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**AMSC N/A**

REVIEWER ACTIVITIES

**AIR FORCE-82  
DLA-15**

USER ACTIVITIES  
ARMY-CRM

**ⓕ ENTIRE STANDARD REVISED**

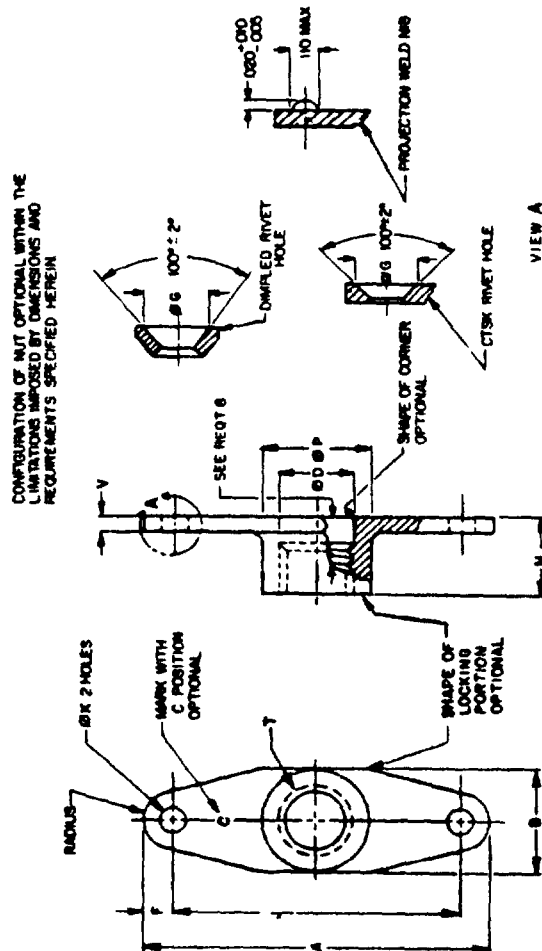
P.A. NAVY-AS Other Cost ARMY-AV AIR FORCE-II	INTERNATIONAL INTEREST	TITLE NUT, SELF LOCKING, PLATE, TWO LUG, REDUCED RIVET SPACING, LOW HEIGHT, CRES, 125KSI Ftu, 450°F. & 800°F
PROCUREMENT SPECIFICATION MIL-N-25027		SUPERSEDES NAS 697

## MILITARY STANDARD

**MS21070**

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**TABLE 1. ECHO MONITORING AND DISSEMINATIONS**

[illegible]

✓ HEDSON "4" NOT SPECIFIED, LISTED ONLY BY STRENGTH REQUIREMENTS OF SPECIFICATION.  
✓ CENTER OF THE TYPED WELD SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE  
✓ PLATE NOT BE EXTENDING BY THE WELD BEHIND BY MORE THAN 100%.  
✓ DOWNWARD RIVER BOLT TOLERANCE FOR Ø "4" IS +.015 - .000.  
✓ SPACES WELD NOT PERMIT COUPLING.

APPROVED 6 APR 64  
REVISED  
F 30 SEP 87

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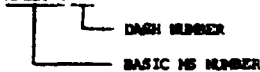
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## REQUIREMENTS:

1. **MATERIAL:** CORROSION RESISTANT STEEL, TYPE A286, (UNS S46286) IN ACCORDANCE WITH AMS5525, AMS5732 OR AMS5737.
2. **FINISH:** ONLY 800°F NUTS: SILVER PLATE ALL THREADED SURFACES OF NUT ELEMENT IN ACCORDANCE WITH AMS 2410. THREADS SHALL SHOW COMPLETE COVERAGE. SILVER PLATING ON ALL OTHER SURFACES OPTIONAL. TURNISHING OR DISCOLORATION OF SILVER NOT CAUSE FOR REJECTION.
3. **LUBRICANT:** ONLY 450°F NUTS: DRY FILM LUBRICANT IN ACCORDANCE WITH MIL-N-25027
4. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
5. **HARDNESS:** 49HRC, MAX.
6. **THREADS:** THREADS BEFORE LUBRICATION IN ACCORDANCE WITH MIL-G-8879.
7. **SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL NOT EXCEED 125 MICROINCHES, IN ACCORDANCE WITH ANSI B46.1.
8. **COUNTERBORE/COUNTERSINK:** ON SIZE .164 AND LARGER, THREAD RELIEF SHALL BE .062 MINIMUM; ON SIZE .138 AND SMALLER, COUNTERSINK TO "P" DIAMETER.
9. **PERFORMANCE:** SEE PROCUREMENT SPECIFICATION, EXCEPT 450°F DRY FILM LUBRICATED NUTS LIMITED TO FIVE REUSE CYCLES.
10. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC NS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: NS21070LW



NS21070LW INDICATES NUT, SELF-LOCKING, PLATE, TWO LUG, REDUCED RIVET SPACING, LOW HEIGHT, CRES; 125 KSI F<sub>tu</sub>, 450°F DRY FILM LUBRICATION; .250-28 UNJF-3B; WELDING PROTECTION

## NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
3. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
4. DESIGN AND USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO DEVELOP THE TENSILE STRENGTH OF BOLTS AND SCREWS WITH AN ULTIMATE TENSILE STRENGTH OF 125 KSI BASED ON THE CROSS SECTION AREA AT THE BASIC ROOT DIAMETER OF THE THREADS. THESE NUTS ARE DESIGNED TO BE USED ON 3A EXTERNAL THREADS. THESE NUTS SHALL BE USED IN ACCORDANCE WITH THE LIMITATIONS OF NS33588. ONLY NUTS FOR WHICH THERE ARE QUALIFIED PRODUCTS LISTED ON QPL 25027 SHALL BE USED.

## INTERCHANGEABILITY RELATIONSHIP

NS21070 NUTS CAN UNIVERSALLY REPLACE NAS697 NUTS OF LIKE MATERIAL, THREAD SIZE, LUBRICANT (DRY FILM OR NON-DRY FILM LUBRICANT), AND FASTENING METHOD (PLAIN RIVET HOLES; DIMPLED OR COUNTERBUNK RIVET HOLES), BUT THESE NAS697 NUTS CANNOT UNIVERSALLY REPLACE NS21070 NUTS.

INTERCHANGEABILITY TABLE

CANCELLED PART NUMBERS	SUBSTITUTIVE PART NUMBERS	CANCELLED PART NUMBERS	SUBSTITUTIVE PART NUMBERS
NAS697C02	NS21070-02	NAS697C05	NS21070-6
NAS697C02M	NS21070L02	NAS697C05M	NS21070L6
NAS697C03	NS21070-03	NAS697A3K	
NAS697C03M	NS21070L03	NAS697X4	
NAS697C04L	NS21070-04	NAS697X4K	
NAS697C04LM	NS21070L04	NAS697A4	
NAS697C06L	NS21070-06	NAS697A4K	
NAS697C06LM	NS21070L06	NAS697X5	
NAS697C08	NS21070-08	NAS697X5K	
NAS697C08M	NS21070L08	NAS697A5	
NAS697C3	NS21070-3	NAS697A5K	
NAS697C3M	NS21070L3	NAS697X5	
NAS697C4	NS21070-4		
NAS697C4M	NS21070L4		
NAS697C5	NS21070-5		
NAS697C5M	NS21070L5		

P. A. NAVY-AS Other Code ARMY-AV AIR FORCE-11	INTERNATIONAL INTEREST	TITLE NUT, SELF LOCKING, PLATE, TWO LUG, REDUCED RIVET SPACING, LOW HEIGHT, CRES, 125 KSI F <sub>tu</sub> , 450°F & 800°F	MILITARY STANDARD <b>MS21070</b>
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDED NAS 697	PAGE 2 OF 2	

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5310-1541

USER ACTIVITIES  
ARMY-CR,MIREVIEWER ACTIVITIES  
AIR FORCE-82  
DLA-15

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APPROVED 6 APR 64 REVISED 6 FOR CHANGES SEE PAGES 1 AND 2