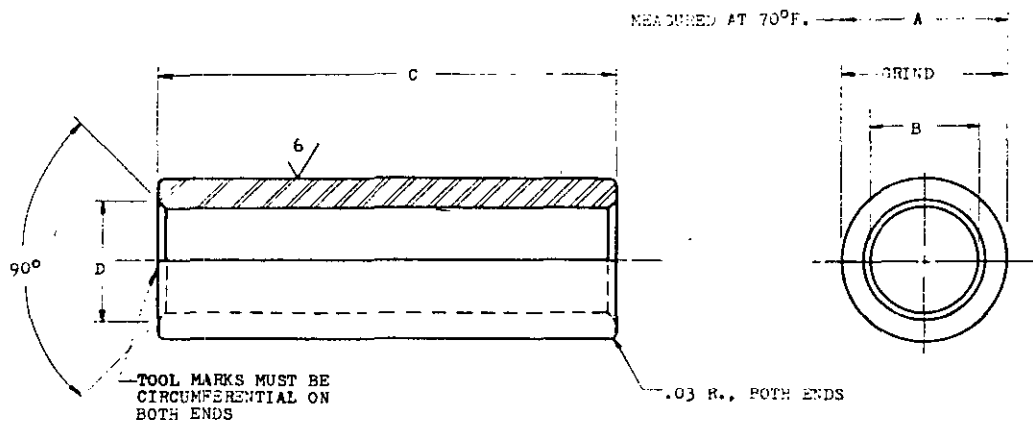


REVIEW ACTIVITY : DSCC, 69
USER ACTIVITY : YD.

This Military Standard has been approved by the Department of Defense and is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.



DASH
NUMBER

© CANCELED AFTER 24 JUNE 1982
NO SUPERSEDING STANDARD.

				.67
		.940	3.242	.80
		.810	3.257	
	1.1151	.815	3.257	.88
	1.2498	.868	3.620	
	1.2500	.882	3.625	.94
-7	1.3748	.995	4.120	
	1.3750	1.000	4.125	1.13
-7	1.4994	.995	4.433	
	1.4996	1.000	4.438	1.13
-9	1.7498	1.240	4.524	
	1.7500	1.260	4.539	1.375
-9	1.7498	1.243	4.995	
	1.7500	1.257	5.000	1.321
-10	.5433	NO	1.910	NO
	.5435	HOLE	1.925	HOLE
-11	.6400	.365	2.124	
	.6402	.385	2.139	.44

NOTES:

1. MATERIAL: STEEL, SAE 1015, 1019 and 1117
2. HEAT TREATMENT: CARBURIZE TO A FINISH DEPTH OF .025 to .040 ON O.D.
3. HARDEN AND TEMPER AT 325°F. MIN. FOR 1 HOUR MIN. TO A HARDNESS OF ROCKWELL "C" 58 TO 63.
4. CASE DEPTH ON I.D. .015 TO .040. CORE HARDNESS ROCKWELL "C" 20 TO 42.
5. PERMISSIBLE GRINDING AFTER HEAT TREATING: .009 MAX. PER SIDE.
6. PISTON PINS SHOULD BE MADE FROM FINE GRAIN AIR QUALITY HAR STEEL.
7. SMOOTH FINISH I.D.
8. MAX. ECCENTRICITY IS .020 T.I.R.
9. ENDS ARE SQUARE WITH O.D. WITHIN .003 T.I.R.
10. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
11. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
12. TOLERANCES: UNLESS OTHERWISE SPECIFIED, LINEAR MACHINED DIMENSIONS $\pm .010$; ANGULAR MACHINED DIMENSIONS $\pm 30'$. DO NOT SCALE DRAWING.
13. ALL DIMENSIONS IN INCHES.
14. THE "MS" PART NUMBER CONSISTS OF THE MS NUMBER, PLUS THE DASH NUMBER
EXAMPLE: MS 13996-1

© ENTIRE STANDARD REVISED

P.A. Other Cust	Army - MO(ERDL) A.F. - 69 NAVY - YD	TITLE PIN, PISTON: ENGINE	MILITARY STANDARD MS 13996
PROCUREMENT SPECIFICATION MIL-E-11775	SUPERSEDES.	SHEET 1	OF 1