MILITARY STANDARD

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

TO ALL HOLDERS OF MIL-STD-1373.

1.

New Page	Date	SUPERSEDED PAGE	Date
3	27 November 1972	3	8 April 1971
4	27 November 1972	4	8 April 1971
11	27 November 1972	11	3 November 1971
12	8 April 1971	(Reprinted without change)	
13	27 November 1972	13	8 April 1971
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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.

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Preparing activity:
Navy - EC
(Project MISC-0869)

FSC MISC

TABLE III. Class 2A
.1428 Pitch
Modified 60° Stub External Double Thread Series
Symbol DS-2A

Designation			Allowance	External Thread-Limits of Size								
				Major Diameter			Pitch Diameter			Minor Diameter		
Thread Size	Pitch	Lead		Limits		Tolerance	Limits		Tolerance	Limits		
				Max	Min		Max	Min		Max	Min	
2.0000	.1428	.2857	.0020	1.9980	1.9860	.0120	1.9360	1.9260	.0100	1.8685	1.8505
2.2500				2.2480	2.2360		2.1860	2.1760		2.1185	2.1005
2.7500				2.7480	2.7360		2.6860	2.6760		2.6185	2.6005
3.0000				2.9980	2.9860		2.9360	2.9260		2.8685	2.8505
3.2500				3.2480	3.2360		3.1860	3.1760		3.1185	3.1005
3.5000	↓	↓	↓	3.4980	3.4860	↓	3.4360	3.4260	↓	3.3685	3.3505

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

TABLE IV. Class 2B
.05 Pitch
Modified 60° Stub Internal Double Thread Series
Symbols DS-2B

Designation			Internal Thread-Limits of Size								
			Minor Diameter			Pitch Diameter			Major Diameter		
Thread Size	Pitch	Lead	Limits		Tolerance	Limits		Tolerance	Limits		
			Min	Max		Min	Max		Min	Max	
.2500	.05	.1	.2183	.2263	.0080	.2320	.2400	.0080	.2520	.3640
.3750			.3433	.3513		.3570	.3650		.3770	.3890
.5000			.4683	.4763		.4820	.4900		.5020	.5140
.5625			.5308	.5388		.5445	.5525		.5645	.5765
.6250	↓	↓	.5933	.6013	↓	.6070	.6150	↓	.6270	.6390

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

TABLE V. Class 2B
0.1 Pitch
Modified 60° Stub Internal Double Thread Series
Symbol DS-2B

Designation			Internal Thread-Limits of Size								
			Minor Diameter			Pitch Diameter			Major Diameter		
Thread Size	Pitch	Lead	Limits		Tolerance	Limits		Tolerance	Limits		
			Min	Max		Min	Max		Min	Max	
.6875	.1	.1	.6417	.6517	.0100	.6615	.6715	.0100	.6911	.7075
.7500			.7042	.7142		.7240	.7340		.7540	.7700
.8750			.8292	.8392		.8490	.8590		.8790	.8950
1.0000	↓	↓	.9542	.9642	↓	.9740	.9840	↓	1.0041	1.0200

TABLE V. Class 2B
0.1 Pitch
Modified 60° Stub Internal Double Thread Series
Symbol DS-2B (Continued)

Designation			Internal Thread-Limits of Size							
			Minor Diameter			Pitch Diameter			Major Diameter	
Thread Size	Pitch	Lead	Limits		Toler-ance	Limits		Toler-ance	Limits	
			Min	Max		Min	Max		Min	Max
1.1250	.1	.2	1.0650	1.0770	.0120	1.0910	1.1030	.0120	1.1290	1.1490
1.2500			1.1900	1.2020		1.2160	1.2280		1.2540	1.2740
1.3750			1.3150	1.3270		1.3410	1.3530		1.3790	1.3990
1.5000			1.4400	1.4520		1.4660	1.4780		1.5040	1.5240
1.7500			1.6900	1.7020		1.7160	1.7280		1.7540	1.7740
2.0000			1.9400	1.9520		1.9660	1.9780		2.0040	2.0240
2.2500			2.1900	2.2020		2.2160	2.2280		2.2540	2.2740
2.5000			2.4400	2.4520		2.4660	2.4780		2.5040	2.5240
2.6250			2.5650	2.5770		2.5910	2.6030		2.6290	2.6490
2.7500			2.6900	2.7020		2.7160	2.7280		2.7540	2.7740
3.0000			2.9400	2.9520		2.9660	2.9780		3.0040	3.0240
3.2500	↓	↓	3.1900	3.2020	↓	3.2160	3.2280	↓	3.2540	3.2740

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

TABLE VI. Class 2B
.1428 Pitch
Modified 60° Stub Internal Double Thread Series
Symbol DS-2B

Designation			Internal Thread-Limits of Size							
			Minor Diameter			Pitch Diameter			Major Diameter	
Thread Size	Pitch	Lead	Limits		Toler-ance	Limits		Toler-ance	Limits	
			Min	Max		Min	Max		Min	Max
2.0000	.1428	.2857	1.8908	1.9028	.0120	1.9380	1.9500	.0120	2.0055	2.0255
2.2500			2.1408	2.1528		2.1880	2.2000		2.2555	2.2755
2.7500			2.6408	2.6528		2.6880	2.7000		2.7555	2.7755
3.0000			2.8908	2.9028		2.9380	2.9500		3.0055	3.0255
3.2500			3.1408	3.1528		3.1880	3.2000		3.2555	3.2755
3.5000	↓	↓	3.3908	3.4028	↓	3.4380	3.4500	↓	3.5055	3.5255

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

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 2.2500 2.7500 3.0000 3.2500 3.5000	.0619	.0647	.0357	.0425 .0298	.0324	.0382 .0220	.0443	.0512 .0373	.0324	.0394 .0209

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°
	MAX	= P/2 - [(Min Major D. Screw) - (Max P. D. screw)] tan 30°
	MIN	= P/2 - [(Max Major D. screw) - (Min P. D. screw)] tan 30°
F_R (Minor Dia)	BASIC	= P/2 - [(Max P. D. screw) - (Max Minor D. screw)] tan 30°
	MAX	= P/2 - [(Min P. D. screw) - (Max Minor D. screw)] tan 30°
	MIN	= P/2 - [(Max P. D. screw) - (Min Minor D. screw)] tan 30°

Internal Thread (nut)

F_C (Minor Dia)	BASIC	= P/2 - [(Min P. D. nut) - (Min Minor D. nut)] tan 30°
	MAX	= P/2 - [(Min P. D. nut) - (Max Minor D. nut)] tan 30°
	MIN	= P/2 - [(Max P. D. nut) - (Min Minor D. nut)] tan 30°
F_R (Minor Dia)	BASIC	= P/2 - [(Min Major D. nut) - (Min P. D. nut)] tan 30°
	MAX	= P/2 - [(Min Major D. nut) - (Max P. D. nut)] tan 30°
	MIN	= P/2 - [(Max Major D. nut) - (Min P. D. nut)] tan 30°

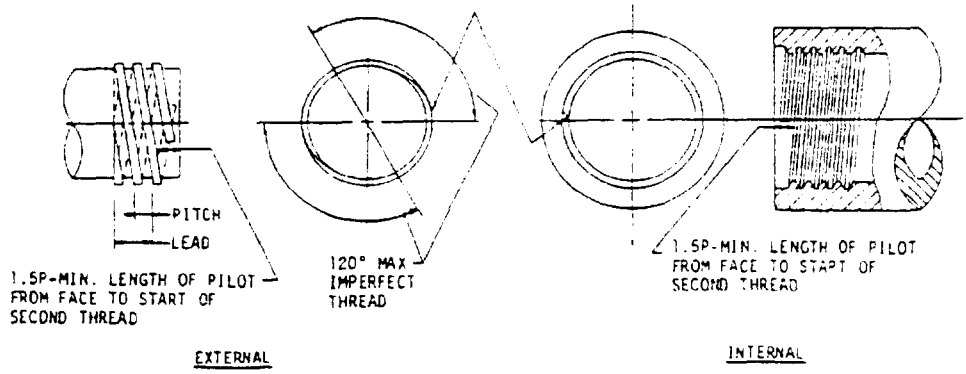

FIGURE 3. Thread start.

TABLE XII.
Gage Measurements .05 Pitch

Size	Basic Helix Angle	Setting Plug (External Thread)								Plug Gage (Internal Thread)			
		Unplated				After Plating							
		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	7°52'	.2245	.2305	.26826	.27422	.2245	.2320	.26826	.27572	.2320	.2400	.27572	.28369
.3750	5°07'	.3495	.3555	.39299	.39898	.3495	.3570	.39299	.40048	.3570	.3650	.40048	.40847
.5000	3°48'	.4745	.4805	.51791	.52391	.4745	.4820	.51791	.52540	.4820	.4900	.52540	.53340
.5625	3°21'	.5370	.5430	.58038	.58638	.5370	.5445	.58038	.58788	.5445	.5525	.58788	.59588
.6250	3°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							
		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	4°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	3°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.

TABLE XIII.
Gage Measurements 0.1 Pitch (Continued)

Size	Basic Helix Angle	Setting Plug (External Thread)								Plug Gage (Internal Thread)			
		Unplated				After Plating							
		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
2.6250	1°24'	2.5790	2.5890	2.66562	2.67562	2.5790	2.5910	2.66562	2.67762	2.5910	2.6030	2.67762	2.68962
2.7500	1°21'	2.7040	2.7140	2.79062	2.88062	2.7040	2.7160	2.79062	2.80262	2.7160	2.7280	2.80262	2.81462
3.0000	1°14'	2.9540	2.9640	3.04062	3.05062	2.9540	2.9660	3.04062	3.05262	2.9660	2.9780	3.05262	3.06462
3.2500	1°8'	3.2040	3.2140	3.29062	3.30062	3.2040	3.2160	3.29062	3.30262	3.2160	3.2280	3.30262	3.31462

TABLE XIV.
Gage Measurements .1428 Pitch

Size	Basic Helix Angle	Setting Plug (External Thread)								Plug Gage (Internal Thread)			
		Unplated				After Plating							
		Pitch Diameter		Measurement Over (3) Wires .08248 Diameter		Pitch Diameter		Measurement Over (3) Wires .08248 Diameter		Pitch Diameter		Measurement Over (3) Wires .08248 Diameter	
		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
2.0000	2°42'	1.9260	1.9360	2.04972	2.05972	1.9260	1.9380	2.04972	2.06172	1.9380	1.9500	2.06172	2.07372
2.2500	2°23'	2.1760	2.1860	2.29972	2.30972	2.1760	2.1880	2.29972	2.31172	2.1880	2.2000	2.31172	2.32372
2.7500	1°56'	2.6760	2.6860	2.79972	2.80972	2.6760	2.6880	2.79972	2.81172	2.6880	2.7000	2.81172	2.82372
3.0000	1°47'	2.9260	2.9360	3.04972	3.05972	2.9260	2.9380	3.04972	3.06172	2.9380	2.9500	3.06172	3.07372
3.2500	1°38'	3.1760	3.1860	3.29972	3.30972	3.1760	3.1880	3.29972	3.31172	3.1880	3.2000	3.31172	3.32372
3.5000	1°31'	3.4260	3.4360	3.54972	3.55972	3.4260	3.4380	3.54972	3.56172	3.4380	3.4500	3.56172	3.57372

Custodians:
Army - EL
Navy - EC

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Army - SC

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Preparing activity:
Navy - EC
(Project MISC-0722)