

INCH-POUND

MIL-N-8985  
AMENDMENT 2  
23 NOVEMBER 1999

## MILITARY SPECIFICATION

NUT, SELF-LOCKING STEEL, 180 KSI  $F_{TU}$ , 450°F

This amendment forms a part of MIL-N-8985, dated 30 NOVEMBER 1976, and is approved for use by all Departments and Agencies of the Department of Defense.

## PAGE 1

Title: Delete and substitute the following:

"Nuts, Alloy Steel, Shear and Tensile, Self-Locking; (180 KSI  $F_{tu}$  450°F), General Specification For"

1. Scope Delete and substitute the following:

"1. Scope: This specification covers external wrenching tensile and shear nuts. The nuts shall be used in temperatures not greater than 450°F."

## PAGE 3

3.1 Delete and Substitute: "3.1 Qualification. The nut manufacturer shall be responsible for conducting qualification tests and furnishing part drawings, certified qualification test reports (if required by the purchaser) and test samples. The nuts furnished under this specification shall be produced using the same manufacturing methods as those used to produce nuts that have passed qualification tests. The purchaser may apply any or all tests specified herein to any product represented as meeting this specification, at any time, to verify conformance."

MIL-N-8985  
AMENDMENT 2

**PAGE 4**

3.1.1 Delete and Substitute: "3.1.1 Requalification. Requalification will be required in the event any change is made in the product design, construction, materials, method of manufacture, heat treatment, finish, lubricant, or manufacturer's part number or designation."

**Add the following paragraph:**

**"3.2.2 Specification Sheets. The individual item requirements shall be as specified herein and in accordance with the applicable specification sheet. In the event of any conflict between requirements of this specification and the specification sheet, the latter shall govern."**

3.3 Delete and Substitute: "3.3 Materials. The nuts shall be fabricated from alloy steel as specified on the nut standard and which have passed the qualification tests (see 6.3). "

**PAGE 5**

3.6 Delete the 2<sup>nd</sup> Sentence and Substitute: "The certified test report shall identify the lubricant coating and it shall not be changed without requalification of the nut."

**PAGE 9**

4.3.1 Delete and Substitute: "4.3.1 Qualification Samples. Test samples shall be of the same material and manufactured by the same method as production parts. The number of nuts to be subjected to qualification tests for each size shall be sufficient to perform the tests identified in Table V. A minimum of 50 nuts for each size are required. All bolts, screws, or mandrels required for testing shall be in accordance with this specification."

**PAGE 10**

4.3.3 Delete and Substitute: "4.3.3 Certified Test Report. The manufacturer shall maintain on file a certified test report showing that the manufacturer's product satisfactorily conforms to this specification. The test report shall include, as a minimum, actual results of the tests specified herein. A complete description and name of lubricating material used on the nuts shall be furnished. The manufacturer shall also maintain a dated drawing that completely describes the manufacturer's product. The drawing shall specify all dimensions and tolerances, material composition, coatings or platings applied, forming process, and heat treatment. The drawing shall also specify the manufacturer's part number for each size. Requalification will be required in the event any change is made in the product design, construction, materials, method of manufacture, heat treatment, finish, lubricant, or manufacturer's part number or designation."

MIL-N-8985  
AMENDMENT 2

**PAGE 23**

6.3 Delete and Substitute: "6.3 Qualification. Awards will be made only for products that meet the qualification requirements of this document at the time set for opening of bids. Nuts that have not been previously qualified via government-certified qualification tests and reports may be acquired, provided that certified qualification test reports for these nuts are retained on file by the manufacturer along with the quality conformance inspection data, and they are made available to the buyer upon request."

6.3.1 Delete entire paragraph.

Custodians:  
Army - AV  
Navy - AS  
Air Force - 99

Preparing Activity:  
DLA-IS  
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