

USER SYMBOLS:

REVIEW SYMBOLS:
ARMY - MI, AV
NAVY - SH
AF - 99, 82
DLA - IS

THIS STANDARD APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

1. APPLICATION AND DESIGN SELECTION: THESE A.R.E. (ATTACHED RETENTION ELEMENT) NUT ELEMENTS SHALL BE SELECTED AND USED IN ACCORDANCE WITH MS33588.
2. MILITARY INSTALLATION AND TOOLS: NONE
3. GENERAL REQUIREMENTS:
 - 3.1 ASSEMBLED NUT ELEMENTS SHALL MEET THE TEST REQUIREMENTS OF MIL-N-25027.
 - 3.2 MATERIAL:
 - 3.2.1 NUT ELEMENT: STEEL AISI 1050 PER AMS 5085 OR AISI 4130 PER AMS 6351.
 - 3.3 HEAT TREAT:
 - 3.3.1 NUT ELEMENT: ROCKWELL C49 MAX.
 - 3.4 COATING:
 - 3.4.1 NUT ELEMENT SHALL BE CADMIUM PLATED PER QQ-P-416, TYPE AND CLASS OPTIONAL PROVIDED THE ELEMENT MEETS THE SALT SPRAY REQUIREMENTS OF MIL-N-25027.
 - 3.5 LUBRICANT:
 - 3.5.1 NUT ELEMENT SHALL BE DRY FILM LUBRICATED PER MIL-L-8937.
 - 3.6 SURFACE TEXTURE:
 - 3.6.1 SURFACE TEXTURE IN ACCORDANCE WITH ANSI B46.1. UNLESS OTHERWISE SPECIFIED, THE SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICRO INCHES.
 - 3.7 NUT REPLACEABILITY:
 - 3.7.1 THE NUT ELEMENT SHALL BE CAPABLE OF BEING SNAPPED INTO AND REMOVED FROM A.R.E. MS14200 AND MS14201 NUT ASSEMBLIES USING THE PROPER PROCEDURES AND TOOLING.
 - 3.8 WORKMANSHIP:
 - 3.8.1 BREAK ALL SHARP EDGES AND REMOVE ALL BURRS AND SLIVERS.
 - 3.8.2 DIMENSIONS ARE IN INCHES.
 - 3.8.3 TOLERANCES: DECIMALS ± 0.010 , ANGLES $\pm 5^\circ$ UNLESS OTHERWISE SPECIFIED.

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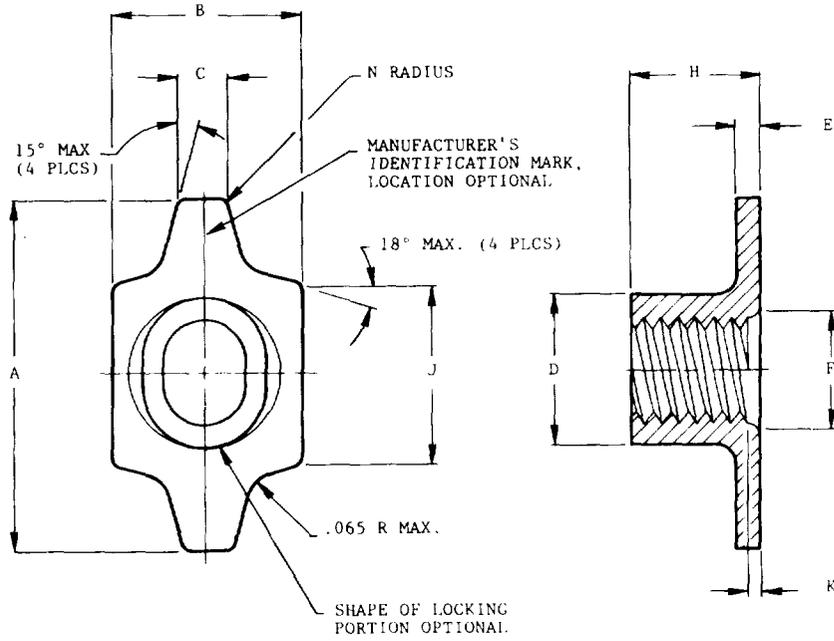
This military standard is approved for use by all Departments & Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 21 DEC 83 REVISED

P.A. NAVY - AS Other Cust ARMY - AR AF - 11	TITLE	MILITARY STANDARD
	NUT ELEMENT, ATTACHED RETENTION ELEMENT (A.R.E.), 450°F, STEEL (AISI 1050 OR 4130), 125 KSI Ft _u .	MS14214
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 3
MIL-N-25027		

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5. TABLE 1

SIZE DASH NO. (a)	SIZE MIL-S-8879	A $\pm .010$	B MAX.	C $\pm .010$	D MAX.	E $+ .010$ $- .000$	F MIN.	H MAX.	J $\pm .010$	K REF.	N MAX.	AXIAL STRENGTH LBS. MIN.
04	.1120-40 UNJC-3B	.420	.245	.070	.165	.025	.116	.151	.224	.015	.018	750
06	.1380-32 UNJC-3B	.420	.245	.070	.195	.025	.142	.151	.224	.015	.018	1130
08	.1640-32 UNJC-3B	.525	.350	.110	.225	.032	.168	.182	.295	.018	.040	1720
3	.1900-32 UNJF-3B	.525	.350	.110	.250	.032	.194	.182	.295	.018	.040	2460
4	.2500-28 UNJF-3B	.620	.435	.125	.325	.040	.254	.240	.367	.020	.040	4580

(a) NUT ELEMENT DASH NO. IS THE SAME AS ASSEMBLY DASH NO.

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TITLE
NUT ELEMENT, ATTACHED RETENTION ELEMENT (A.R.E.), 450°F, STEEL (AISI 1050 OR 4130), 125 KSI Ft_u.

MILITARY STANDARD
MS14214

PROCUREMENT SPECIFICATION
MIL-N-25027

SUPERSEDES:

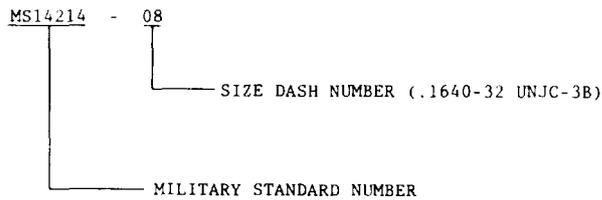
SHEET 2 OF 3

FED. SUP CLASS
5310

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6. PART NUMBER EXAMPLE:



7. ADMINISTRATIVE AND CONTRACTUAL PROVISIONS:

- 7.1 FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
- 7.2 REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
- 7.3 NUT ELEMENTS WITHOUT MANUFACTURER'S IDENTIFICATION MAY BE FURNISHED FROM MANUFACTURER'S STOCK UNTIL DECEMBER 31, 1985.

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		MS14214	
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES:	SHEET 3	OF 3