

MIL-STD-1373

8 April 1971

SUPERSEDING

MIL-S-23747B(SHIPS)

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



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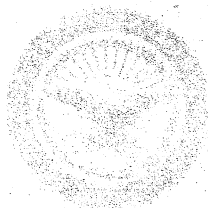
MIL-STD-1373

8 April 1971

DEPARTMENT OF DEFENSE
WASHINGTON, D.C. 20360

Screw-Thread, Modified,
60° Stub, Double
MIL-STD-1373

1. This standard is mandatory for use by all Departments and Agencies of the Department of Defense.
2. Recommended corrections, additions, or deletions should be addressed to Commander, Naval Electronic Systems Command, Department of the Navy, Washington, D.C. 20360.



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SCREW-THREAD, MODIFIED, 60° STUB, DOUBLE

1. SCOPE

1.1 This standard covers the requirements for the double stub, 60° modified screw-thread series, classes and sizes for quick disconnect use.

1.2 Classification. Screw-threads covered by this standard shall be of the following series and classes, as specified.

<u>Double Stub Thread Series</u>			
Class 2A	Symbols DS-2A	.05 pitch	Table I
		0.1 pitch	Table II
		.1428 pitch	Table III
Class 2B	Symbols DS-2B	.05 pitch	Table IV
		0.1 pitch	Table V
		.1428 pitch	Table VI

1.3 Designation

Class 2A	X.XXXX (size) - 0.05P-0.1L-DS-2A
	X.XXXX (size) - 0.1P-0.2L-DS-2A
	X.XXXX (size) - .1428P-.2857L-DS-2A
Class 2B	X.XXXX (size) - 0.05P-0.1L-DS-2B
	X.XXXX (size) - 0.1P-0.2L-DS-2B
	X.XXXX (size) - .1428P-.2857L-DS-2B

2. REFERENCED DOCUMENTS

2.1 The issue of the following documents in effect on date of invitation for bids forms a part of this standard to the extent specified herein.

GOVERNMENTAL

STANDARDS

MILITARY

MIL-STD-10 - Surface Roughness, Waviness and Lay

(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

NATIONAL BUREAU OF STANDARDS

Handbook H28 - Screw-Thread Standards for Federal Services.

(Application for copies should be addressed to the Superintendent of Documents, Government Printing Office, Washington, D.C. 20402)

NONGOVERNMENTAL

Commercial Standard AGD CS8-51 - Gage Blanks.

(Application for copies should be addressed to the Superintendent of Documents, Government Printing Office, Washington, D.C. 20402.)

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

Designation			Allow- ance	External Thread—Limits of Size							
Thread Size	Pitch	Lead		Major Diameter			Pitch Diameter			Minor Diameter	
				Limits		Toler- ance	Limits		Toler- ance	Limits	
				Max	Min		Max	Min		Max	Min
.2500	.05	.1	.0015	.2485	.2425	.0060	.2305	.2245	.0060	.2105	.2005
.3750	↓	↓	↓	.3735	.3675	↓	.3555	.3495	↓	.3355	.3255
.5000	↓	↓	↓	.4985	.4925	↓	.4805	.4745	↓	.4605	.4505
.5625	↓	↓	↓	.5610	.5550	↓	.5430	.5370	↓	.5230	.5130
.6250	↓	↓	↓	.6235	.6175	↓	.6055	.5995	↓	.5855	.5755

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

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

Designation			Allow- ance	External Thread—Limits of Size							
Thread Size	Pitch	Lead		Major Diameter			Pitch Diameter			Minor Diameter	
				Limits		Toler- ance	Limits		Toler- ance	Limits	
				Max	Min		Max	Min		Max	Min
.6875	.1	.2	.0015	.6860	.6780	.0080	.6600	.6520	.0080	.6300	.6160
.7500	↓	↓	↓	.7485	.7405	↓	.7225	.7145	↓	.6925	.6785
.8750	↓	↓	↓	.8735	.8655	↓	.8475	.8395	↓	.8175	.8035
1.0000	↓	↓	↓	.9985	.9905	↓	.9725	.9645	↓	.9425	.9285
1.1250	↓	↓	.0020	1.1230	1.1110	.0120	1.0890	1.0790	.0100	1.0510	1.0330
1.2500	↓	↓	↓	1.2480	1.2360	↓	1.2140	1.2040	↓	1.1760	1.1580
1.3750	↓	↓	↓	1.3730	1.3610	↓	1.3390	1.3290	↓	1.3010	1.2830
1.5000	↓	↓	↓	1.4980	1.4860	↓	1.4640	1.4540	↓	1.4260	1.4080
1.7500	↓	↓	↓	1.7480	1.7360	↓	1.7140	1.7040	↓	1.6760	1.6580
2.0000	↓	↓	↓	1.9980	1.9860	↓	1.9640	1.9540	↓	1.9260	1.9080
2.2500	↓	↓	↓	2.2480	2.2360	↓	2.2140	2.2040	↓	2.1760	2.1580
2.5000	↓	↓	↓	2.4980	2.4860	↓	2.4640	2.4540	↓	2.4260	2.4080
2.6250	↓	↓	↓	2.6230	2.6110	↓	2.5890	2.5790	↓	2.5510	2.5330
2.7500	↓	↓	↓	2.7480	2.7360	↓	2.7140	2.7040	↓	2.6760	2.6580
3.0000	↓	↓	↓	2.9980	2.9860	↓	2.9640	2.9540	↓	2.9260	2.9080
3.2500	↓	↓	↓	3.2480	3.2360	↓	3.2140	3.2040	↓	3.1760	3.1580

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

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

Symbol DS-2A

Designation			Allow- ance	External Thread—Limits of Size							
Thread Size	Pitch	Lead		Major Diameter		Pitch Diameter			Minor Diameter		
				Limits		Toler- ance	Limits		Toler- ance	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

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							
Thread Size	Pitch	Lead	Minor Diameter			Pitch Diameter			Major Diameter	
			Limits		Toler- ance	Limits		Toler- ance	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							
Thread Size	Pitch	Lead	Minor Diameter			Pitch Diameter			Major Diameter	
			Limits		Toler- ance	Limits		Toler- ance	Limits	
			Min	Max		Min	Max		Min	Max
.6875	.1	.2	.6417	.6517	.0100	.6615	.6715	.0100	.6915	.7075
.7500	↓	↓	.7042	.7142	↓	.7240	.7340	↓	.7540	.7700
.8750	↓	↓	.8292	.8392	↓	.8490	.8590	↓	.8790	.8950
1.0000	↓	↓	.9542	.9642	↓	.9740	.9840	↓	1.0040	1.0200

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

Designation			Internal Thread—Limits of Size							
Thread Size	Pitch	Lead	Minor Diameter			Pitch Diameter			Major Diameter	
			Limits		Tolerance	Limits		Tolerance	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							
Thread Size	Pitch	Lead	Minor Diameter			Pitch Diameter			Major Diameter	
			Limits		Tolerance	Limits		Tolerance	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

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

TABLE VII. Thread Data

TABLE VII. Thread Data												
	Major Diameter					Pitch Diameter		Minor Diameter				
	Toler- ance Class	Dimension Dg				Width of Relief	Dimension Eg	Toler- ance	Dimension Kg	Toler- ance	Width of Relief	
		Full	Toler- ance	Truncated	Toler- ance							
<u>Truncated Setting Plugs</u>												
Go -2A	Y	max Ds	plus	min Ds	minus		max Es	minus			Rs max	
No Go -2A	X	max Ds	plus	min Es+2h/3	minus		min Es	plus			Rs max	
Go -3A	Y	max Ds	plus	min Ds	minus		max Es + A	minus			Rs max	
<u>Thread Ring Gages</u>												
Go -2A	Y					Rc max	max Es	minus	min Kn - A	minus		
No Go -2A	X					Ra max	min Es	plus	min Kn + .05h	plus		
Go -3A	Y					Rc max	max Es + A	minus	min Kn	minus		
<u>Thread Plug Gages</u>												
Go -2B	Y	min Dn	plus				min En	plus			Re max	
No Go -2B	X	min Dn - .05h	minus				max En	minus			Rn max	
Go-pre Plate	Y	min Dn + Ap	plus				min En + Ap	plus			Re max	

Symbols used in this table are as follows:

h = Basic depth of thread
 Dg = Major dia of gage
 Es = Pitch dia of screw
 Ds = Major dia of screw
 Eg = Pitch dia of gage
 A = Allowance of external thread
 Ap = Allowance for plating
 Kg = Minor dia of thread ring gage

Dn = Major dia of nut
 Kn = Minor dia of nut
 En = Pitch dia of nut
 Rs = Max width of flat of screw minor dia
 Rn = Max width of flat of nut minor dia
 Ra = Max width of flat of screw major dia
 Rc = Min width of flat of screw major dia
 Re = Min width of flat of nut minor dia

TABLE VII. Thread Data (Continued)

Tolerances for Gage Class	"x" Tolerance			"y" Tolerance		
	0.05P - 0.1L	0.1P - 0.2L	.1428P - .2857L	0.05P - 0.1L	0.1P - 0.2L	.1428P - .2857L
Tolerance in lead	±.0003	±.0003	±.0004	±.0003	±.0003	±.0004
Tolerance on half angle of thread	±15'	±10'	±05'	±20'	±10'	±05'
Tolerance on major or minor dia	.0005	.0006	.0007	.0005	.0006	.0007
Tolerance on pitch dia to and including 1 1/2 inch dia	.0003	.0003	.0004	From .0002 To .0005	.0002 .0006	.0002 .0007
Tolerance on pitch dia above 1 1/2 inch dia	.0004	.0004	.0005	From .0002 To .0007	.0002 .0008	.0002 .0009

FORMULAS FOR CALCULATING THREAD DATA

External Thread (screw)

Major Dia (Max) = Basic thread size - Allowance
 (Min) = Max major dia - Tolerance
 Pitch Dia (Max) = Max major dia - h
 (Min) = Max pitch dia - Tolerance
 Minor Dia (Max) = Max major dia - 2h - (0.02P x 2)
 (Min) = Max minor dia - Tolerance

Internal Thread (nut)

Minor Dia (Min) = Basic thread size - 1.7648h
 (Max) = Min minor dia + Tolerance
 Pitch Dia (Min) = Basic thread size - h
 (Max) = Min pitch dia + Tolerance
 Major Dia (Min) = Basic thread size + (0.02P x 2)
 (Max) = Min major dia + Tolerance

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3. DEFINITIONS

3.1 Definition and application. The double stub 60° modified thread covered by this standard is in agreement with Handbook H28, insofar as nominal size is concerned. This thread is recommended for electrical connectors and other devices requiring fast coupling action and strong, shallow thread.

4. GENERAL REQUIREMENTS

4.1 Not applicable.

5. DETAILED REQUIREMENTS

5.1 Form of thread. The double stub 60° modified screw-thread form, as shown in figures 1 and 2, shall be used for all screw-threads covered by this standard.

5.2 Basic thread data. The basic thread data for the double stub 60° modified screw-thread is given in tables VIII, IX and X.

5.3 Thread series. Series of threads are classified and distinguished from each other by (1) the number of threads per inch (pitch) applied to specific diameters and by (2) the relationship of lead to pitch, i.e., lead equal to, double, or triple the pitch.

5.4 Thread classes. Classes of threads are distinguished from each other by the amount of tolerance and allowance specified. Threads specified herein are for the Class 2 double stub 60° modified screw-thread. Figure 2 shows the thread engagement for this class. Class 2A applies to external threads. Class 2B applies to internal threads.

5.5 Thread start. The thread start shall be full width. Full thread depth shall be attained by an increase from root to crest through a maximum arc of 120° (see figure 3).

5.6 Surface roughness. When the requirements of design or application make control of the surface roughness of screw-threads absolutely necessary, the allowable roughness shall be specified in microinches RMS in accordance with MIL-STD-10.

5.7 Gages. All gages shall conform to tables XII, XIII and XIV and the gage tolerances shall conform to applicable requirements of the National Bureau of Standards Handbook H28. The gage design shall be in accordance with Commercial Standard CS8-51 for gage blanks.

5.7.1 Gages for plated threads. Unless otherwise specified, maximum gaging limits of Class 2A products which are plated may be increased by the amount of the product allowance.

5.7.2 Gage wear. Gages shall not be permitted to wear beyond such a point that the product being gaged will be outside the limits specified. Gages shall be reset or replaced when these limits are exceeded.

5.7.3 "No Go" gaging. No go ring or plug gages may engage the product not more than one half turn when the gage shall be restricted to encounter a snug fit for the remainder of the full thread of the product.

5.8 Workmanship. Workmanship shall be consistent with the tolerances specified therein. Threads shall have a smooth finish, free from flaws, abrupt terminations, and other defects which would make them unsuitable for the purpose intended. When the surface roughness is specified, the smoothness of the thread shall be within the limit or limits specified.

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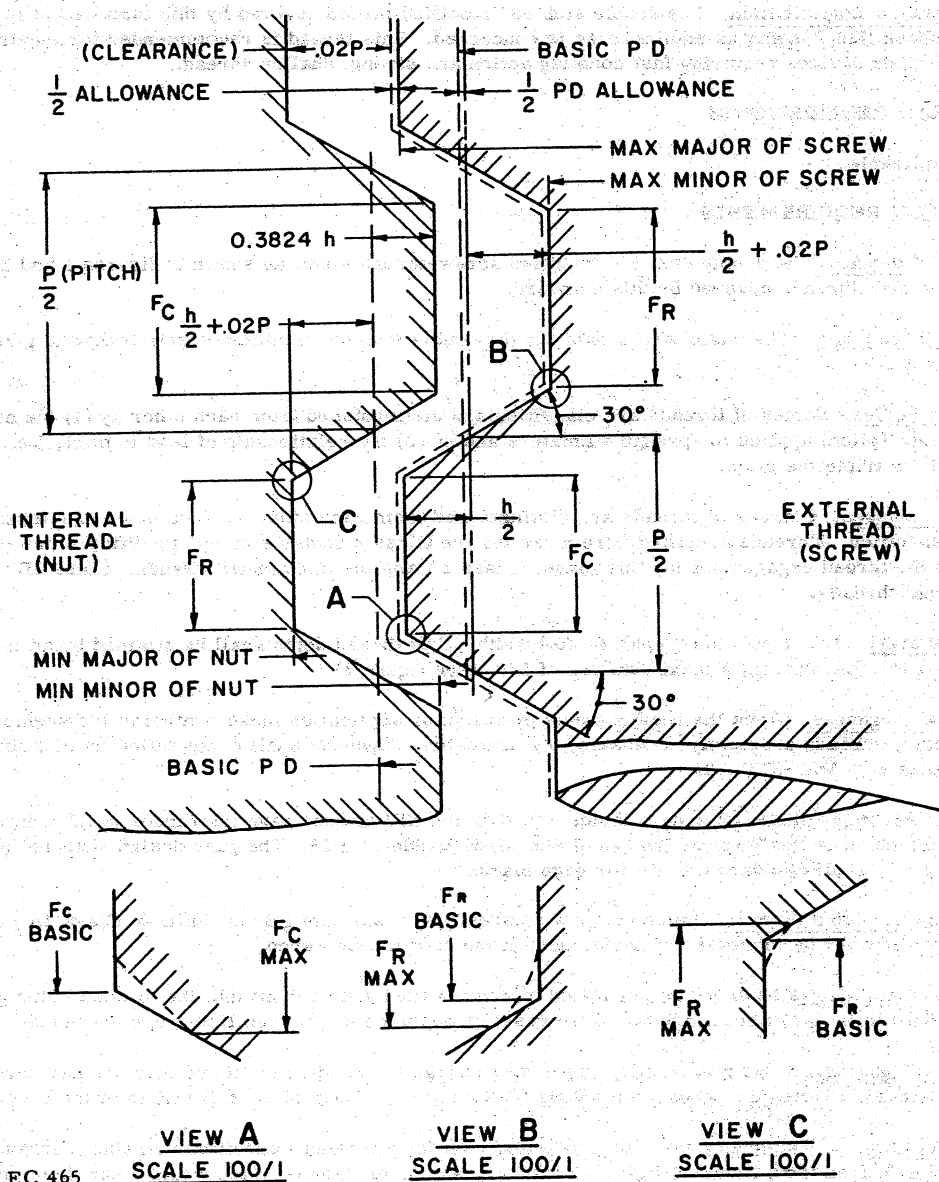
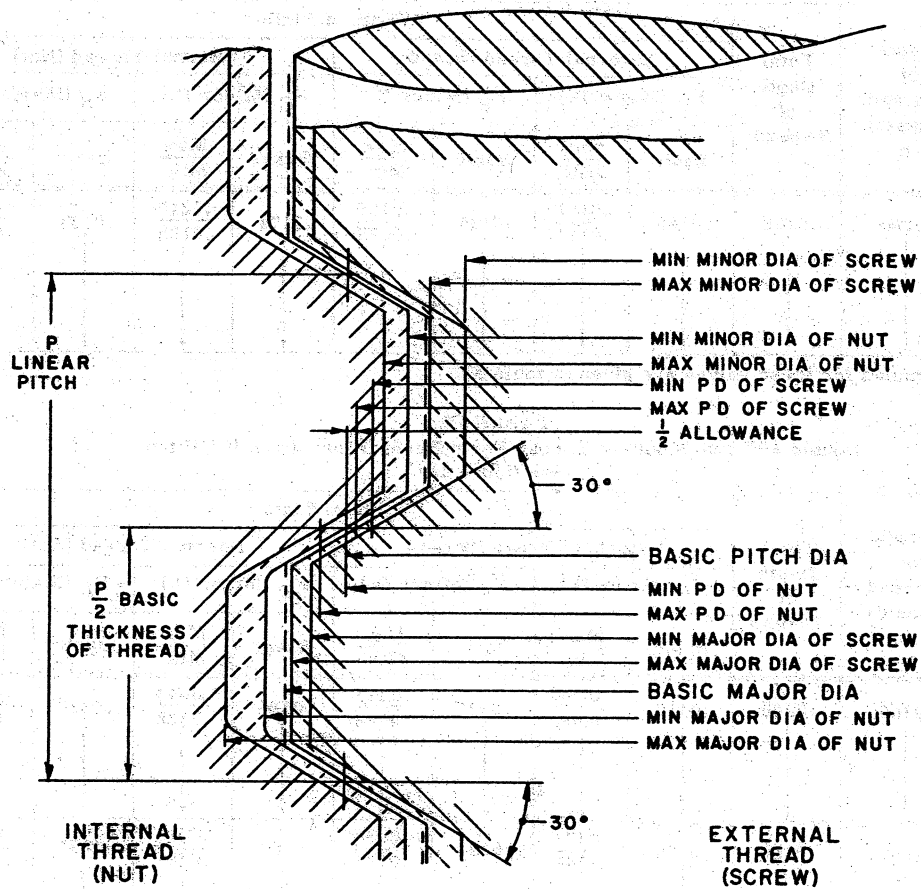


FIGURE 1. Basic dimensions - Class 2A and 2B threads. The dashed line indicates an allowance. Nut and screw threads have been separated for clarity.

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FIGURE 2. Thread engagement for Class 2A and 2B threads. Tolerances, allowances, and crest clearances for Classes 2A and 2B are shown. The dashed line indicates an allowance.

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TABLE VIII.
Double 60° Stub Modified Thread Form Basic Dimensions, .05 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
.2500	.0180	.0190	.0146	.0181 .0111	.0135	.0169 .0077	.0171	.0217 .0125	.0135	.0181 .0065
.3750										
.5000										
.5625										
.6250										

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

TABLE IX.
Double 60° Stub Modified Thread Form Basic Dimensions, 0.1 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
.6875	.0260	.0280	.0350	.0396 .0304	.0327	.0373 .0246	.0386	.0443 .0328	.0327	.0385 .0234
.7500										
.8750										
1.0000										
1.1250	.0340	.0360	.0304	.0373 .0246	.0281	.0338 .0177	.0350	.0419 .0281	.0281	.0350 .0165
1.2500										
1.3750										
1.5000										
1.7500										
2.0000										
2.2500										
2.5000										
2.6250										
2.7500										
3.0000										
3.2500										

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

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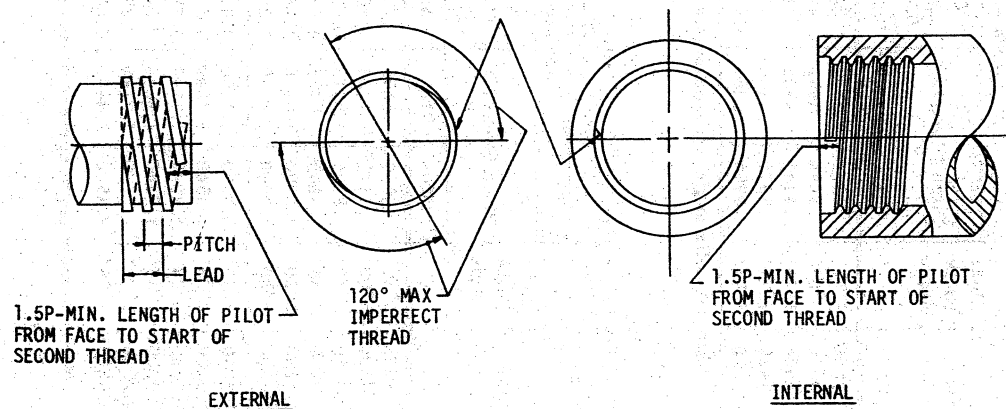
TABLE X.
Double 60° Stub Modified Thread Form Basic Dimensions, .1428 Pitch
(See figure 1)

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 .0298	.0324	.0382 .0220	.0443	.0512 .0373	.0324	.0394 .0209
2.2500										
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	$P/2 - [(Max \text{ Major D. Screw}) - (Max \text{ P. D. screw})] \tan 30^\circ$
	MAX	$P/2 - [(Min \text{ Major D. Screw}) - (Max \text{ P. D. screw})] \tan 30^\circ$
	MIN	$P/2 - [(Max \text{ Major D. screw}) - (Min \text{ P. D. screw})] \tan 30^\circ$
F _R (Minor Dia)	BASIC	$P/2 - [(Max \text{ P. D. screw}) - (Max \text{ Minor D. screw})] \tan 30^\circ$
	MAX	$P/2 - [(Min \text{ P. D. screw}) - (Max \text{ Minor D. screw})] \tan 30^\circ$
	MIN	$P/2 - [(Max \text{ P. D. screw}) - (Min \text{ Minor D. screw})] \tan 30^\circ$
Internal Thread (nut)		
F _C (Minor Dia)	BASIC	$P/2 - [(Min \text{ P. D. nut}) - (Min \text{ Minor D. nut})] \tan 30^\circ$
	MAX	$P/2 - [(Min \text{ P. D. nut}) - (Max \text{ Minor D. nut})] \tan 30^\circ$
	MIN	$P/2 - [(Max \text{ P. D. nut}) - (Min \text{ Minor D. nut})] \tan 30^\circ$
F _R (Major Dia)	BASIC	$P/2 - [(Min \text{ Major D. nut}) - (Min \text{ P. D. nut})] \tan 30^\circ$
	MAX	$P/2 - [(Min \text{ Major D. nut}) - (Max \text{ P. D. nut})] \tan 30^\circ$
	MIN	$P/2 - [(Max \text{ Major D. nut}) - (Min \text{ P. D. nut})] \tan 30^\circ$



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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)

Gage Measurements U.P. 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

Gage Measurements 1425 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	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

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