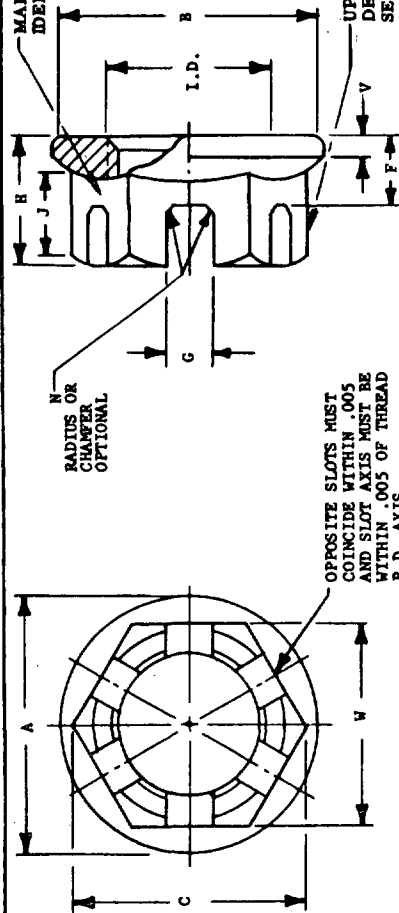


REVIEWER SYMBOLS:

USER SYMBOLS:

"Review/user information is current as of the date of this document.  
For future coordination of changes to this document, draft circulations  
should be based on the information in the current 900155."

This military standard is approved for use by all Departments  
B. Agencies of the Department of Defense. Selection for all new  
engineering and design applications and for replacing use shall  
be made from this document.

MARK MANUFACTURERS  
IDENTIFICATION

OPPOSITE SLOTS MUST  
COINCIDE WITHIN .005  
AND SLOT AXIS MUST BE  
WITHIN .005 OF THREAD  
P.D. AXIS.

UPPER PORTION OF NUT  
DEFORMED TO PRODUCE  
SELF-LOCKING ACTION

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.  
REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

P.A.  
NAVY - AS  
Other Cust

ARMY - AV

TITLE

NUT, SELF-LOCKING, LIGHTWEIGHT, THIN, CASTELLATED,  
450° FPROCUREMENT SPECIFICATION  
MIL-N-25027

SUPERSEDES:

MILITARY STANDARD

MS14145

SHEET 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 27065

APPROVED 7 DEC 73 REVISED

DASH NUMBER	THREAD	A MAX	B MIN	C MIN	I.D. MAX	F MAX	G MIN	H MIN	J MIN	N MAX	V REF	W MAX	ULTIMATE STRENGTH LB MIN	WEIGHT LB/100 MAX	COTTER PIN SIZE (REF)
3 L3	.1900-32UNJF-3B	.325	.291	.277	.220	.094	.065	.203	.173	.090	.035	.252	1,230	.16	3/64
4 L4	.2500-28UNJF-3B	.420	.386	.348	.280	.094	.100	.203	.173	.100	.035	.315	2,290	.25	1/16
5 L5	.3125-24UNJF-3B	.520	.482	.419	.342	.094	.100	.203	.173	.100	.035	.378	3,700	.36	1/16
6 L6	.3750-24UNJF-3B	.579	.539	.480	.405	.109	.155	.234	.204	.110	.053	.440	5,720	.49	3/32
7 L7	.4375-20UNJF-3B	.645	.600	.552	.467	.109	.155	.234	.204	.110	.053	.504	7,720	.60	3/32
8 L8	.5000-20UNJF-3B	.770	.725	.623	.530	.141	.155	.265	.235	.120	.053	.566	10,550	.95	3/32
9 L9	.5625-18UNJF-3B	.850	.815	.765	.592	.188	.186	.328	.298	.175	.062	.692	13,400	1.70	1/8
10 L10	.6250-18UNJF-3B	.910	.875	.836	.655	.188	.186	.328	.298	.175	.062	.755	17,060	1.90	1/8
12 L12	.7500-16UNJF-3B	1.130	1.095	.978	.785	.250	.186	.390	.360	.200	.062	.880	25,010	2.80	1/8
14 L14	.8750-14UNJF-3B	1.345	1.300	1.121	.910	.313	.186	.452	.422	.250	.062	1,006	34,220	5.30	1/8
16 L16	1.0000-12UNJF-3B	1.545	1.500	1.263	1.035	.375	.186	.515	.485	.300	.062	1,132	45,000	7.40	1/8
18 L18	1.1250-12UNJF-3B	1.745	1.700	1.41	1.160	.406	.186	.578	.548	.350	.062	1,257	58,350	11.00	1/8
20 L20	1.2500-12UNJF-3B	1.915	1.875	1.556	1.285	.469	.186	.640	.610	.375	.062	1,383	73,970	14.00	1/8

DD FORM 672-1

REPLACES DD FORM 672-1

FED. SUP CLASS  
3310**NOTES:**

1. MATERIAL: STEEL - SEE PROCUREMENT SPECIFICATION.
2. PLATING: STEEL NUTS (WITHOUT DRY FILM LUBRICANT) CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE II CLASS 2 DRY FILM LUBRICATED STEEL NUTS IN ACCORDANCE WITH QQ-P-416, TYPE AND CLASS OPTIONAL IF NUTS MEET THE SALT SPRAY REQUIREMENTS OF QQ-P-416, TYPE II.
3. SURFACE TEXTURE: IN ACCORDANCE WITH ANSI B46.1 SHALL NOT EXCEED 125 MICROINCHES.
4. DIMENSIONS IN INCHES.
5. LUBRICANT: LUBRICANT APPROVED IN ACCORDANCE WITH MIL-N-25027. LUBRICANTS, EXCEPT DRY FILM LUBRICANTS, SHALL BE SOLUBLE IN THE CLEANER SPECIFIED IN THE PROCUREMENT SPECIFICATION. FOR USAF APPLICATIONS NUTS TREATED WITH DRY FILM LUBRICANTS SHALL NOT BE UTILIZED IN INTEGRAL FUEL TANKS.
6. THREADS: IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.
7. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS AND SLIVERS.
8. PERFORMANCE: MIL-N-25027 EXCEPT LOCKING TORQUE VALUES APPLICABLE FOR 5 CYCLES.
9. DESIGN INFORMATION: THESE NUTS MAY BE USED AT TEMPERATURES 450°F AND BELOW IN THOSE TYPES OF APPLICATIONS FOR WHICH SLOTTED OR CASTELLATED NUTS ARE APPROVED FOR USE; AND IF SUCH APPLICATIONS CONFLICT WITH ANY LIMITATIONS ON THE USE OF SELF-LOCKING NUTS, AS CITED BY MS33588, THIS STANDARD TAKES PRECEDENCE. NUTS ARE TO BE INSTALLED IN ACCORDANCE WITH MS33540.

EXAMPLE OF PART NUMBER: MS14145 L4-.2500-28 NUT, CADMIUM PLATED, DRY FILM LUBRICATED.  
MS14145-4-.2500-28 NUT, CADMIUM PLATED, SOLUBLE LUBRICANT.

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& Agencies of the Department of Defense. Selection for all new  
engineering and design applications and for repetitive use shall  
be made from this document.

P.A. NAVY - AS Other Cust	TITLE	MILITARY STANDARD	
ARMY - AV	NUT, SELF-LOCKING, LIGHTWEIGHT, THIN, CASTELLATED, 450°F.	MS14145	
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES:	SHEET 2 OF 2	

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 23085

APPROVED 7 DEC 73 REVISED