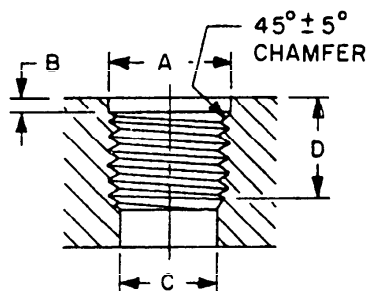


MIL-S-45933/3A
 22 September 1977
 SUPERSEDING
 MIL-S-45933/3
 30 June 1971

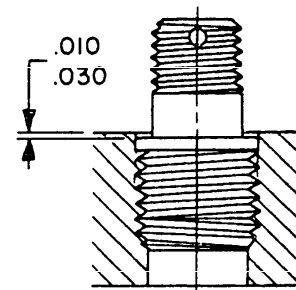
MILITARY SPECIFICATION SHEET

STUD, KEYRING LOCKED, HOLE DIMENSIONS FOR AND ASSEMBLY OF

This specification is approved for use by all Departments and Agencies of the Department of Defense.



HOLE PREPARATION



INSTALLATION

TABLE I

MIL-S-45933		TAP SIZE	A CBORE DIA +.010 -.000	B CBORE DEPTH +.015 -.000	C HOLE DIA		D FULL THREAD DEPTH MIN
/1 Dash No.	/2 Dash No.				MIN	MAX	
4	1	.1640-32UNJC	.169	.032	.1336	.1417	.237
	2	.1900-32UNJF	.195	.046	.1596	.1675	.297
	3	.2500-28UNJF	.255	.046	.2152	.2229	.304
		.2500-28UNJF	.255	.046	.2152	.2229	.366
5	4	.3125-24UNJF	.317	.046	.2719	.2799	.375
		.3125-24UNJF	.317	.046	.2719	.2799	.500
6	5	.3750-24UNJF	.380	.062	.3344	.3418	.500
		.3750-24UNJF	.380	.062	.3344	.3418	.562
7	6	.4375-20UNJF	.442	.078	.3888	.3970	.637
		.4375-20UNJF	.442	.078	.3888	.3970	.762
	7	.5625-18UNJF	.567	.078	.5084	.5166	.707
	8	.6250-18UNJF	.627	.078	.5709	.5788	.833
	9	.7500-16UNJF	.755	.093	.6892	.6977	.970
	10	.8750-14UNJF	.880	.093	.8055	.8152	.982
	11	1.0000-12UNJF	1.005	.109	.9189	.9298	1.125
	12	1.1250-12UNJF	1.130	.125	1.0439	1.0539	1.375
	14	1.3750-12UNJF	1.380	.140	1.2939	1.3039	1.500
	16	1.5000-12UNJF	1.505	.140	1.4189	1.4289	1.750

MIL-S-45933/3A

NOTES:

1. Prepare hole in accordance with Table I for corresponding dash numbers of MIL-S-45933/1 and /2.
2. Axis of hole shall be normal to entry surface or spotface shall be provided when required.
3. "A" diameter and thread PD shall be concentric within 0.005 TIR.
4. All dimensions are in inches, unless otherwise specified.
5. Surface roughness of machined surfaces shall be 125 microinches in accordance with ANSI B46.1.
6. Remove all burrs and sharp edges.
7. Install stud to depth shown.
8. Drive or press keyring flush with top of stud end.
9. Replacement of studs is made with the same size parts as those removed and in the same manner as originally installed.

Custodians:

Army - WC
Air Force - 99

Reviewer Activities:

Army - AV , EL
DSA - IS
NSA - NS

Preparing Activity:

Army - WC

Project No. 5307-0200

User Activities:

Navy - AS , OS

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL		OMB Approval No. 22-R255
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DOCUMENT IDENTIFIER AND TITLE Mil-S-45933/3A		
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	MATERIAL PROCURED UNDER A <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT	
1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? A. GIVE PARAGRAPH NUMBER AND WORDING. B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES		
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