

MIL-STD-1373
NOTICE 1
3 November 1971

MILITARY STANDARD

SCREW-THREAD, MODIFIED, 60°, STUB, DOUBLE

To all holders of MIL-STD-1373.

1. The following page(s) of MIL-STD-1373 have been revised and supersedes the page(s) listed:

<u>New Page</u>	<u>Date</u>	<u>Superseded Page</u>	<u>Date</u>
11	3 November 1971	11	8 April 1971
12	8 April 1971	(Reprinted without change)	

2. Retain this Notice and insert before the table of contents.

3. Holders of MIL-STD-1373 will verify that page change(s) and addition(s) indicated above have been entered. The Notice page will be retained as a check sheet. This issuance, together with appended page(s), is a separate publication. Each Notice is to be retained by stocking points until the Military Standard is completely revised or cancelled.

Custodians:

Army - EL
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Preparing activity:

Navy - EC
(Project MISC-0793)

Review activities:

Army - SC

User activities:

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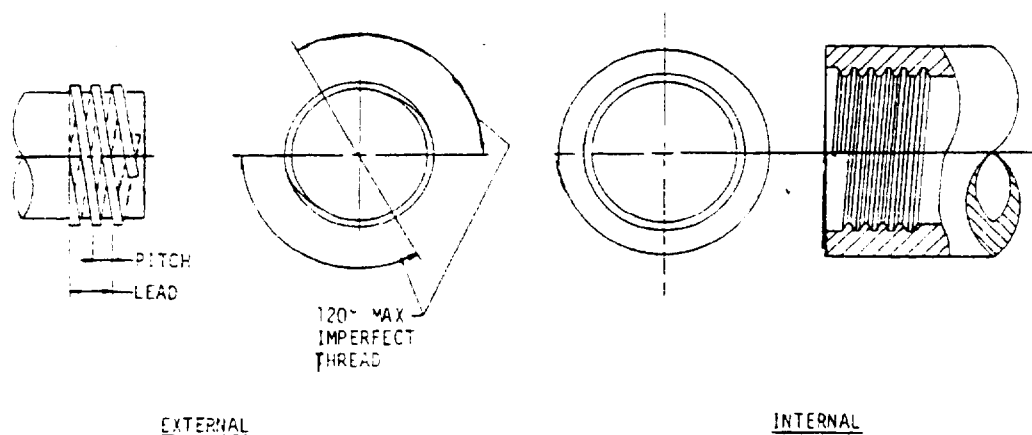
TABLE X.
Double 60° Stub Modified Thread Form Basic Dimensions, .1428 Pitch
(See figure 1)

Thread Size	Depth of Thread (Basic) h	Total Depth of Thread	Width of Flats							
			External Thread (Screw)				Internal Thread (Nut)			
			F _C (Major D.)		F _R (Minor D.)		F _C (Minor D.)		F _R (Major D.)	
			Basic	Max Min	Basic	Max Min	Basic	Max Min	Basic	Max Min
2.0000	.0619	.0647	.0357	.0425	.0324	.0382	.0443	.0512	.0324	.0394
2.2500				.0298		.0220		.0373		.0209
2.7500										
3.0000										
3.2500										

Note: Formulas for these values are given in table XI.

TABLE XI.
FORMULAS FOR CALCULATING WIDTH OF FLATS

External Thread (screw)		
F _C (Major Dia)	BASIC	$P/2 - [(Max\ Major\ D.\ Screw) - (Max\ P.\ D.\ screw)] \tan 30^\circ$
	MAX	$P/2 - [(Min\ Major\ D.\ Screw) - (Max\ P.\ D.\ screw)] \tan 30^\circ$
	MIN	$P/2 - [(Max\ Major\ D.\ screw) - (Min\ P.\ D.\ screw)] \tan 30^\circ$
F _R (Minor Dia)	BASIC	$P/2 - [(Max\ P.\ D.\ screw) - (Max\ Minor\ D.\ screw)] \tan 30^\circ$
	MAX	$P/2 - [(Min\ P.\ D.\ screw) - (Max\ Minor\ D.\ screw)] \tan 30^\circ$
	MIN	$P/2 - [(Max\ P.\ D.\ screw) - (Min\ Minor\ D.\ screw)] \tan 30^\circ$
Internal Thread (nut)		
F _C (Minor Dia)	BASIC	$P/2 - [(Min\ P.\ D.\ nut) - (Min\ Minor\ D.\ nut)] \tan 30^\circ$
	MAX	$P/2 - [(Min\ P.\ D.\ nut) - (Max\ Minor\ D.\ nut)] \tan 30^\circ$
	MIN	$P/2 - [(Max\ P.\ D.\ nut) - (Min\ Minor\ D.\ nut)] \tan 30^\circ$
F _R (Major Dia)	BASIC	$P/2 - [(Min\ Major\ D.\ nut) - (Min\ P.\ D.\ nut)] \tan 30^\circ$
	MAX	$P/2 - [(Min\ Major\ D.\ nut) - (Max\ P.\ D.\ nut)] \tan 30^\circ$
	MIN	$P/2 - [(Max\ Major\ D.\ nut) - (Min\ P.\ D.\ nut)] \tan 30^\circ$



PL 467

FIGURE 3. Thread start.

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Gage Measurements .05 Pitch

Size	Basic Helix Angle	Setting Plug (External Thread)								Plug Gage (Internal Thread)			
		Unplated				After Plating				Plug Gage (Internal Thread)			
		Pitch Diameter		Measurement Over (3) Wires .02887 Diameter		Pitch Diameter		Measurement Over (3) Wires .02887 Diameter		Pitch Diameter		Measurement Over (3) Wires .02887 Diameter	
		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
.2500	1°52'	.2245	.2305	.26826	.27422	.2245	.2320	.26826	.27572	.2320	.2400	.27572	.28369
.3750	3°07'	.3495	.3555	.39299	.39898	.3495	.3570	.39299	.40048	.3570	.3650	.40048	.40847
.5000	5°48'	.4745	.4805	.51791	.52391	.4745	.4820	.51791	.52540	.4820	.4900	.52540	.53340
.6250	7°21'	.5370	.5430	.58038	.58638	.5370	.5445	.58038	.58788	.5445	.5525	.58788	.59588
.7500	8°01'	.5995	.6055	.64287	.64887	.5995	.6070	.64287	.65037	.6070	.6150	.65037	.65837

Note: A helix angle correction has been added.

TABLE XIII.
Gage Measurements 0.1 Pitch

Size	Basic Helix Angle	Setting Plug (External Thread)								Plug Gage (Internal Thread)			
		Unplated				After Plating				Plug Gage (Internal Thread)			
		Pitch Diameter		Measurement Over (3) Wires .05774 Diameter		Pitch Diameter		Measurement Over (3) Wires .05774 Diameter		Pitch Diameter		Measurement Over (3) Wires .05774 Diameter	
		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
.6875	5°30'	.6520	.6600	.73903	.74702	.6520	.6615	.73903	.74852	.6615	.6715	.74852	.75851
.7500	5°02'	.7145	.7225	.80146	.80945	.7145	.7240	.80146	.81095	.7240	.7340	.81095	.82094
.8750	1°17'	.8395	.8475	.92637	.93436	.8395	.8490	.92637	.93586	.8490	.8590	.93586	.94586
1.0000	3°45'	.9645	.9725	1.05131	1.05931	.9645	.9740	1.05131	1.06080	.9740	.9840	1.06080	1.07080
1.1250	5°20'	1.0790	1.0890	1.16577	1.17573	1.0790	1.1030	1.16577	1.17776	1.0910	1.1030	1.17776	1.18976
1.2500	3°00'	1.2040	1.2140	1.29064	1.30074	1.2040	1.2160	1.29064	1.30274	1.2160	1.2280	1.30274	1.31477
1.3750	2°43'	1.3290	1.3390	1.41562	1.42562	1.3290	1.3410	1.41562	1.42762	1.3410	1.3530	1.42762	1.43962
1.5000	2°29'	1.4540	1.4640	1.54062	1.55062	1.4540	1.4660	1.54062	1.55262	1.4660	1.4780	1.55262	1.56462
1.7500	2°07'	1.7040	1.7140	1.79062	1.80062	1.7040	1.7160	1.79062	1.80262	1.7160	1.7280	1.80262	1.81462
2.0000	1°51'	1.9540	1.9640	2.04062	2.05062	1.9540	1.9660	2.04062	2.05262	1.9660	1.9780	2.05262	2.06462
2.2500	1°39'	2.2040	2.2140	2.29062	2.30062	2.2040	2.2160	2.29062	2.30262	2.2160	2.2280	2.30262	2.31462
2.5000	1°29'	2.4540	2.4640	2.54062	2.55062	2.4540	2.4660	2.54062	2.55262	2.4660	2.4780	2.55262	2.56462

Note: A helix angle correction has been added for wire dimensions above the dashed line.