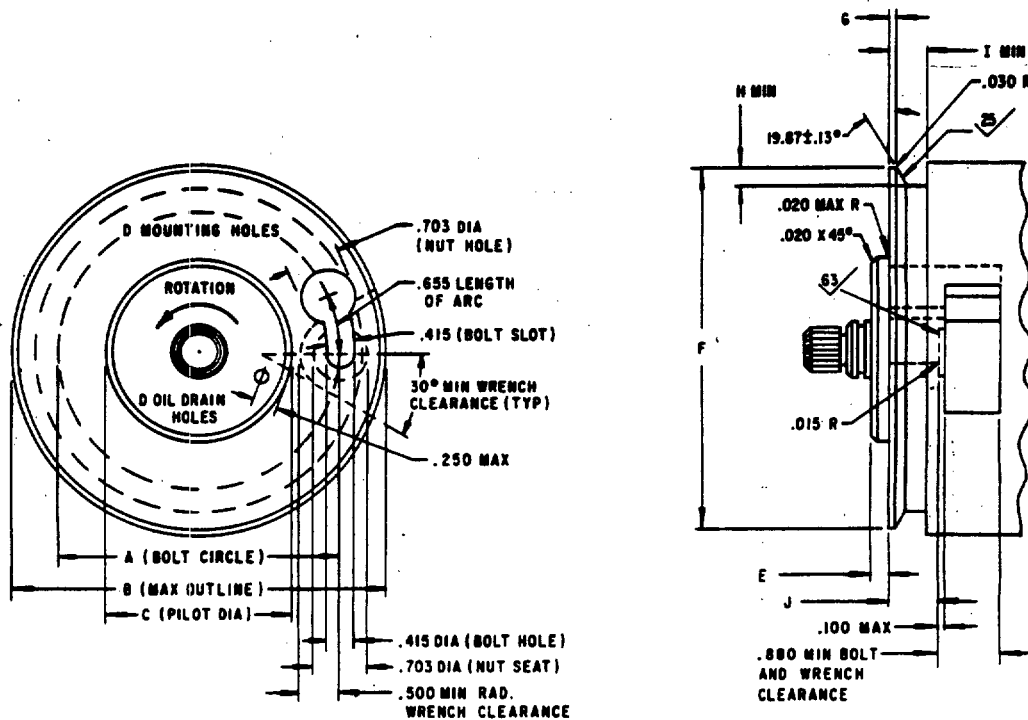


FED. SUP CLASS  
6150

(E)

NOMINAL SIZE	A	B	C	D	E	F	G	H	I	J	SUPERSEDES
3 INCH	5.000	6.000	4.122 4.120	6	.137	6.000 5.990	.130 .125	.100 .090	.320	.380 .360	AND10262
8 INCH	8.000	9.000	6.997 6.995	8	.178	9.000 8.990	.138 .133	.120 .110	.350	.380 .360	MS18055
10 INCH	10.000	11.000	8.996 8.992	12	.240	11.000 10.990	.145 .140	.140 .130	.380	.448 .408	AND10266

SEE SHEET 2 FOR SHAFT DETAILS AND SHEET 3 FOR NOTES

NOTE: INACTIVE FOR NEW DESIGNS

(E) DENOTES CHANGES

P.A. NAVY - AS OTHER CUST	TITLE <b>MOUNTING FLANGES FOR AIRCRAFT ELECTRIC EQUIPMENT, CIRCULAR, 5-, 8- AND 10- INCH</b>	<b>MILITARY STANDARD</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: AND10262, AND10266 AND MS18055 FOR NAVAIR USE ON ELECTRIC EQUIPMENT	<b>MS 18056 (AS)</b>
		SHEET 1 OF 3

This standard has been approved by the NAVAL AIR SYSTEM COMMAND Department of the NAVY, and is mandatory for use by their activity. All other military activities are required to employ this standard when suitable.

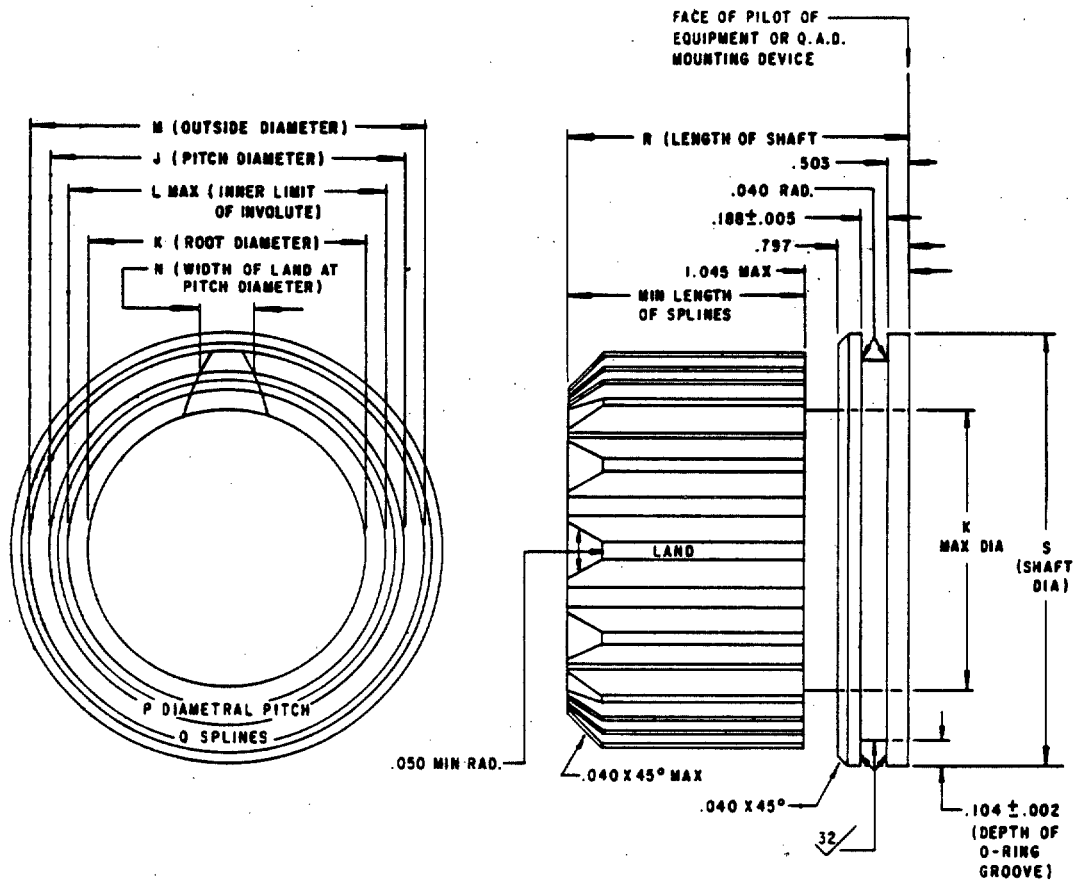
DD FORM 672-1N

LIMITED COORDINATION

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PROJECT NO. 6150-NI69

APPROVED 18 OCT 63 REVISED (A) 9 DEC 63 (B) 26 APR 65 (C) 4 AUG 65 (D) 24 MAR 69 (E) 3 MAR 80

FED SUP CLASS  
6150

SHAFT DETAILS

NOMINAL SIZE	J	K	L	M	N	P	Q	R	S	SUPERSEDES NOMINAL SIZE
3/4 INCH	.809	.713 .693	.727	.867 .862	.073 .070	20- 30	16	1.795 1.675	.981 .979	.800 INCH
1 INCH	1.200	1.100 1.080	1.127	1.267 1.262	.073 .070	20- 30	24	1.910 1.790	1.356 1.354	1.200 INCH
1 1/2 INCH	1.625	1.500 1.480	1.550	1.688 1.683	.092 .089	16- 32	26	2.215 2.095	1.793 1.791	1.625 INCH

SEE SHEET 3 FOR NOTES

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		SHEET 2 OF 3

DD FORM 672-1 N

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APPROVED 18 OCT 63 REVISED (E) FOR CHANGES SEE SHEET 1

FED SUP CLASS  
6150

## NOTES:

1. DIMENSIONS -  
ALL LINEAR DIMENSIONS ARE IN INCHES EXCEPT ROUGHNESSES, WHICH ARE IN MICROINCHES. ALL TOLERANCES UNLESS OTHERWISE SPECIFIED ARE: LINEAR  $\pm .010$ , ANGULAR  $\pm 5^\circ$ .
2. FINISH -  
ALL BURRS AND SHARP EDGES SHALL BE REMOVED.
3. MAXIMUM OUTLINE -  
THE MAXIMUM OUTLINE SHALL BE OBSERVED FOR AT LEAST .375 FROM THE FACE OF THE FLANGE.
4. MOUNTING HOLES -  
THE MOUNTING HOLES SHALL BE UNIFORMLY SPACED ALONG THE BOLT CIRCLE, AND EACH HOLE SHALL BE WITHIN .005 CIRCUMFERENTIALLY OF ITS NOMINAL POSITION AND WITHIN .005 RADIALLY OF THE CENTER OF THE PILOT DIAMETER.
5. NUT SEATS -  
THE NUT SEATS SHALL BE FLAT AND PARALLEL TO THE FACE OF THE FLANGE WITHIN .004 FULL INDICATOR READING.
6. QUICK ATTACH-DETACH (Q.A.-D.) MOUNTING DEVICES -  
EQUIPMENTS FOR USE WITH A Q.A.-D. MOUNTING DEVICE SHALL CONFORM TO THIS STANDARD WHEN THE FLANGE OF THE EQUIPMENT IS INSTALLED IN A Q.A.-D. MOUNTING DEVICE CONFORMING TO MS17520 FOR THE NOMINAL SIZE OF THE FLANGE. EQUIPMENTS FOR USE WITHOUT A Q.A.-D. MOUNTING DEVICE SHALL CONFORM TO THIS STANDARD WITHOUT ANY Q.A.-D. MOUNTING DEVICE.
7. SHAFT RETENTION -  
THE SHAFT SHALL BE RETAINED IN THE EQUIPMENT WHEN THE EQUIPMENT IS NOT MOUNTED.
8. SHAFT DISPLACEMENT -  
THE EQUIPMENT SHALL MEET ALL REQUIREMENTS OF ITS SPECIFICATION AND/OR STANDARD WHEN MOUNTED AND OPERATED WITH THE CENTER OF THE PITCH DIAMETER OF THE SHAFT ANYWHERE WITHIN .006 FULL INDICATOR READING LINEARLY, AND ANYWHERE WITHIN .001 INCH/INCH FULL INDICATOR READING ANGULARLY, IN ANY DIRECTION, FROM THE LINE PERPENDICULAR TO THE PLANE OF THE FACE OF THE FLANGE AND INCLUDING THE CENTER OF THE PILOT DIAMETER.
9. OIL DRAIN HOLES -  
THE OIL DRAIN HOLES SHALL BE UNIFORMLY SPACED AROUND THE FACE OF THE PILOT, AND SHALL BE CONNECTED TO DRAINS CAPABLE OF DISPOSING, WITHOUT DAMAGE TO THE EQUIPMENT, OF UP TO 3 CC PER HOUR OF OIL LEAKAGE FROM THE DRIVE SOURCE THROUGH ANY ONE OF THE HOLES (WHICHEVER IS LOWEST).
10. ORIENTATION -  
THE RELATIVE ORIENTATION OF THE MOUNTING HOLES AND THE OIL DRAIN HOLES IS MATERIAL.
11. SPLINES -  
SPLINES SHALL HAVE A  $30^\circ$  PRESSURE ANGLE, A MAXIMUM SURFACE HARDNESS OF 55 ROCKWELL C, AND A MINIMUM DEPTH OF EFFECTIVE CASE HARDENING OF .010. SPLINES SHALL HAVE INVOLUTE FORM OUTSIDE DIMENSION L. BETWEEN DIMENSIONS K AND L, SPLINES SHALL NOT EXCEED INVOLUTE FORM. PITCH DIAMETER AND O-RING GROOVE DIAMETER SHALL EACH BE CONCENTRIC WITH SHAFT DIAMETER WITHIN .002 FULL INDICATOR READING. WIDTH OF LAND SPECIFIED INCLUDES SPACING AND OTHER ERRORS.
12. SHEAR SECTION -  
THE SHAFT SHALL INCLUDE A SHEAR SECTION WHICH SHALL SHEAR AT THE TORQUE SPECIFIED BY THE SPECIFICATION AND/OR STANDARD FOR THE EQUIPMENT, AND THE EQUIPMENT AND SHAFT SHALL BE DESIGNED SO THAT IF THE SHEAR SECTION IS SHEARED, THE SHAFT MAY CONTINUE TO BE DRIVEN FOR ANY LENGTH OF TIME WITHOUT ANY DAMAGE TO THE DRIVE SOURCE OR EQUIPMENT.
13. SPECIFYING DATA -  
THE SPECIFICATION AND/OR STANDARD FOR THE EQUIPMENT ON WHICH THE FLANGE IS TO BE PROVIDED MUST SPECIFY THE FOLLOWING:
  - A. THE NOMINAL SIZE OF THE FLANGE.
  - B. THAT THE FLANGE SHALL HAVE KEYHOLE MOUNTING HOLES. (FUTURE REVISIONS OF THIS STANDARD MAY ALSO COVER FLANGES HAVING CIRCULAR MOUNTING HOLES.)
  - C. THE NOMINAL SIZE OF THE SHAFT.
  - D. THE MAXIMUM WEIGHT AND OVERHUNG MOMENT OF THE EQUIPMENT.
  - E. THE SPEED, OR RANGE OF SPEED, AT WHICH THE SHAFT SHALL BE DRIVEN FOR THE EQUIPMENT TO GIVE SPECIFIED PERFORMANCE.
  - F. THE MAXIMUM TORQUE WHICH THE EQUIPMENT SHALL REQUIRE (WHERE APPLICABLE, SHORT-TERM VALUES AS WELL AS CONTINUOUS VALUES SHOULD BE SPECIFIED).
  - G. THE TORQUE, INCLUDING A TOLERANCE, AT WHICH THE SHEAR SECTION OF THE SHAFT SHALL SHEAR.
  - H. WHETHER THE EQUIPMENT IS FOR USE WITH OR WITHOUT A Q.A.-D. MOUNTING DEVICE.

THE SPECIFICATION AND/OR STANDARD FOR THE EQUIPMENT SHOULD COVER TWO ITEMS, ONE FOR USE WITH, AND ONE FOR USE WITHOUT, A Q.A.-D. MOUNTING DEVICE, AND SHOULD ASSIGN DIFFERENT DESIGNATIONS TO THEM. IT SHOULD ALSO STATE THAT EACH ITEM SHALL BE MADE SO THAT IT CAN BE CHANGED TO THE OTHER ITEM BY CHANGING ONLY ONE PART, THE SHAFT, AND THAT THE MANUFACTURER'S MAINTENANCE HANDBOOK SHALL INCLUDE INSTRUCTIONS FOR CHANGING THE GOVERNMENT AND MANUFACTURER'S DESIGNATIONS ON THE EQUIPMENT WHEN THE SHAFT IS CHANGED TO ONE OF THE OTHER LENGTH.
14. SUPERSESSION -  
EACH NOMINAL SIZE OF FLANGE SUPERSEDES THE STANDARD LISTED ON SHEET FOR NAVAIR USE ON ELECTRIC EQUIPMENT.
15. KIND OF STANDARD -  
THIS IS A DESIGN STANDARD, AND IS NOT TO BE USED AS A PART NUMBER.

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		SHEET 3 OF 3

DD FORM 672-1 N

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\*U.S.

\*U.S. GOVERNMENT PRINTING OFFICE: 1981-505-022/8332

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