										
4-7	427	4C7	4P7	F4-7	4C7	8-24	8Z24	8C24	8P24	F8-24	8C24	8C24	8C24										
4-8	428	4C8	4P8	F4-8	4C8	8-28	8Z28	8C28	8P28	F8-28	8C28	8C28	8C28										
4-10	4210	4C10	4P10	F4-10	4C10	8-32	8Z32	8C32	8P32	F8-32	8C32	8C32	8C32										
4-12	4212	4C12	4P12	F4-12	4C12																		
4-14	4214	4C14	4P14	F4-14	4C14	10-10	10Z10	10C10	10P10	F10-10	10C10	10C10	10C10										
4-16	4216	4C16	4P16	F4-16	4C16	10-12	10Z12	10C12	10P12	F10-12	10C12	10C12	10C12										
4-20	4220	4C20	4P20	F4-20	4C20	10-14	10Z14	10C14	10P14	F10-14	10C14	10C14	10C14										
4-24	4224	4C24	4P24	F4-24	4C24	10-16	10Z16	10C16	10P16	F10-16	10C16	10C16	10C16										
						10-20	10Z20	10C20	10P20	F10-20	10C20	10C20	10C20										
5-4	524	5C4	5P4	F5-4	5C4	10-24	10Z24	10C24	10P24	F10-24	10C24	10C24	10C24										
5-5	525	5C5	5P5	F5-5	5C5	10-28	10Z28	10C28	10P28	F10-28	10C28	10C28	10C28										
5-6	526	5C6	5P6	F5-6	5C6	10-32	10Z32	10C32	10P32	F10-32	10C32	10C32	10C32										
5-7	527	5C7	5P7	F5-7	5C7																		
5-8	528	5C8	5P8	F5-8	5C8	12-12	12Z12	12C12	12P12	F12-12	12C12	12C12	12C12										
5-10	5210	5C10	5P10	F5-10	5C10	12-14	12Z14	12C14	12P14	F12-14	12C14	12C14	12C14										
5-12	5212	5C12	5P12	F5-12	5C12	12-16	12Z16	12C16	12P16	F12-16	12C16	12C16	12C16										
5-14	5214	5C14	5P14	F5-14	5C14	12-20	12Z20	12C20	12P20	F12-20	12C20	12C20	12C20										
5-16	5216	5C16	5P16	F5-16	5C16	12-24	12Z24	12C24	12P24	F12-24	12C24	12C24	12C24										
5-20	5220	5C20	5P20	F5-20	5C20	12-28	12Z28	12C28	12P28	F12-28	12C28	12C28	12C28										
5-24	5224	5C24	5P24	F5-24	5C24	12-32	12Z32	12C32	12P32	F12-32	12C32	12C32	12C32										
5-28	5228	5C28	5P28	F5-28	5C28																		
5-32	5232	5C32	5P32	F5-32	5C32																		
						14-16	14Z16	14C16	14P16	F14-16	14C16	14C16	14C16										
6-4	624	6C4	6P4	F6-4	6C4	14-20	14Z20	14C20	14P20	F14-20	14C20	14C20	14C20										
6-5	625	6C5	6P5	F6-5	6C5	14-24	14Z24	14C24	14P24	F14-24	14C24	14C24	14C24										
						14-28	14Z28	14C28	14P28	F14-28	14C28	14C28	14C28										
						14-32	14Z32	14C32	14P32	F14-32	14C32	14C32	14C32										

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PREPARING ACTIVITY DLA-IS	MILITARY SPECIFICATION SHEET	SPECIFICATION SHEET NUMBER
CUSTODIANS ARMY- AR NAVY- OS	TITLE	MS20613
AIR FORCE- 99 DLA-	RIVET SOLID-UNIVERSAL HEAD, STEEL, CARBON AND STEEL, CORROSION-RESISTANT	8 FEB 94 REV F
REVIEW USER		SUPERSEDING MS20613 E 13 JAN 89 (SEE NOTE 8)
PROJECT NUMBER 5320-0813		AMSC- N/A FSC 5320

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