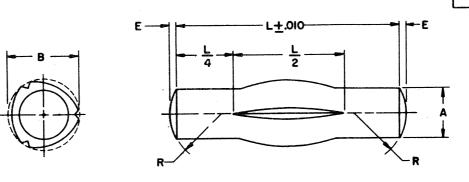
FED. SUP CLASS 5315



NOMINAL SIZE		1/16		5/64		3/32		1/8		5/32	
A DIAMETER	MAX MIN	.0625 .0615		.0781 .0771		.0938 .0928		.1250 .1230		.1563 .1543	
E *CROWN HEIGHT	REF	.0065		.0087		.0091		.0130		.0170	
R RADIUS	MAX MIN	.0881 .0681		.1037 .0837		.1350 .1150		.1662 .1462		.1975 .1775	
RECOMMENDED HOLE SIZE	MAX MIN	.0640 .0625		.0798 .0781		.0956 .0938		.1271 .1250		.1587 .1563	
SINGLE SHEAR STRENGTH - LBS	MIN	2	00	310		440		790		1230	
L LENGTH		DASH NO.	B DIA. ±.001	DASH NO.	B DIA. ±.001	DASH NO.	B DIA. ±.001	DASH NO.	B DIA. ±.002	DASH NO.	B DIA. ±.002
1/4 3/8 1/2		1 2 3	.068 .068 .068	6 7	.084 .084	10 11	.101 .101	15 16	.134	22	.166
5/8 3/4 1		4 5	.068 .068	8 9	.084 .084	12 13 14	.101 .101 .101	17 18 19	.134 .134 .134	23 24 25	.166 .166 .166
1-1/4 1-1/2								20 21	.134 .134	26 27	.166 .166

For additional sizes see sheet 2.

MATERIAL: Steel, cold-drawn, Blll2 or 1212, in accordance with the procurement specification.

PROTECTIVE COATING: Cadmium plate in accordance with the procurement specification.

APPLICATION: Grooved pins are locked securely in place by elastic deformation eliminating the need for tapping or reaming of tapered or sized holes.

DIMENSIONS: All dimensions are in inches unless otherwise specified.

PART NUMBER: The MS part number consists of the MS number plus the dash number. Example: MS35677-1.

NOTES: (1) Dash numbers for cadmium plated pins as shown on this revised standard are the same as the dash numbers for the cadmium or zinc plated (optional) pins shown on the original standard. standard.

standard.

Diameter"B" is the expanded diameter as measured with a ring gage.

Ends of pins may be square with .01-inch to .02-inch radius on the edges.

For design feature purposes, this standard takes precedence over procurement documents referenced herein.

(5) Referenced documents shall be of the issue in effect on date of invitations for bid.

**ENTIRE** STANDARD REVISED (A)

MILITARY STANDARD WC TITLE PIN, GROOVED, HEADLESS-LONGITUDINAL WP 69 MS 35677 CENTER GROOVE, CARBON STEEL PROCUREMENT SPECIFICATION SUPERSEDES: MIL-P-20700 BFCX4.1 and in part AEGX2

P.A. WC Other Cust WP 69	1	PIN, GROOVED, HEADLESS - LONGITUDINAL CENTER GROOVE, CARBON STEEL							MILITARY STAND MS 35677		
								,			
*See Note (3), For illustrat	sheet l ion, mat	erial, p	orotective	e coating	, and oth	er perti	nent data	see she	eet 1.		
2-1/2 2-3/4								58 59	.394		
1-3/4		32 33 34 35	.198 .198 .198 .198	40 41 42	.230 .230 .230 .230	46 47 48 49 50	.263 .263 .263 .263 .263	54 55 56 57	.394 .394 .394 .394		
1/2 5/8 3/4		28 29 30 31	.198 .198 .198	36 37 38	.230 .230 .230	43 44 45	.263 .263 .263	51 52 53	.394 .394		
L LENGTH		DASH NO.	B DIA. ±.002	DASH NO.	B DIA. ±.002	DASH NO.	B DIA. ±.002	DASH NO.	B DIA. ±.002	DASH NO.	D: ±.0
SINGLE SHEAR	MIN	1770		, 2400		3140		7070			
RECOMMENDED HOLE SIZE	MAX MIN	.1903		.2219 .2188		.2534 .2500		.3797 .3750			
R RADIUS	MAX MIN	.2600 .2400		.2912 .2712		.3225 .3025		.4787 .4587			
E *CROWN HEIGHT	REF			.0220		.0260		.0390			
A DIAMETER	MAX MIN			.2188 .2168		.2500 .2480		.3750 .3730			
	E *CROWN HEIGHT  R RADIUS  RECOMMENDED HOLE SIZE  SINGLE SHEAR STRENGTH - LBS  L LENGTH  1/2 5/8 3/4 1 1-1/4 1-1/2 1-3/4 2-1/4 2-1/2 2-3/4  *See Note (3), For illustrat:	A DIAMETER MIN  E *CROWN HEIGHT REF  R RADIUS MAX MIN  RECOMMENDED MAX HOLE SIZE MIN  SINGLE SHEAR STRENGTH - LBS  L LENGTH  1/2 5/8 3/4 1 1-1/4 1-1/2 1-3/4 2 2-1/4 2-1/2 2-3/4  *See Note (3), sheet 1 For illustration, mat	### BIAMETER   MIN   .1    E *CROWN HEIGHT   REF   .0    R RADIUS   MAX   .2    RECOMMENDED   MAX   .1    HOLE SIZE   MIN   .1    SINGLE SHEAR   STRENGTH - LBS   MIN   17    L LENGTH   DASH   NO.      1/2   28   5/8   29   3/4   30      1   31   1-1/4   32   1-1/2   33      1   -1/4   32   35      2-1/4   2-1/2   2-3/4    *See Note (3), sheet 1.    For illustration, material, p	E *CROWN HEIGHT REF .0180  R RADIUS MAX .2600 MIN .2400  RECOMMENDED MAX .1903 .1875  SINGLE SHEAR STRENGTH - LBS MIN 1770  L LENGTH DASH NO. ±.002  1/2 28 .198 .198 .3/4 .30 .198 .198 .198 .1-1/2 .33 .198 .198 .1-1/2 .33 .198 .1-3/4 .34 .198 .2-1/4 .2-1/2 .2-3/4  *See Note (3), sheet 1. For illustration, material, protective	E *CROWN HEIGHT REF .0180 .0  R RADIUS MAX .2600 .2  RECOMMENDED MAX .1903 .2  HOLE SIZE MIN .1875 .2  SINCLE SHEAR STRENGTH - LBS MIN .002400 .24  L LENGTH DASH DIA2002 NO24  L LENGTH .28 .29 .198 .36 .37 .198 .37 .198 .37 .198 .37 .198 .38 .198 .29 .198 .37 .198 .37 .198 .38 .198 .40 .2-1/2 .35 .198 .40 .2-1/2 .2-3/4 .2-1/2 .2-3/4 .198 .40 .2-1/2 .2-3/4 .198 .40 .42 .2-1/2 .2-3/4 .198 .40 .42 .2-1/2 .2-3/4 .198 .40 .42 .2-1/2 .2-3/4 .198 .40 .42 .42 .42 .42 .42 .42 .42 .43 .43 .44 .44 .45 .45 .45 .45 .45 .45 .45 .45	E *CROWN HEIGHT REF .0180 .0220  R RADIUS MAX .2600 .2912 .7712  RECOMMENDED MAX .1903 .2219 .188  SINCLE SHEAR STRENCTH - LBS MIN 1770 .2400  L LENGTH DASH DIA NO. ±002 1912 .1002  1/2 28 .198 36 .230 3/4 30 .198 36 .230 198 39 .230 198 39 .230 198 39 .230 198 39 .230 198 39 .230 198 39 .230 193/4 34 .198 39 .230 193/4 34 .198 34 .230 198 39 .230 193/4 34 .198 40 .230 193/4 34 .198 41 .230 2-1/4 2-1/2 35 .198 42 .230  *See Note (3), sheet 1. For illustration, material, protective coating, and other statements of the statement	## A BIAMETER MIN	## CROWN HEIGHT REF	## CROWN HEIGHT REF	## A DIAMETER MIN	E *CROWN HEIGHT REF .0180 .0220 .0260 .0390

FED. SUP CLASS 5315

REVISED (A) FOR CHANGES SEE SHEET I.

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		PPROVED		
P.A. WC	TITLE PIN, GROOVED, HEADLESS - LONGITUDINAL	MILITARY STANDARD		
Other Cust WP 69	CENTER GROOVE, CARBON STEEL	MS 35677		
PROCUREMENT SPECIFICATION MIL-P-20700	SUPERSEDES: BFCX4.1 and in part AEGX2	SHEET 2 OF		