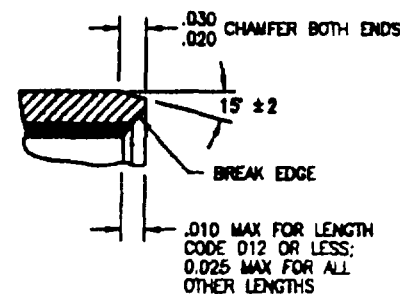
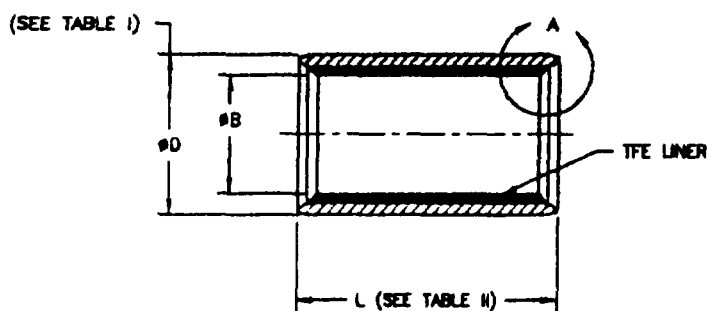


①

NOTE:
CONCENTRICITY TOLERANCE
BETWEEN #B AND #D DIA SHALL
NOT EXCEED .003 TIR



DETAIL A

① TABLE I. DIMENSIONS AND WEIGHTS

DASH NO.	NOMINAL SIZE	#B (BORE DIA) +.0000 -.0010	#D 1/	WEIGHT LB/IN (REF) L = 1.000	
				AL	CRES
-04	.2500	.2515	.3780	.008	.018
-05	.3125	.3140	.4388	.007	.019
-06	.3750	.3765	.5012	.008	.022
-07	.4375	.4390	.5838	.009	.025
-08	.5000	.5015	.6265	.011	.028
-09	.5625	.5640	.6892	.012	.031
-10	.6250	.6265	.8142	.021	.056
-11	.6875	.6890	.8767	.022	.060
-12	.7500	.7515	.9393	.024	.065
-14	.8750	.8765	1.0645	.028	.075
-16	1.0000	1.0015	1.1898	.031	.084
-18	1.1250	1.1265	1.3148	.035	.094
-20	1.2500	1.2515	1.4398	.038	.103
-22	1.3750	1.3765	1.5648	.041	.113
-24	1.5000	1.5015	1.7523	.062	.171
-26	1.6250	1.6265	1.8773	.067	.183
-28	1.7500	1.7515	2.0023	.071	.196
-32	2.0000	2.0015	2.2523	.081	.222

1/ #D TOLERANCE: ALUMINUM ±.0005; CORROSION RESISTANT STEEL +.0000, -.0005.

EXAMPLE OF WEIGHT CALCULATION:

M81934/1-18A008 SLEEVE WEIGHT = (0.031 LB/IN) x .250 INCH = 0.008 LB.

① DENOTES CHANGES

PREPARING ACTIVITY: NAVY - AS

CUSTODIANS: ARMY-AV NAVY-

AIR FORCE-99 DLA-
REVIEW: DLA-IS, AIR FORCE-84, NAVY-SH,
ARMY-AR, AT, MI

PROJECT NUMBER: 3120-0743-01

MILITARY SPECIFICATION SHEET

TITLE

BEARING, SLEEVE, PLAIN,
SELF-LUBRICATING, 325° F

SPECIFICATION SHEET NUMBER

MIL-B-81934/1 REV D 5 DEC 94

SUPERSEDING

MIL-B-81934/1 REV C 25 SEP 87

AMSC - N/A

FSC 3120

DISTRIBUTION STATEMENT A. APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED.

PAGE 1 OF 4

① TABLE II. SLEEVE BEARING LENGTH

DASH NO.	NOMINAL SIZE	LENGTH L $\begin{smallmatrix} +.000 \\ -.010 \end{smallmatrix}$														
		.156	.187	.218	.250	.281	.312	.343	.375	.437	.500	.562	.625	.687	.750	.875
-04	1/4	005	006	007	008	009	010	011	012	014						
-05	5/16	005	006	007	008	009	010	011	012	014	016	018				
-06	3/8	005	006	007	008	009	010	011	012	014	016	018	020	022		
-07	7/16	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-08	1/2	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-09	9/16	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-10	5/8	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-11	11/16				008	009	010	011	012	014	016	018	020	022	024	028
-12	3/4				008	009	010	011	012	014	016	018	020	022	024	028
-14	7/8				008	009	010	011	012	014	016	018	020	022	024	028
-16	1				008	009	010	011	012	014	016	018	020	022	024	028
-18	1 1/8						010	011	012	014	016	018	020	022	024	028
-20	1 1/4								012	014	016	018	020	022	024	028
-22	1 3/8								012	014	016	018	020	022	024	028
-24	1 1/2								012	014	016	018	020	022	024	028
-26	1 5/8										016	018	020	022	024	028
-28	1 3/4										016	018	020	022	024	028
-32	2										016	018	020	022	024	028

TABLE II. SLEEVE BEARING LENGTH (CONTINUED)

DASH NO.	NOMINAL SIZE	LENGTH L $\begin{smallmatrix} +.000 \\ -.010 \end{smallmatrix}$														
		1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000	2.125	2.250	2.375	2.500	2.750	3.000
-04	1/4															
-05	5/16															
-06	3/8															
-07	7/16															
-08	1/2															
-09	9/16	032	036													
-10	5/8	032	036	040	044											
-11	11/16	032	036	040	044	048	052									
-12	3/4	032	036	040	044	048	052									
-14	7/8	032	036	040	044	048	052									
-16	1	032	036	040	044	048	052	056	060							
-18	1 1/8	032	036	040	044	048	052	056	060							
-20	1 1/4	032	036	040	044	048	052	056	060	064	068					
-22	1 3/8	032	036	040	044	048	052	056	060	064	068					
-24	1 1/2	032	036	040	044	048	052	056	060	064	068	072	076	080	088	
-26	1 5/8	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096
-28	1 3/4	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096
-32	2	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096

PREPARING ACTIVITY: NAVY - AS
 CUSTODIANS: ARMY- AV NAVY-
 AIR FORCE-99 DLA-
 REVIEW: DLA-IS, AIR FORCE-84, NAVY-SH,
 ARMY-AR, AT, MI
 PROJECT NUMBER: 3120-0743-01

MILITARY SPECIFICATION SHEET

TITLE

BEARING, SLEEVE, PLAIN,
SELF-LUBRICATING, 325° F

SPECIFICATION SHEET NUMBER

MIL-B-81934/1

REV D
5 DEC 94

SUPERSEDING

MIL-B-81934/1 REV C 25 SEP 87

AMSC - N/A

FSC 3120

PAGE 2 OF 4

④ TABLE III. OVERSIZE BEARING DIMENSIONS 2/RESTRICTED USAGE FOR REPAIR WORK ONLY.010 AND .020 OVERSIZE OUTSIDE DIAMETER FOR
REPLACEMENT OF BEARINGS SHOWN ON SHEET 1

DASH NO.	NOMINAL SIZE	1st OVERSIZE (.010) ØD 1/
-04	.2500	.3860
-05	.3125	.4486
-06	.3750	.5112
-07	.4375	.5738
-08	.5000	.6365
-09	.5625	.6992
-10	.6250	.8242
-11	.6875	.8867
-12	.7500	.9483
-14	.8750	1.0745
-16	1.0000	1.1998
-18	1.1250	1.3248
-20	1.2500	1.4498
-22	1.3750	1.5748
-24	1.5000	1.7623
-26	1.6250	1.8873
-28	1.7500	2.0123
-32	2.0000	2.2823

DASH NO.	NOMINAL SIZE	2nd OVERSIZE (.010) ØD 1/
-04	.2500	.3860
-05	.3125	.4586
-06	.3750	.5212
-07	.4375	.5838
-08	.5000	.6465
-09	.5625	.7092
-10	.6250	.8342
-11	.6875	.8967
-12	.7500	.9593
-14	.8750	1.0845
-16	1.0000	1.2098
-18	1.1250	1.3348
-20	1.2500	1.4598
-22	1.3750	1.5848
-24	1.5000	1.7723
-26	1.6250	1.8973
-28	1.7500	2.0223
-32	2.0000	2.2723

1/ ØD TOLERANCE: ALUMINUM $\pm .0005$; CORROSION RESISTANT STEEL $+.0000, -.0005$.

2/ BEFORE INITIATING A REPAIR PROCEDURE TO USE AN OVERSIZE BEARING, APPROVAL FOR MODIFYING AND REDENTIFYING THE BEARING HOUSING MUST BE OBTAINED FROM THE COGNIZANT ENGINEERING AUTHORITY.

REQUIREMENTS:

1. MATERIAL: BEARING: " A " INDICATES ALUMINUM ALLOY QQ-A-200/3 OR QQ-A-225/6 (2024T851 OR 2024T8511).
NOTE: THE MANUFACTURER MAY SUBSTITUTE ALLOY 2024T351 OR 2024T3511 FOR 2024T851 OR 2024T8511, RESPECTIVELY, PROVIDED THE PROCESSING PROCEDURES EMPLOYED IN MANUFACTURING THE BEARING RESULT IN A CONVERSION OF ALLOY TO 2024T851 OR 2024T8511.
" C " INDICATES CORROSION RESISTANT STEEL, AMS-5643 (17-4PH) CONDITION H1150 PER MIL-H-6875.

LINER: SEE PROCUREMENT SPECIFICATION.

- ④ 2. SURFACE TEXTURE: SMOOTH MACHINE FINISH 83 MICRO-INCH R_a ON O.D., 125 MICRO-INCH R_a ON ALL OTHER METALLIC SURFACES PER ASME-B46.1. LINER SURFACES ARE EXEMPT FROM SURFACE TEXTURE MEASUREMENTS.
3. BREAK SHARP EDGES AND CORNERS AND REMOVE ALL BURRS AND SLIVERS.
4. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE; DECIMALS $\pm .010$ AND ANGLES $\pm 0.5^\circ$.
5. MARKING: FOR DASH NO 08 AND LARGER THE MILITARY PART NUMBER SHALL BE MARKED ON THE PART.
6. INTERCHANGEABILITY RELATIONSHIP: USE ONLY ASSIGNED PART NUMBERS FOR LENGTH AS LISTED IN LENGTH COLUMN OF TABLE II.
7. LOAD RATINGS: QUALIFICATION TEST DYNAMIC LOADS ARE BASED UPON THE FORMULA:
TEST LOAD (LBS) = 37,500 PSI x BORE DIAMETER x (L - .1).
8. USE OF THESE BEARINGS WILL USUALLY REQUIRE OPERATION AT A LOWER STRESS LEVEL IN ORDER TO OBTAIN THE DESIRED WEAR/LIFE CHARACTERISTICS FOR A SPECIFIC APPLICATION.
9. STATIC LIMIT LOAD: ALUMINUM = 50,000 B x (L - .1) LBS.
CORROSION RESISTANT STEEL = 78,500 x BORE DIAMETER x (L - .01) LBS.

PREPARING ACTIVITY: NAVY - AS
CUSTODIANS: ARMY - AV NAVY -
AIR FORCE - 99 DLA -
REVIEW: DLA-IS, AIR FORCE - B4, NAVY - SH,
ARMY - AR, AT, MI
PROJECT NUMBER: 3120-0743-01

MILITARY SPECIFICATION SHEET

TITLE
BEARING, SLEEVE, PLAIN,
SELF-LUBRICATING, 325' F

SPECIFICATION SHEET NUMBER
MIL-B-81934/1 REV D 5 DEC 94
SUPERSEDING
MIL-B-81934/1 REV C 25 SEP 87
AMSC - N/A FSC 3120

PAGE 3 OF 4

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: MIL-B-81934.

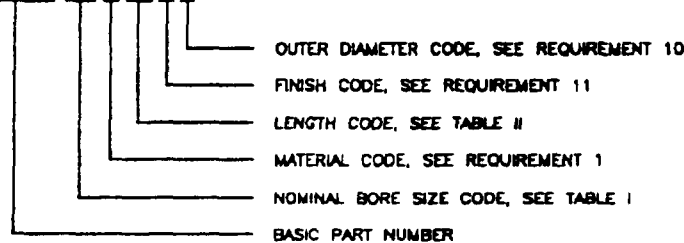
REQUIREMENTS: (CONTINUED)

- (D) 10. OUTER DIAMETER CODE: ABSENCE OF THE LETTER T AND U INDICATE STD OUTER DIA (O.D.), DIMENSION #D (SEE TABLE I).
 * T * INDICATES .010 OVERSIZE O.D., DIMENSION #D (FOR REPAIR ONLY, SEE TABLE II).
 * U * INDICATES .020 OVERSIZE O.D., DIMENSION #D (FOR REPAIR ONLY, SEE TABLE II).
- (D) 11. FINISH CODE: * P * INDICATES CORROSION RESISTANT STEEL SHALL BE ZINC-NICKEL PLATED PER AMS-2417, TYPE 2 OR CADMIUM PLATED PER QQ-P-418, TYPE II, CLASS 2 WITH A THICKNESS RANGE OF 0.0003 TO 0.0008 INCH. ABSENCE OF LETTER "P" INDICATES:
 ALUMINUM SLEEVE BEARINGS SHALL BE ANODIZED PER MIL-A-8625, TYPE I OR II;
 OR CHEMICAL FILM TREATMENT PER MIL-C-5841.
 CORROSION RESISTANT STEEL BEARINGS, O.D., SHALL BE PASSIVATED PER QQ-P-35 AND THE PROCUREMENT SPECIFICATION.
12. TEMPERATURE RANGE: -65° F TO 325° F.

NOTES:

- (D) 1. EXAMPLE OF PART NO.

M81934/1 -04 C 008 P I = .250 INCH NOMINAL SIZE, ZINC-NICKEL PLATED CRES BY .250 INCH LONG .010 INCH OVERSIZE O.D..



2. 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.
3. 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.

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

PREPARING ACTIVITY: NAVY - AS CUSTODIANS: ARMY-AV NAVY- AIR FORCE-89 DLA- REVIEW: DLA-IS, AIR FORCE-84, NAVY-SH, ARMY-AR, AT, MI PROJECT NUMBER: 3120-0743-01	MILITARY SPECIFICATION SHEET TITLE BEARING, SLEEVE, PLAIN, SELF-LUBRICATING, 325° F	SPECIFICATION SHEET NUMBER MIL-B-81934/1 REV D 5 DEC 94 SUPERSEDING MIL-B-81934/1 REV C 25 SEP 87 AMSC - N/A FSC 3120
		PAGE 4 OF 4