

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 SPECIFIED IN THE SOLICITATION: NONE

Form Approved  
OMB No. 0704-0188

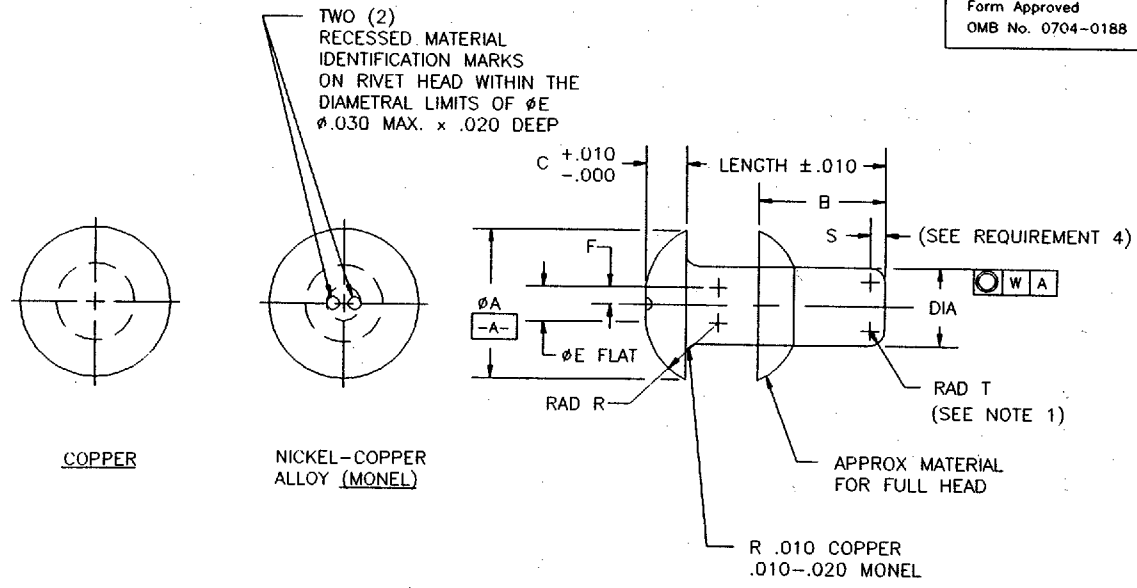


TABLE I. DIMENSIONS

NOMINAL DIA.	DIA.		$\phi A$	B REF.	C	$\phi E$ REF.	F	R RAD	S	T RAD	W
1/16	.062	+.003 -.001	.125 $\pm .006$	.094	.027	.031	.015	.054	.016	.019	.020
3/32	.094		.187 $\pm .009$	.141	.040	.046	.023	.082	.023	.029	
1/8	.125	+.004 -.001	.250 $\pm .012$	.168	.054	.062	.031	.108	.031	.039	.025
5/32	.156		.312 $\pm .016$	.234	.067	.078	.039	.135	.039	.049	
3/16	.187		.375 $\pm .019$	.281	.080	.093	.046	.164	.047	.059	
1/4	.250	+.005 -.001	.500 $\pm .025$	.375	.107	.125	.062	.217	.062	.078	.030
5/16	.312		.625 $\pm .031$	.469	.133	.156	.078	.272	.078	.098	
3/8	.375		.750 $\pm .037$	.562	.161	.187	.093	.328	.094	.117	
7/16	.437		.875 $\pm .043$	.625	.189	.218	.109	.383	.110	.137	

REQUIREMENTS:

- MATERIAL:** COPPER, ASTM B3. (UNS C11000).  
NICKLE-COPPER ALLOY (MONEL), QQ-N-281, CLASS A, (UNS N04400).  
BRASS, QQ-W-321, ALLOY 270, 1/8 HARD (UNS C27000).
- FINISH:** ONLY WHEN SPECIFIED NICKLE-COPPER ALLOY (MONEL) CADMIUM PLATE, QQ-P-416, TYPE II, CLASS 2.
- SHEAR STRENGTH:** COPPER, 17,000 PSI TO 30,000 PSI.  
NICKLE-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, FINS, 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 "R" AFTER THE LAST DASH NUMBER.

EXAMPLE OF PART NUMBER:

MS20615-2M8 = RIVET, UNIVERSAL HEAD, NICKEL COPPER ALLOY, 1/16 INCH DIA., 1/2 INCH LONG.  
MS20615-2M8R = RIVET, UNIVERSAL HEAD NICKEL COPPER ALLOY, 1/16 INCH DIA., .531 LONG.

ENTIRE DOCUMENT REVISED

INCH-POUND

PREPARING ACTIVITY: DLA-IS	MILITARY SPECIFICATION SHEET	SPECIFICATION SHEET NUMBER	13 FEB 1995
CUSTODIANS: ARMY- AV      NAVY- AS	TITLE	MS20615	REV G
AIR FORCE- 82      DLA-	RIVET, SOLID-UNIVERSAL HEAD, BRASS, COPPER, NICKLE-COPPER ALLOY	SUPERSEDING	MS20615F 30 AUG 1990
REVIEW: 99		AMSC-	N/A      FSC 5320
USER:			
PROJECT NUMBER: 5320-0828			
DISTRIBUTION STATEMENT	A. Approved for public release; distribution is unlimited.		Page 1 of 3

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

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**NOTES:**

1. DIMENSIONS ARE IN INCHES.
2. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ± 0.10.
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.
4. IN THE EVENT OF A CONFLICT THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED 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	COPPER	MONEL	MONEL - CADMIUM PLATED	DIA.	LENGTH	BRASS	COPPER	MONEL	MONEL - CADMIUM PLATED	DIA.	LENGTH		
DASH NO.	DASH NO.	DASH NO.				DASH NO.	DASH NO.	DASH NO.					
-2B2	-2CU2	-2M2	-2MP2	1/16	.125	-6B4		-6M4	-6MP4	3/16	.250		
-2B3	-2CU3	-2M3	-2MP3		.187	-6B5		-6M5	-6MP5		.312		
-2B4	-2CU4	-2M4	-2MP4		.250	-6B6	-6CU6	-6M6	-6MP6		.375		
-2B5	-2CU5	-2M5	-2MP5		.312	-6B7	-6CU7	-6M7	-6MP7		.438		
-2B6	-2CU6	-2M6	-2MP6		.375	-6B8	-6CU8	-6M8	-6MP8		.500		
-2B7	-2CU7	-2M7	-2MP7		.438	-6B9		-6M9	-6MP9		.562		
-2B8	-2CU8	-2M8	-2MP8		.500	-6B10	-6CU10	-6M10	-6MP10		.625		
-2B9			-2MP9		.562	-6B11		-6M11	-6MP11		.688		
						-6B12	-6CU12	-6M12	-6MP12		.750		
-3B3	-3CU3	-3M3	-3MP3	3/32	.187	-6B13		-6M13	-6MP13	.812			
-3B4	-3CU4	-3M4	-3MP4		.250	-6B14	-6CU14	-6M14	-6MP14	.875			
-3B5	-3CU5	-3M5	-3MP5		.312	-6B15		-6M15	-6MP15	.938			
-3B6	-3CU6	-3M6	-3MP6		.375	-6B16	-6CU16	-6M16	-6MP16	1.000			
-3B7	-3CU7	-3M7	-3MP7		.438	-6B18	-6CU18	-6M18	-6MP18	1.125			
-3B8	-3CU8	-3M8	-3MP8		.500	-6B20	-6CU20	-6M20	-6MP20	1.250			
-3B9		-3M9	-3MP9		.562	-6B22	-6CU22	-6M22	-6MP22	1.375			
-3B10	-3CU10	-3M10	-3MP10		.625	-6B24	-6CU24	-6M24	-6MP24	1.500			
-3B11		-3M11	-3MP11		.688	-6B28		-6M28	-6MP28	1.750			
-3B12	-3CU12	-3M12	-3MP12		.750	-6B32		-6M32	-6MP32	2.000			
	-3CU14		-3MP14		.875								
	-3CU16		-3MP16		1.000								
-4B3		-4M3	-4MP3	1/8	.187	-8B5	-8CU5	-8M5	-8MP5	1/4	.312		
-4B4	-4CU4	-4M4	-4MP4		.250	-8B6	-8CU6	-8M6	-8MP6		.375		
-4B5	-4CU5	-4M5	-4MP5		.312	-8B7	-8CU7	-8M7	-8MP7		.438		
-4B6	-4CU6	-4M6	-4MP6		.375	-8B8	-8CU8	-8M8	-8MP8		.500		
-4B7	-4CU7	-4M7	-4MP7		.438	-8B9	-8CU9	-8M9	-8MP9		.562		
-4B8	-4CU8	-4M8	-4MP8		.500	-8B10	-8CU10	-8M10	-8MP10		.625		
-4B9		-4M9	-4MP9		.562	-8B11	-8CU11	-8M11	-8MP11		.688		
-4B10	-4CU10	-4M10	-4MP10		.625	-8B12	-8CU12	-8M12	-8MP12		.750		
-4B11		-4M11	-4MP11		.688	-8B13	-8CU13	-8M13	-8MP13		.812		
-4B12	-4CU12	-4M12	-4MP12		.750	-8B14	-8CU14	-8M14	-8MP14		.875		
-4B13		-4M13	-4MP13		.812	-8B15	-8CU15	-8M15	-8MP15		.938		
-4B14	-4CU14	-4M14	-4MP14		.875	-8B16	-8CU16	-8M16	-8MP16		1.000		
-4B15		-4M15	-4MP15		.938	-8B18	-8CU18	-8M18	-8MP18		1.125		
-4B16	-4CU16	-4M16	-4MP16		1.000	-8B20	-8CU20	-8M20	-8MP20		1.250		
-4B18		-4M18	-4MP18		1.125	-8B22	-8CU22	-8M22	-8MP22		1.375		
-4B20		-4M20	-4MP20		1.250	-8B24	-8CU24	-8M24	-8MP24		1.500		
						-8B28	-8CU28	-8M28	-8MP28		1.750		
						-8B32	-8CU32	-8M32	-8MP32		2.000		
-5B4		-5M4	-5MP4		5/32	.250	-10B10	-10CU10	-10M10		-10MP10	5/16	.625
-5B5		-5M5	-5MP5			.312	-10B12	-10CU12	-10M12		-10MP12		.750
-5B6	-5CU6	-5M6	-5MP6	.375		-10B14	-10CU14	-10M14	-10MP14	.875			
-5B7	-5CU7	-5M7	-5MP7	.438		-10B16	-10CU16	-10M16	-10MP16	1.000			
-5B8	-5CU8	-5M8	-5MP8	.500		-10B20	-10CU20	-10M20	-10MP20	1.250			
-5B9		-5M9	-5MP9	.562		-10B24	-10CU24	-10M24	-10MP24	1.500			
-5B10	-5CU10	-5M10	-5MP10	.625		-10B28	-10CU28	-10M28	-10MP28	1.750			
-5B11		-5M11	-5MP11	.688		-10B32	-10CU32	-10M32	-10MP32	2.000			
-5B12	-5CU12	-5M12	-5MP12	.750									
-5B13		-5M13	-5MP13	.812		-12B12	-12CU12	-12M12	-12MP12	.750			
-5B14	-5CU14	-5M14	-5MP14	.875		-12B14	-12CU14	-12M14	-12MP14	.875			
-5B15		-5M15	-5MP15	.938		-12B16	-12CU16	-12M16	-12MP16	1.000			
-5B16	-5CU16	-5M16	-5MP16	1.000		-12B20	-12CU20	-12M20	-12MP20	1.250			
		-5M18	-5MP18	1.125		-12B24	-12CU24	-12M24	-12MP24	1.500			
		-5M20	-5MP20	1.250		-12B28	-12CU28	-12M28	-12MP28	1.750			
		-5M22	-5MP22	1.375		-12B32	-12CU32	-12M32	-12MP32	2.000			
		-5M24	-5MP24	1.500									
		-5M28	-5MP28	1.750		-14B16	-14CU16	-14M16	-14MP16	1.000			
		-5M32	-5MP32	2.000	-14B20	-14CU20	-14M20	-14MP20	1.250				
					-14B24	-14CU24	-14M24	-14MP24	1.500				
					-14B28	-14CU28	-14M28	-14MP28	1.750				
					-14B32	-14CU32	-14M32	-14MP32	2.000				

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PREPARING ACTIVITY: DLA-IS	MILITARY SPECIFICATION SHEET	SPECIFICATION SHEET NUMBER	13 FEB 1995
CUSTODIANS: ARMY- AV NAVY- AS	TITLE	MS20615	REV G
AIR FORCE- 82 DLA-	RIVET, SOLID-UNIVERSAL HEAD, BRASS, COPPER, NICKEL-COPPER ALLOY	SUPERSEDING	
REVIEW: 99		MS20615F 30 AUG 1990	
USER:		AMSC- N/A	FSC 5320
PROJECT NUMBER: 5320-0828			
DISTRIBUTION STATEMENT	A. Approved for public release; distribution is unlimited.		Page 2 of 3

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TABLE III. INTERCHANGEABILITY TABLE

DASH NUMBERS					
MONEL		MONEL CADMIUM PLATED		COPPER	
INACTIVE	REPLACEMENT	INACTIVE	REPLACEMENT	INACTIVE	REPLACEMENT
MS20435	MS20615	MS20435	MS20615	MS20435	MS20615
-M2-2	-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	---	---	---	---

PREPARING ACTIVITY: DLA-IS  
CUSTODIANS: ARMY- AV NAVY- AS  
AIR FORCE- 82 DLA-  
REVIEW: 99  
USER:  
PROJECT NUMBER: 5320-0828

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

DISTRIBUTION STATEMENT  
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