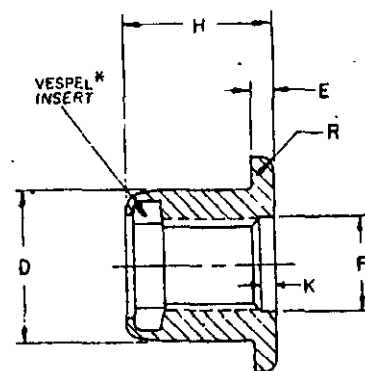
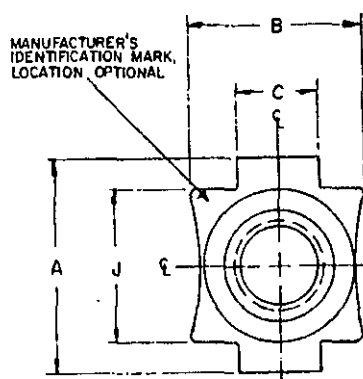


REVIEWER SYMBOLS: USAF-99 USER SYMBOLS:
ARMY-AR
DLA -25

FED. SUP CLASS
5310



SHAPE WITHIN
ENVELOPE OPTIONAL

PART NUMBER	THREAD SIZE	A ±.000 -.006	B ±.000 -.030	C ±.010	D MAX	E ±.010 MIN.	F MIN.	H (b) MAX	J ±.003 MAX	R MAX	AXIAL TENSILE STRENGTH LBS. MIN.	SEATING TORQUE IN LBS.	PUSH- OUT LBS. MIN.	TORQUE- OUT IN LBS. MIN.	WEIGHT LBS/100	"X" MIN.	K MIN.
MS14180-3	.1900-32UNJF-3B	.540	.400	.188	.570	.050	.194	.340	.370	.030	3,620	40	200	90	.60	.005	.038
MS14180-4	.2500-28UNJF-3B	.600	.470	.225	.440	.060	.254	.420	.437	.040	6,470	70	250	150	1.1	.006	.038
MS14180-5	.3125-24UNJF-3B	.678	.530	.250	.500	.070	.317	.490	.517	.050	10,200	140	250	240	1.6	.007	.028

(a) THREADS BEFORE LUBRICATION PER MIL-S-8879.

(b) MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS.

NOTES:

1. MATERIAL: CARBON STEEL PER AISI C1035, AISI C1042, AISI 1050, AISI C11137 OR ALLOY STEEL PER AMS 6322, AMS 6415, AMS 6304, EXCEPT INSERT; VESPEL* POLYIMIDE. *DUPONT REGISTERED TRADEMARK

2. HARDNESS: ROCKWELL "C" 46 MAXIMUM.

3. PLATING: CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 2.

4. LUBRICANT: DRY FILM LUBRICANT, (SUPPLEMENTARY LUBRICANT OPTIONAL).

5. PERFORMANCE: MIL-N-8985 EXCEPT AS FOLLOWS:

(a) SEVEN NUTS SHALL BE ASSEMBLED ON THE BOLTS. IMMERSE FIRST NUT AND BOLT ASSEMBLY IN MIL-H-5606 FLUID; SECOND NUT AND BOLT ASSEMBLY IN MIL-T-2624 FLUID; THIRD ASSEMBLY IN MIL-L-7808 FLUID; FOURTH ASSEMBLY IN MIL-A-8243 FLUID; FIFTH ASSEMBLY IN MIL-C-43616 FLUID; SIXTH ASSEMBLY IN MIL-H-83283 FLUID; SEVENTH ASSEMBLY IN SKYDROL 500B FLUID FOR 24 HOURS AT 160°F.

AFTER 12 HOURS DRYING IN AIR THE NUTS SHALL BE REMOVED AND REINSTALLED (SEATED) ON THE BOLTS TO THE SEATING TORQUE VALUES TABULATED ABOVE FOR 500 CYCLES. THE NUTS SHALL MEET MAX. LOCKING TORQUE AND MIN. BREAKAWAY TORQUES SPECIFIED IN MIL-N-8985 THRU 500 SEATED CYCLES.

(b) THREE SAMPLES SHALL BE BAKED AT 450°F FOR 6 HOURS THEN TESTED FOR 500 SEATED CYCLES AS ABOVE IN TORQUE EFFECTIVITY "a" EXCEPT FOR THIS TEST SAMPLES ARE NOT REQUIRED TO BE IMMERSED IN FLUIDS. THE NUTS SHALL MEET MAX. LOCKING TORQUE AND 50% OF THE MIN. BREAKAWAY TORQUES SPECIFIED IN MIL-N-8985 THRU 500 SEATED CYCLES.

(c) PUSH-OUT PER MIL-N-25027 EXCEPT THE PUSH-OUT LOAD VALUES AS TABULATED ABOVE WHEN THE NUT IS INSTALLED INTO A MS14179 BASKET.

(d) TORQUE-OUT PER MIL-N-25027 EXCEPT THE TORQUE-OUT VALUES AS TABULATED ABOVE WHEN THE NUT IS INSTALLED INTO A MS14179 BASKET.

(e) MIN. VIBRATION LIFE SHALL BE 90,000 CYCLES.

(f) WRENCH TORQUE NOT APPLICABLE.

(g) MIN. AXIAL TENSILE STRENGTH VALUES AS TABULATED ABOVE.

6. SURFACE TEXTURE IN ACCORDANCE WITH ANSI B46.1 SHALL NOT EXCEED 125 MICROINCHES.

7. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS AND SLIVERS.

8. DIMENSIONS IN INCHES.

9. TOLERANCES: DECIMALS ±.010, ANGLES ±5°.

10. NUT REPLACEABILITY: THIS IS A REPLACEMENT NUT THAT CAN BE SNAPPED IN PLACE INTO A MS14179 BASKET.

11. TRIM OF NUT IS OPTIONAL BUT MUST MEET NOTE 5 PERFORMANCE WHEN ASSEMBLED INTO MS14179 BASKET.

12. BEARING SURFACE AND P.D. OF THREAD SHALL RUN TRUE TO EACH OTHER WITHIN "X" WHEN MEASURED IN ACCORDANCE WITH MIL-N-8985.

13. THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENT REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

P.A.
NAVY - AS
Other Cust

USAF-II
ARMY-AV

PROCUREMENT SPECIFICATION
MIL-N-8985

TITLE

NUT REPLACEMENT FOR SELF-LOCKING PLATE,
FLOATING, TWO LUG, STEEL, (VESPEL* INSERT)
500 CYCLES REUSE
160 KSI F_{tu} , 450°F

SUPERSEDES

MILITARY STANDARD

MS14180

SHEET 1 OF 1

PLATE NO. 27

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

PROJECT NO. 5310-1008

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

This military standard is approved for use by all Departments
in Agencies of the Department of Defense Selection for all new
engineering and design specifications and for repetitive use shall
be made from this document