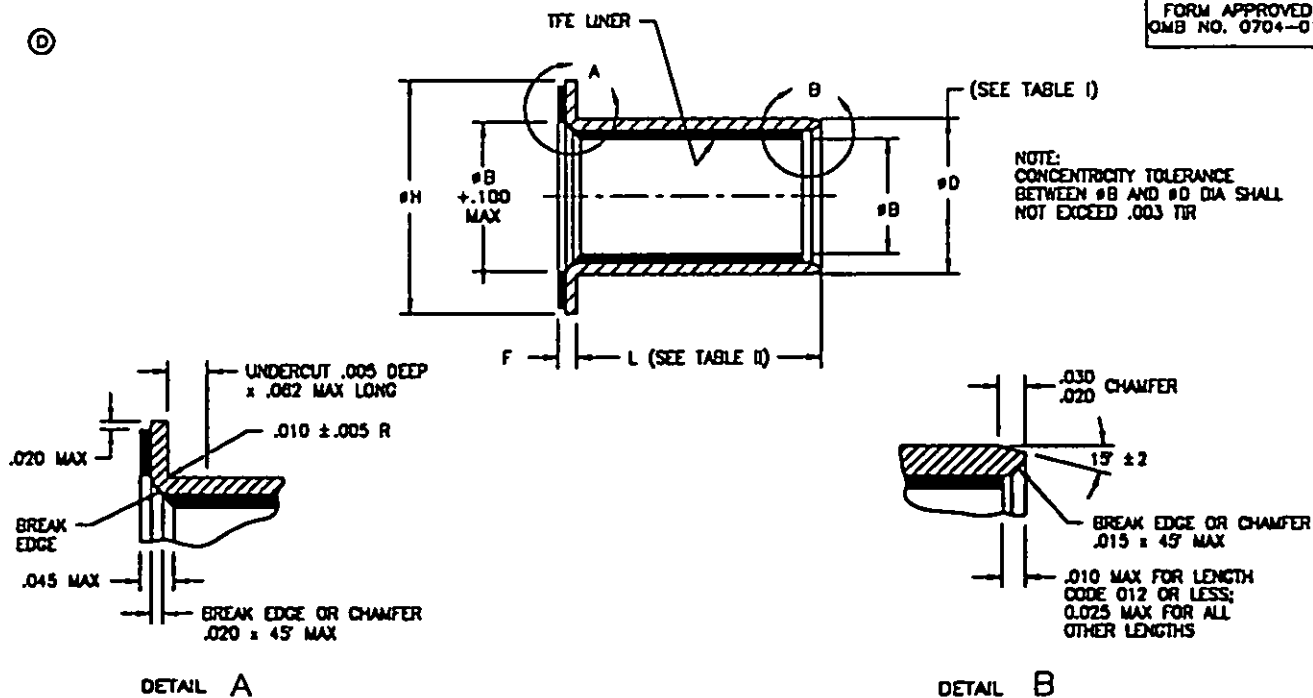


①



① TABLE 1. DIMENSIONS AND WEIGHTS

DASH NO.	NOMINAL SIZE (REF)	#B (BORE DIA) +.0000 -.0010	#D 1/	F +.000 -.005	#H +.000 -.020	SLEEVE WEIGHT LB/IN (REF) L = 1.000		FLANGE WEIGHT LB/IN (REF)	
						AL	CRES	AL	CRES
-04	.2500	.2515	.3780	.0825	.750	.008	.018	.002	.008
-05	.3125	.3140	.4388	.0825	.812	.007	.019	.003	.007
-06	.3750	.3765	.5012	.0825	.875	.008	.022	.003	.007
-07	.4375	.4390	.5638	.0825	.937	.009	.025	.003	.008
2/-07A					.745				
-08	.5000	.5015	.6285	.0825	1.000	.011	.028	.003	.009
-09	.5625	.5640	.6892	.0825	1.125	.012	.031	.004	.011
-10	.6250	.6265	.8142	.0825	1.250	.021	.056	.005	.014
-11	.6875	.6890	.8767	.0825	1.375	.022	.060	.006	.016
-12	.7500	.7515	.9393	.0825	1.500	.024	.065	.007	.020
-14	.8750	.8765	1.0845	.0825	1.625	.028	.075	.008	.022
-16	1.0000	1.0015	1.1898	.0825	1.750	.031	.084	.009	.024
-18	1.1250	1.1265	1.3148	.0937	1.875	.035	.094	.015	.041
-20	1.2500	1.2515	1.4398	.0937	2.000	.038	.103	.016	.045
-22	1.3750	1.3765	1.5648	.0937	2.125	.041	.113	.017	.048
-24	1.5000	1.5015	1.7523	.0937	2.250	.062	.171	.018	.051
-26	1.6250	1.6265	1.8773	.0937	2.375	.067	.183	.020	.055
-28	1.7500	1.7515	2.0023	.0937	2.500	.071	.196	.021	.058
-32	2.0000	2.0015	2.2523	.0937	2.750	.081	.222	.023	.065

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

EXAMPLE OF WEIGHT CALCULATION: M81934/2-16A008:

SLEEVE WEIGHT: $(0.031 \text{ LB/IN}) \times .250 \text{ INCH} = 0.008 \text{ LB}$ FLANGE WEIGHT: $= 0.009 \text{ LB}$ TOTAL WEIGHT: $= 0.017 \text{ LB}$

2/ INACTIVE FOR NEW DESIGN AFTER 1 AUGUST 1981. USE M81934/2-07.

① DENOTES CHANGE

PREPARING ACTIVITY: NAVY - AS
CUSTODIANS: ARMY-AV NAVY-
AIR FORCE-99
REVIEW: DLA-IS, NAVY-SH, AIR FORCE-84
ARMY-AR, AT, NI
PROJECT NUMBER: 3120-0743-02

MILITARY SPECIFICATION SHEET

TITLE

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

SPECIFICATION SHEET NUMBER

MIL-B-81934/2 REV D
5 DEC 94

SUPERSEDING

MIL-B-81934/2 REV C 4 JAN 88

AWSC - N/A

FSC 3120

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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	.582	.625	.687	.750	.875
-04	.2500	005	006	007	008	009	010	011	012	014						
-05	.3125	005	006	007	008	009	010	011	012	014	016	018				
-08	.3750	005	006	007	008	009	010	011	012	014	016	018	020	022		
-07	.4375	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-08	.5000	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-09	.5625	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-10	.6250	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
-11	.6875				008	009	010	011	012	014	016	018	020	022	024	028
-12	.7500				008	009	010	011	012	014	016	018	020	022	024	028
-14	.8750				008	009	010	011	012	014	016	018	020	022	024	028
-16	1.0000				008	009	010	011	012	014	016	018	020	022	024	028
-18	1.1250						010	011	012	014	016	018	020	022	024	028
-20	1.2500								012	014	016	018	020	022	024	028
-22	1.3750								012	014	016	018	020	022	024	028
-24	1.5000								012	014	016	018	020	022	024	028
-26	1.6250										016	018	020	022	024	028
-28	1.7500										016	018	020	022	024	028
-32	2.0000										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	.2500															
-05	.3125															
-08	.3750															
-07	.4375															
-08	.5000															
-09	.5625	032	036													
-10	.6250	032	036	040	044											
-11	.6875	032	036	040	044	048	052									
-12	.7500	032	036	040	044	048	052									
-14	.8750	032	036	040	044	048	052									
-16	1.0000	032	036	040	044	048	052	056	060							
-18	1.1250	032	036	040	044	048	052	056	060							
-20	1.2500	032	036	040	044	048	052	056	060	064	068					
-22	1.3750	032	036	040	044	048	052	056	060	064	068					
-24	1.5000	032	036	040	044	048	052	056	060	064	068	072	076	080	088	
-26	1.6250	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096
-28	1.7500	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096
-32	2.0000	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

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

PROJECT NUMBER: 3120-0743-02

MILITARY SPECIFICATION SHEET

TITLE

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

SPECIFICATION SHEET NUMBER

MIL-B-81934/2 REV D
5 DEC 94

SUPERSEDING

MIL-B-81934/2 REV C 4 JAN 88

AMSC - N/A

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① 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 I

DASH NO.	NOMINAL SIZE	1st OVERSIZE (.010) #D 1/
-04	.2500	.3880
-05	.3125	.4488
-06	.3750	.5112
-07	.4375	.5738
-08	.5000	.6385
-09	.5625	.6992
-10	.6250	.8242
-11	.6875	.8887
-12	.7500	.9493
-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	1.7823
-26	1.6250	1.8873
-28	1.7500	2.0123
-32	2.0000	2.2823

DASH NO.	NOMINAL SIZE	2nd OVERSIZE (.020) #D 1/
-04	.2500	.3980
-05	.3125	.4588
-06	.3750	.5212
-07	.4375	.5838
-08	.5000	.6485
-09	.5625	.7092
-10	.6250	.8342
-11	.6875	.8987
-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/ #D TOLERANCE: ALUMINUM $\pm .0005$; CORROSION RESISTANT STEEL $+.0000, -.0005$.

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

REQUIREMENTS:

1. MATERIAL: BEARING: "A" INDICATES ALUMINUM ALLOY 90-A-200/3 OR 90-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-5843 (17-4PH) CONDITION H1150 PER MIL-H-6875.

LINER: SEE PROCUREMENT SPECIFICATION.

2. SURFACE TEXTURE: SMOOTH MACHINE FINISH 63 MICRO-INCH R_a ON O.D.; 125 MICRO-INCH R_a ON ALL OTHER METALLIC SURFACES PER ASME-B46.1, UNLESS OTHERWISE SPECIFIED.
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 \times BORE DIAMETER \times (L + F - .13).
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 \times (L + F - .13) LBS.
CORROSION RESISTANT STEEL = 75,500 \times BORE DIAMETER \times (L + F - .13) LBS.

PREPARING ACTIVITY: NAVY - AS

CUSTODIANS: ARMY-AV

NAVY-

AIR FORCE-99

REVIEW: OLA-IS, NAVY-SH, AIR FORCE-84

ARMY-AR, AT, MI

PROJECT NUMBER: 3120-0743-02

MILITARY SPECIFICATION SHEET

TITLE

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

SPECIFICATION SHEET NUMBER

MIL-B-81934/2 REV D
5 DEC 94

SUPERSEDING

MIL-B-81934/2 REV C 4 JAN 88

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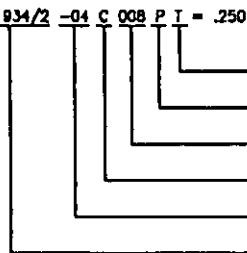
REQUIREMENTS: (CONTINUED)

- ① 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).
- ① 11. FINISH CODE: " P " INDICATES CORROSION RESISTANT STEEL SHALL BE ZINC-NICKEL PLATED PER AMS-2417, TYPE 2 OR CADMIUM PLATED PER QQ-P-416, 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-8825, TYPE I OR II;
 OR CHEMICAL FILM TREATMENT PER MIL-C-8541.
 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:

- ① 1. EXAMPLE OF PART NO.

M81934/2 -04 C 008 P T = .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.

PREPARING ACTIVITY: NAVY - AS
 CUSTODIANS: ARMY-AV NAVY-
 AIR FORCE-99
 REVIEW: DLA-IS, NAVY-SH, AIR FORCE-84
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MILITARY SPECIFICATION SHEET

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BEARING, SLEEVE, FLANGED,
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