

This standard has been approved by the BUREAU OF NAVAL WEAPONS Department of the NAVY and is mandatory for use by that activity. All other military activities are required to employ this standard where suitable.

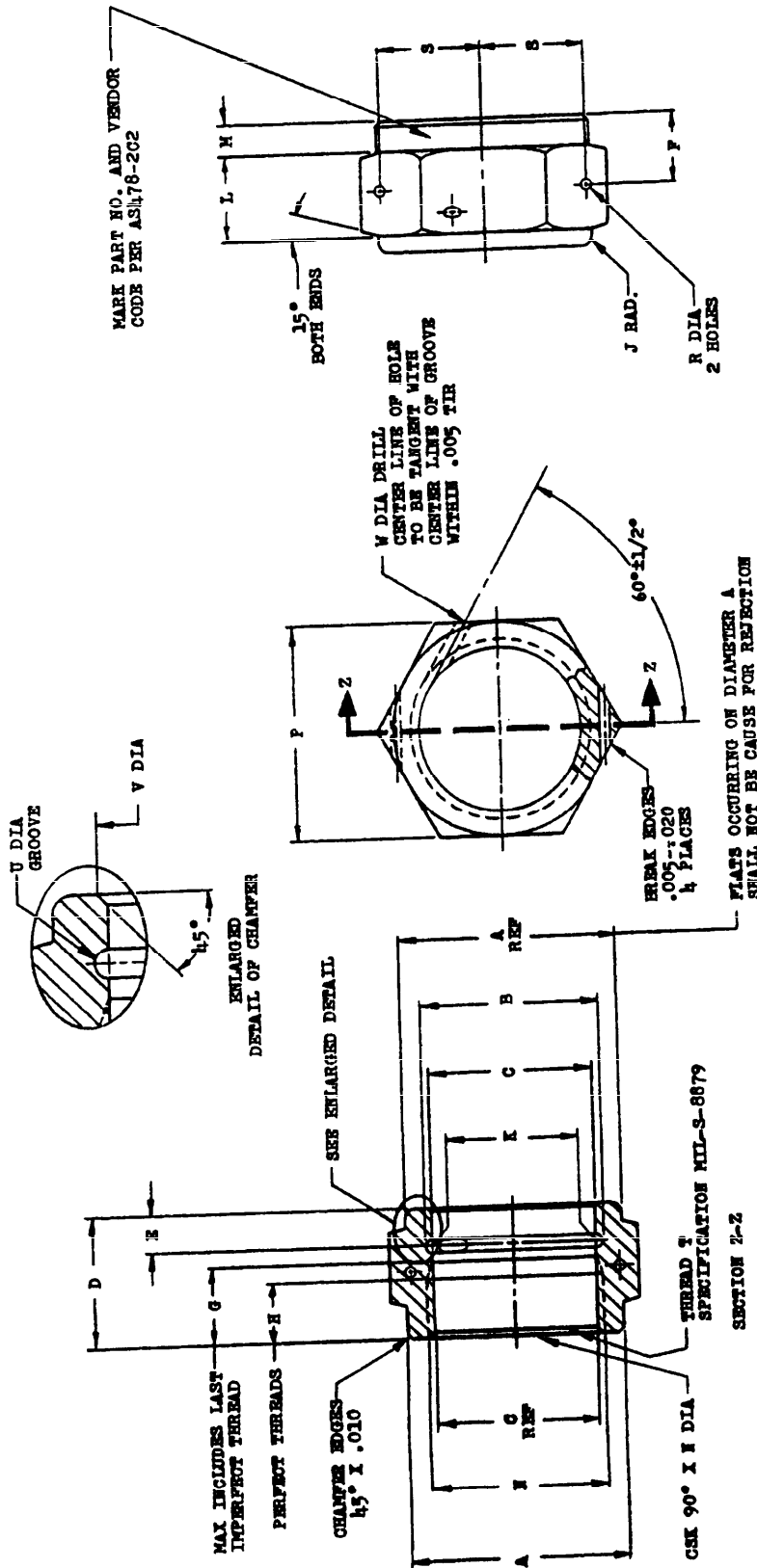
P.A.
Other Cast

PROCUREMENT SPECIFICATION

TITLE

NUT, WIRE RETAINED, SWIVEL
SAFETY WIRE HOLES, ROSE FITTING
AMS 5639 ORS STEEL

SUPERSEDES:



MILITARY STANDARD
MS18080 (WP)

SHEET 1 OF 2

NOTES:

1. ALL DIAMETERS MUST BE CONCENTRIC WITH EACH OTHER WITHIN .005 TIR.
2. BREAK SHARP EDGES .005-.015 AND REMOVE ALL BURRS.
3. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.010, ANGLES ±5°.
4. SURFACE ROUGHNESS: PER MIL-STD-10 NOT TO EXCEED 63 UNLESS OTHERWISE SPECIFIED.
5. MATERIAL: CORROSION RESISTANT STEEL AMS 5639.
6. PASSIVATION: A.) DECREASE. B.) IMMERSIVE FOR NOT LESS THAN 20 MINUTES IN A SOLUTION OF 1 VOLUME OF NITRIC ACID (SP GR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.

FED. SUP CLASS
4730

APPROVED 26 April 1965 REVISED

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PART NO.	A	B	C	D	E	F	G	H	J	K	L	M	N
MS18080-03	.500 .490	.404 .399	.3413 .3340	.594	.119	.375 ±.004	.407	.282	.031	.3275	.406	.141	.375
MS18080-04	.562 .552	.465 .460	.3972 .3890	.609	.114	.380 +-.005 -.000	.400	.300	.031	.3855	.406	.125	.438
MS18080-05	.625 .615	.524 .525	.4589 .4510	.671	.165	.382	.431	.331	.031	.4485	.484	.125	.500
MS18080-06	.687 .677	.591 .586	.5162 .5080	.718	.201	.362	.444	.333	.047	.5055	.500	.156	.562
MS18080-08	.875 .865	.785 .780	.6974 .6890	.843	.250	.438	.500	.375	.047	.6855	.578	.156	.750
MS18080-10	1.000 .990	.901 .896	.8111 .8050	.968	.276	.521	.604	.461	.047	.8015	.688	.172	.875
MS18080-12	1.250 1.240	1.076 1.071	.9885 .9810	1.015	.276	.615	.636	.469	.062	.9765	.750	.125	1.062
MS18080-16	1.500 1.490	1.357 1.352	1.2385 1.2310	1.125	.279	.627	.729	.563	.078	1.2265	.766	.219	1.312
MS18080-20	2.000 1.990	1.669 1.664	1.5515 1.5440	1.218	.349	.645	.729	.563	.094	1.5385	.766	.312	1.625
MS18080-24	2.250 2.240	1.919 1.914	1.8015 1.7940	1.406	.443	.738	.827	.661	.094	1.7885	.875	.359	1.875

PART NO.	P	R	S	THREAD	U	V	W	WEIGHT MAX LBS
MS18080-03	.500	.045	.227	.3750-24 UNF-3B MOD MIL-S-8879	.075	-	.083	.020
MS18080-04	.563	.060	.260	.4375-20 UNF-3B MOD	.078	-	.084	.024
MS18080-05	.625	.070	.300	.5000-20 UNF-3B MOD	.084	-	.087	.030
MS18080-06	.688	.070	.332	.5625-18 UNF-3B MOD	.084	-	.087	.036
MS18080-08	.875	.070	.426	.7500-16 UNF-3B MOD	.098	-	.102	.058
MS18080-10	1.000	.070	.492	.8750-14 UNF-3B MOD	.098	-	.102	.082
MS18080-12	1.250	.070	.587	1.0625-12 UNF-3B MOD	.129	-	.142	.145
MS18080-16	1.500	.070	.712	1.3125-12 UNF-3B MOD	.129	-	.142	.195
MS18080-20	2.000	.070	.963	1.6250-12 UNF-3B MOD	.129	1.715	.142	.458
MS18080-24	2.250	.070	1.098	1.8750-12 UNF-3B MOD	.129	1.937	.142	.625

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PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 2 OF 2

APPROVED 26 April 1965 REVISED