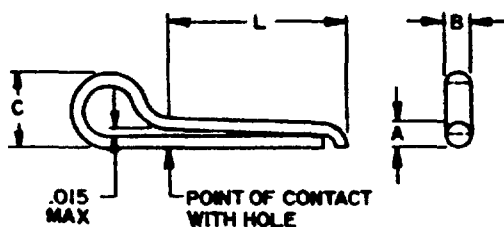
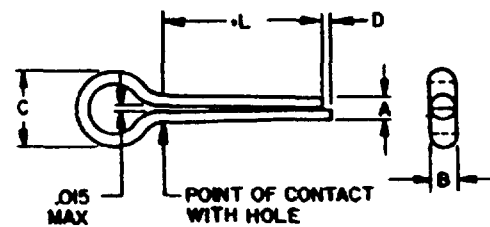


FED. SUP CLASS
5315



HAMMER LOCK
 (SEE NOTE 2)



**EXTENDED PRONG SQUARE CUT
 (PLAN)**
 (SEE NOTE 2)

TABLE I CONFIGURATION DIMENSIONS

SIZE NOMINAL DIAMETER	A		B		C	D	HOLE SIZE RECOMMENDED
	MAX	MIN	MAX	MIN	MIN	MIN	
1/32 - .031	.052	.028	.052	.022	.06	.01	.047
3/64 - .047	.048	.044	.048	.075	.09	.02	.062
1/16 - .062	.060	.056	.060	.044	.12	.03	.078
1/ 5/64 - .078	.076	.072	.076	.057	.16	.04	.094
3/32 - .094	.090	.086	.090	.069	.19	.04	.109
1/8 - .125	.120	.116	.120	.093	.25	.06	.141
5/32 - .156	.150	.146	.150	.116	.31	.07	.172
3/16 - .188	.176	.172	.176	.137	.38	.09	.205
1/ 7/32 - .219	.207	.202	.207	.161	.44	.10	.234
1/4 - .250	.225	.220	.225	.176	.50	.11	.266
5/16 - .312	.280	.275	.280	.220	.62	.14	.312
3/8 - .375	.335	.329	.335	.263	.75	.16	.375
1/ 7/16 - .438	.406	.400	.406	.320	.88	.20	.438
1/2 - .500	.473	.467	.473	.373	1.00	.23	.500
5/8 - .625	.598	.590	.598	.472	1.25	.30	.625
1/ 3/4 - .750	.723	.715	.723	.572	1.50	.36	.750

1/ Not a preferred size. Do not use for new design.

REQUIREMENTS

- MATERIAL** CARBON, STEEL, BRASS, CORROSION RESISTANT STEEL AND NICKEL COPPER ALLOY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- PROTECTIVE COATING** CARBON STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 3 OR PHOSPHATE COATED IN ACCORDANCE WITH MIL-P-16232, TYPE 2, CLASS 3 AND THE PROCUREMENT SPECIFICATION
 BRASS SHALL BE BLACK CHEMICAL FINISH AS SPECIFIED IN MIL-P-495 AND IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION
 CORROSION RESISTANT STEEL SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380 AND THE PROCUREMENT SPECIFICATION.

Ⓕ ENTIRE STANDARD REVISED

P.A.	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cost	OS 99		PIN, COTTER (SPLIT)	MS24665
PROCUREMENT SPECIFICATION	SUPERSEDES		PAGE	OF
ANSI B18.8.1	BFA33, BFA33 I, BFA33.2, AN380, AND AN381		1	8

USER ACTIVITIES
 ARMY-AT, ME, MI
 NAVY-YD

REVIEWER ACTIVITIES
 ARMY-AV, ER
 AIR FORCE-11, 82
 NSA-NS
 DLA-IS

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AMSC N/A

DD FORM 1 MAY 72 **672-1** (COORDINATED)

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5315-0424

APPROVED 16 MAR 60
 REVISED F 18 JUN 86

USER ACTIVITIES
 ARMY-AT, ME, M
 NAVY-YD

REVIEWER ACTIVITIES
 ARMY-AVER
 AIR FORCE-II, 82
 NSA-NS
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3. HARDNESS CORROSION RESISTANT STEEL COTTER PINS SHALL HAVE A HARDNESS AS FOLLOWS:

NOMINAL COTTER PIN DIA	VICKERS (10 Kg LOAD)	ROCKWELL 15N
1/16 - .062 AND LESS	200 TO 350 HV10	65 TO 78 HR15N
5/64 - .078 AND 3/32 - .094	170 TO 245 HV10	60 TO 70 HR15N
1/8 - .125 AND LARGER	140 TO 220 HV10	55 TO 67 HR15N

CORROSION RESISTANT STEEL COTTER PINS SHALL BE TESTED FOR HARDNESS IN
 ACCORDANCE WITH MIL-STD-1312 TEST NO 6.

4. LENGTH TOLERANCE THE COTTER PINS SHALL MEET THE LENGTH TOLERANCE AS SPECIFIED IN THE PROCUREMENT
 SPECIFICATION.
5. PART NUMBER THE PART NUMBER SHALL CONSIST OF THE BASIC MS SHEET NUMBER PLUS THE DASH NUMBER TAKEN
 FROM TABLES II, III, IV, V AND VI AS APPLICABLE.

EXAMPLE MS24665-39
 └── DASH NUMBER
 └── BASIC MS SHEET NUMBER

MS24665-39 INDICATES - PIN, COTTER (SPLIT), BRASS WITH BLACK CHEMICAL FINISH
 NOMINAL DIAMETER 1/32 INCH, LENGTH 1/2 INCH.

6. QUALITY ASSURANCE PROVISIONS QUALITY ASSURANCE PROVISIONS SHALL BE IN ACCORDANCE WITH ANSI B18.18.1M.
7. PACKAGING PACKAGING SHALL BE IN ACCORDANCE WITH ASTM D3951

NOTES

- ALL DIMENSIONS ARE IN INCHES
- PREFERRED POINT TYPES SHALL BE THE EXTENDED POINT SQUARE (PLAIN) CUT OR HAMMER LOCK TYPES AS DEPICTED
 HEREIN OTHER OPTIONAL COTTER PIN DESIGN SHALL BE IN ACCORDANCE WITH PROCUREMENT SPECIFICATION
- 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.
- REFERENCED GOVERNMENT (OR NONGOVERNMENT) 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.

APPROVED 16 MAR 60 REVISED F FOR CHANGES SEE PAGES 1, 2, 3, 4, 5, 6, 7 AND 8

P.A.	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cont	OS 99		PIN, COTTER (SPLIT)	MS24665
PROCUREMENT SPECIFICATION	SUPERSEDES		PAGE	OF
ANSI B18.8.1	BFA33, BFA33.1, BFA33.2, AN380, AND AN381		2	8

FED. SUP. CLASS
 5315

USER ACTIVITIES
 ARMY-AT, ME, MI
 NAVY-YD

REVIEWER ACTIVITIES
 ARMY-AV, ER
 AIRFORCE-11, 82
 NSA-NS
 DLA-IS

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TABLE II DASH NUMBERS AND DIMENSIONS - BRASS

L LENGTH	NOMINAL DIAMETER															
	1/32	3/64	1/16	5/64 ^{1/}	3/32	1/8	5/32	3/16	7/32 ^{1/}	1/4	5/16	3/8	7/16 ^{1/}	1/2	5/8	3/4 ^{1/}
	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
1/4	35	99														
1/2	39	105	170	246 ^{1/}	315	383										
3/4	41	105	172	248 ^{1/}	317	385	454	526								
1	43	107	174	250 ^{1/}	319	387	455	527	591 ^{1/}	651	713					
1-1/4	44	108	176	252 ^{1/}	321	389	457	529	592 ^{1/}	652	714					
1-1/2	45	109	178	254 ^{1/}	323	391	459	531	593 ^{1/}	653	715	779	863 ^{1/}			
1-3/4	46	110	180	256 ^{1/}	325	393	461	533	594 ^{1/}	654	716	780	864 ^{1/}			
2	47	111	181	257 ^{1/}	326	394	462	534	595 ^{1/}	655	717	781	865 ^{1/}	919		
2-1/4					327	395	463	535	596 ^{1/}	656	718	782	866 ^{1/}	920		
2-1/2	48	112	182	258 ^{1/}	328	396	464	536	597 ^{1/}	657	719	783	867 ^{1/}	921		
2-3/4							465	537								
3	49	113	183	259 ^{1/}	329	397	466	538	598 ^{1/}	658	720	784	869 ^{1/}	922	959	999 ^{1/}
3-1/2							467	539	599 ^{1/}	659	721	785	870 ^{1/}	923	960	990 ^{1/}
4							468	540	600 ^{1/}	660 ^{1/}	722	786	871 ^{1/}	924	961	991 ^{1/}
4-1/2 ^{1/}										661 ^{1/}	723 ^{1/}	787 ^{1/}	872 ^{1/}	925 ^{1/}	962 ^{1/}	992 ^{1/}
5										662	724	788	873 ^{1/}	926	963	993 ^{1/}
6										663	726	790	874 ^{1/}	927	964	994 ^{1/}

^{1/} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN.

TABLE III. DASH NUMBERS AND DIMENSIONS - STEEL, PHOSPHATE COATED

L LENGTH	NOMINAL DIAMETER															
	1/32	3/64	1/16	5/64 ^{1/}	3/32	1/8	5/32	3/16	7/32 ^{1/}	1/4	5/16	3/8	7/16 ^{1/}	1/2	5/8	3/4 ^{1/}
	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
1/2			814													
3/4			816			830										
1-1/4						834										

^{1/} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN.

P.A. Other Cont.	AR OS 99	INTERNATIONAL INTEREST	TITLE PIN, COTTER (SPLIT)	MILITARY STANDARD MS24665
PROCUREMENT SPECIFICATION ANSI B18.8.1		SUPERSEDES BFAX3, BFA33-1, BFA33.2, AN380, AND AN381		PAGE 3 OF 8

DD FORM 1 MAY 72 672-1 (COORDINATED)

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5315-0424

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FED. SUP. CLASS
 5315

TABLE IV. DASH NUMBERS AND DIMENSIONS - STEEL, CADMIUM PLATED

L LENGTH	NOMINAL DIAMETER															
	1/32	3/64	1/16	5/64 ^{1/}	3/32	1/8	5/32	3/16	7/32 ^{1/}	1/4	5/16	3/8	7/16 ^{1/}	1/2	5/8	3/4 ^{1/}
	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
1/4	1	65														
1/2	5	69	132	208 ^{1/}	281	349										
3/4	7	71	134	210 ^{1/}	283	351	418	490								
1	9	73	136	212 ^{1/}	285	353	419	491	561 ^{1/}	621	681					
1-1/4	10	74	138	214 ^{1/}	287	355	421	493	562 ^{1/}	622	682					
1-1/2	11	75	140	216 ^{1/}	289	357	423	495	563 ^{1/}	623	683	747				
1-3/4	12	76	142	218 ^{1/}	291	359	425	497	564 ^{1/}	624	684	748	840 ^{1/}			
2	13	77	143	219 ^{1/}	292	360	426	498	565 ^{1/}	625	685	749	841 ^{1/}	899		
2-1/4					293	361	427	499	566 ^{1/}	626	686	750	842 ^{1/}	900		
2-1/2	14	78	144	220 ^{1/}	294	362	428	500	567 ^{1/}	627	687	751	843 ^{1/}	901		
2-3/4							429	501								
3	15	79	145	221 ^{1/}	295	363	430	502	568 ^{1/}	628	688	752	845 ^{1/}	903	947	977 ^{1/}
3-1/2							431	503	569 ^{1/}	629	689	753	846 ^{1/}	904	948	978 ^{1/}
4							432	504	570 ^{1/}	630	690	754	847 ^{1/}	905	949	979 ^{1/}
4-1/2 ^{1/}										631 ^{1/}	691 ^{1/}	755 ^{1/}	848 ^{1/}	906 ^{1/}	950 ^{1/}	980 ^{1/}
5										632	692	756	849 ^{1/}	907	951	981 ^{1/}
6										633	694	758	850 ^{1/}	908	952	982 ^{1/}

^{1/} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN.

APPROVED 16 MAR 80 REVISED (F) FOR CHANGES SEE PAGES 1, 2, 3, 4, 5, 6, 7 AND 8

P.A. Other Chart	AR OS 99	INTERNATIONAL INTEREST	TITLE PIN,COTTER (SPLIT)	MILITARY STANDARD MS24665
PROCUREMENT SPECIFICATION ANSI B18.8.1		SUPERSEDES BFAX3, BFA3.1, BFA3.2, AN380, AND AN381		PAGE 4 OF 8

USER ACTIVITIES
 ARMY-AT, ME, MI
 NAVY-YD

REVIEWER ACTIVITIES
 ARMY-AV, ER
 AIRFORCE-11, 82
 NSA-NS
 DLA-IS

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5315

TABLE V. DASH NUMBERS AND DIMENSIONS - CORROSION RESISTANT STEEL

L LENGTH	NOMINAL DIAMETER															
	1/32	3/64	1/16	5/64 ^{1/}	3/32	1/8	5/32	3/16	7/32 ^{1/}	1/4	5/16	3/8	7/16 ^{1/}	1/2	5/8	3/4 ^{1/}
DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
1/4	18	82	1010													
5/16	1001		1011													
3/8	1002		1012													
7/16	1003		1013													
1/2	22	86	151	227 ^{1/}	298	366										
3/4	24	88	153	229 ^{1/}	300	368	436	508								
1	26	90	155	231 ^{1/}	302	370	437	509	576 ^{1/}	636	697					
1-1/4	27	91	157	233 ^{1/}	304	372	439	511	577 ^{1/}	637	698					
1-1/2	28	92	159	235 ^{1/}	306	374	441	513	578 ^{1/}	638	699	763	851 ^{1/}			
1-3/4	29	93	161	237 ^{1/}	308	376	443	515	579 ^{1/}	639	700	764	852 ^{1/}			
2	30	94	162	238 ^{1/}	309	377	444	516	580 ^{1/}	640	701	765	853 ^{1/}	909		
2-1/4					310	378	445	517	581 ^{1/}	641	702	766	854 ^{1/}	910		
2-1/2	31	95	163	239 ^{1/}	311	379	446	518	582 ^{1/}	642	703	767	855 ^{1/}	911		
2-3/4							447	519								
3	32	96	164	240 ^{1/}	312	380	448	520	583 ^{1/}	643	704	768	857 ^{1/}	913	953	983 ^{1/}
3-1/2							449	521	584 ^{1/}	644	705	769	858 ^{1/}	914	954	984 ^{1/}
4							450	522	585 ^{1/}	645	706	770	859 ^{1/}	915	955	985 ^{1/}
4-1/2 ^{1/}										646 ^{1/}	707 ^{1/}	771 ^{1/}	860 ^{1/}	916 ^{1/}	956 ^{1/}	986 ^{1/}
5										647	708	772	861 ^{1/}	917	957	987 ^{1/}
6										648	710	774	862 ^{1/}	918	958	988 ^{1/}

^{1/} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN

USER ACTIVITIES
 ARMY - AT, ME, MI
 NAVY - YD

REVIEWER ACTIVITIES
 ARMY - AV, ER
 AIR FORCE - I, I, 82
 NSA - NS
 DLA - IS

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P.A. Other Curt	AR OS 99	INTERNATIONAL INTEREST	TITLE PIN, COTTER (SPLIT)	MILITARY STANDARD MS24665
PROCUREMENT SPECIFICATION ANSI B18.8.1		SUPERSEDES BFAX3, BFA3.1, BFA3.2, AN380, AND AN381		PAGE 5 OF 8

USER ACTIVITIES
 ARMY-AT, ME, MI
 NAVY-YD

REVIEWER ACTIVITIES
 ARMY-AV, ER
 AIR FORCE-11, B2
 NSA-NS
 DIA-15

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FED. SUP. CLASS
5315

TABLE VI DASH NUMBERS AND DIMENSIONS - NICKEL-COPPER ALLOY

L LENGTH	NOMINAL DIAMETER															
	1/32	3/64	1/16	5/64 ^{1/}	3/32	1/8	5/32	3/16	7/32 ^{1/}	1/4	5/16	3/8	7/16 ^{1/}	1/2	5/8	3/4 ^{1/}
	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
1/2			189	265 ^{1/}	332	400										
3/4			191	267 ^{1/}	334	402	472	544								
1			193	269 ^{1/}	336	404	473	545	606 ^{1/}	666	729					
1-1/4			195	271 ^{1/}	338	406	475	547	607 ^{1/}	667	730					
1-1/2			197	273 ^{1/}	340	408	477	549	609 ^{1/}	668	731	795	875 ^{1/}			
1-3/4			199	275 ^{1/}	342	410	479	551	609 ^{1/}	669	732	796	876 ^{1/}			
2			200	276 ^{1/}	343	411	480	552	610 ^{1/}	670	733	797	877 ^{1/}	928		
2-1/2			201	277 ^{1/}	345	413	482	554	612 ^{1/}	672	735	799	879 ^{1/}	930		
3			202	278 ^{1/}	346	414	484	556	613 ^{1/}	673	736	800	881 ^{1/}	932	965	995 ^{1/}
4							486	558	615 ^{1/}	675	738	802	883 ^{1/}	934	967	996 ^{1/}
5										677	740	804	885 ^{1/}	936	969	997 ^{1/}
6										678	742	806	886 ^{1/}	937	970	998 ^{1/}

^{1/} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN.

APPROVED 16 MAR 60 REVISED (F) FOR CHANGES SEE PAGES 1, 2, 3, 4, 5, 6, 7 AND 8

P.A. AR	INTERNATIONAL INTEREST	TITLE PIN, COTTER (SPLIT)	MILITARY STANDARD
Other Cont OS 99			MS24665
PROCUREMENT SPECIFICATION ANSI B18.8.1	SUPERSEDES BFA33, BFA33.1, BFA33.2, AN380, AND AN381	PAGE 6	OF 8

USER ACTIVITIES
 ARMY-AT, ME, MI
 NAVY-YD

REVIEWER ACTIVITIES
 ARMY-AV, ER
 AIR FORCE-11, 82
 NSA-NS
 DLA-IS

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5310

TABLE VII. CANCELLATIONS

THE PINS COVERED BY THE FOLLOWING DASH NUMBERS LISTED IN MS24665, ROW. A ARE CANCELLED

CANCELLED	USE	CANCELLED	USE	CANCELLED	USE
MS24665 ROW. A	MS24665 ROW. E	MS24665 ROW. A	MS24665 ROW. E	MS24665 ROW. A	MS24665 ROW. E.
DASH NUMBER		DASH NUMBER		DASH NUMBER	
3	52/		1552/		3682/
20	222/	154	1552/		3682/
	242/		1572/	369	3702/
	242/		1592/	371	3722/
	262/		1612/	373	3742/
37	392/	168	1702/	375	3762/
67	692/	228	2292/	417	4182/
83	862/	230	2312/		4362/
84	862/	232	2332/		4362/
85	862/	234	2352/		4362/
87	882/	236	2372/	435	4362/
89	902/		2982/		4372/
101	1032/		2982/	438	4392/
130	1322/		3002/	440	4412/
148	1512/	299	3002/	442	4422/
149	1512/	301	3022/		5132/
150	1512/	303	3042/	514	5152/
	1532/	305	3062/	757	7582/
	1532/	307	3082/	773	7742/
152	1532/		3662/	789	7902/

2/ SUGGESTED REPLACEMENT, DASH NUMBER INDICATED IS NEXT LONGER LENGTH.

P.A. Other Cost	AR OS 99	INTERNATIONAL INTEREST	TITLE PIN, COTTER (SPLIT)	MILITARY STANDARD MS24665
PROCUREMENT SPECIFICATION ANSI B18.8.1		SUPERSEDES BFA33, BFA33.1, BFA33.2, AN380, AND AN381		PAGE 7 OF 8

FED. SUP CLASS
5315

TABLE VIII. INTERCHANGEABILITY

THE PINS COVERED BY THE FOLLOWING DASH NUMBERS LISTED IN AN380 AND AN381 ARE INACTIVE
 USE ONLY INTERCHANGEABLE PINS LISTED IN THIS TABLE.

IN- ACTIVE	USE	IN- ACTIVE	USE	IN- ACTIVE	USE	IN- ACTIVE	USE	IN- ACTIVE	USE
AN380	MS24665	AN380	MS24665	AN381	MS24665	AN381	MS24665	AN381	MS24665
DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER	
1-1	2/	5-7	425	2-5	2/	3-22	2/	6-28	515
1-2	5	5-8	426	2-6	2/	3-24	306	6-32	516
1-3	7	5-10	428	2-7	2/	3-26	2/	6-36	517
1-4	9	6-6	495	2-8	151	3-28	308	6-40	518
2-1	2/	6-8	498	2-10	2/	3-32	309	6-48	520
2-2	132	6-10	500	2-12	153	4-8	366	7-32	580
2-3	134	6-12	502	2-14	2/	4-12	368	7-36	581
2-4	136	8-8	625	2-16	155	4-14	2/	7-40	582
2-5	138	8-10	627	2-20	157	4-16	370	8-32	640
2-6	140	8-12	628	2-24	159	4-18	2/	8-36	641
2-7	142	8-14	629	2-28	161	4-20	372	8-40	642
2-8	143	8-16	630	2-32	162	4-22	2/	8-48	643
3-2	281	AN381		25-8	227	4-24	374	8-56	644
3-3	283			25-10	2/	4-26	2/	8-64	645
3-4	285			25-12	229	4-28	376	10-32	701
3-5	287	1-6	2/	25-14	2/	4-32	377	10-36	702
3-6	289	1-8	22	25-16	231	4-36	378	10-40	703
3-7	291	1-12	24	25-18	2/	5-8	2/		
3-8	292	1-16	26	25-20	233	5-12	436		
4-2	349	15-5	2/	25-22	2/	5-16	437		
4-3	351	15-6	2/	25-24	235	5-18	2/		
4-4	353	15-7	2/	25-26	2/	5-20	439		
4-5	355	15-8	86	25-28	237	5-22	2/		
4-6	357	15-10	2/	25-32	239	5-24	441		
4-7	359	15-12	88	3-8	298	5-26	2/		
4-8	360	15-14	2/	3-10	2/	5-28	443		
4-10	362	15-16	90	3-12	300	5-32	444		
5-2	2/	15-20	91	3-14	2/	5-36	445		
5-3	418	15-24	92	3-16	302	5-40	446		
5-4	419	15-28	93	3-18	2/	6-24	513		
5-5	421	15-32	94	3-20	304	6-26	2/		
5-6	423								

2/ NO REPLACEMENT

APPROVED 16 MAR 60 REVISED (F) FOR CHANGES SEE PAGES 1,2,3,4,5,6,7, AND 8

P.A. AR Other Cust OS 99	INTERNATIONAL INTEREST	TITLE PIN,COTTER (SPLIT)	MILITARY STANDARD MS24665
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