

FED. SUP CLASS

5310

USER SYMBOLS:

 REVIEWER 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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 engineering and design applications and for repetitive use shall
 be made from this document.

 REVISED
 21 DEC 83
 APPROVED

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

DD FORM 1 MAR 72 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

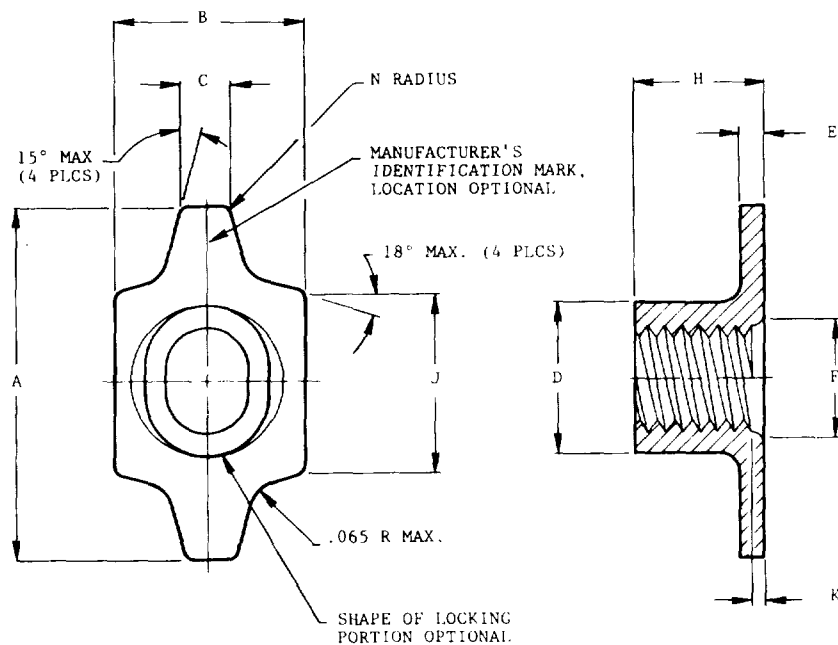
PROJECT NO. 5310-1198

PLATE NO. 23088

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5. TABLE 1

SIZE DASH NO. (a)	SIZE MIL-S-8879	A ±.010	B MAX.	C ±.010	D MAX.	E +.010 -.000	F MIN.	H MAX.	J ±.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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PROCUREMENT SPECIFICATION
MIL-N-25027

TITLE

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

SUPERSEDES:

MILITARY STANDARD

MS14214

SHEET 2 OF 3

DD FORM 1 MAR 78 672-1 (Coordinated)

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PLATE NO. 22000

APPROVED 21 DEC 83 REVISED

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6. PART NUMBER EXAMPLE:

MS14214 - 08

SIZE DASH NUMBER (.1640-32 UNJC-3B)

MILITARY STANDARD NUMBER

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.

APPROVED 21 DEC 83
 REVISED

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PROCUREMENT SPECIFICATION
 MIL-N-25027

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 STEEL (AISI 1050 OR 4130), 125 KSI Ft_u.

SUPERSEDES:

MILITARY STANDARD

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SHEET 3 OF 3

DD FORM 1 MAR 72 672-1 (Coordinated)

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PLATE NO. 23088