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AIR FORCE -99
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ARMY-CR,MI

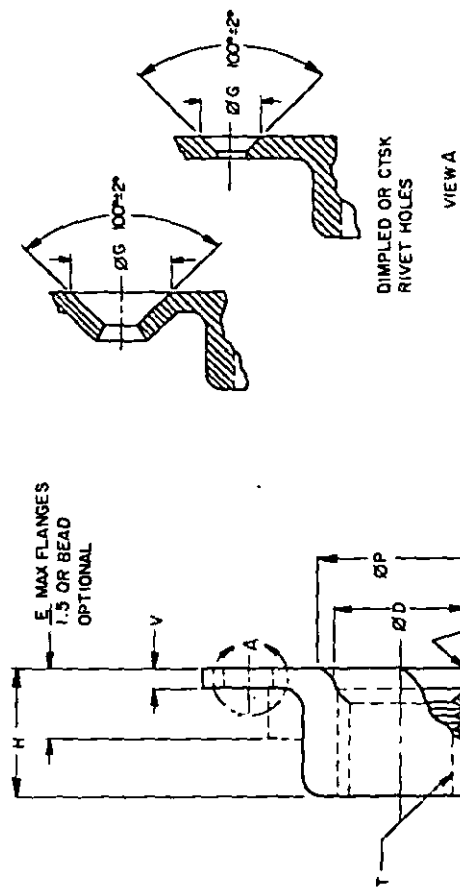
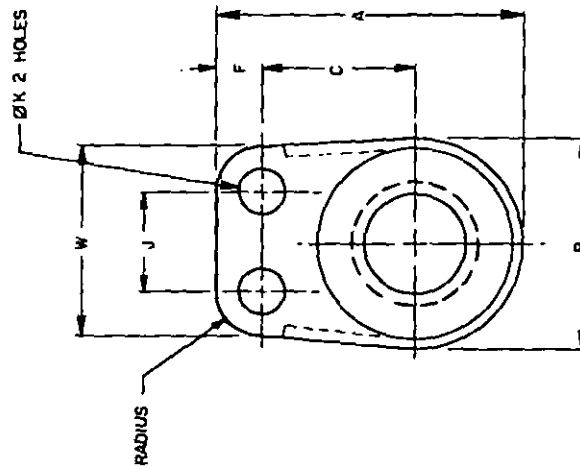
U.S. NAVY-AS	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other: Civil		NUT, SELF-LOCKING, PLATE, SIDE BY SIDE, REDUCED RIVET SPACING, LOW HEIGHT, STEEL, 125KSI FTU, 450°F	MS21086
ARMY-AV			
AIR FORCE-11			
PROCUREMENT SPECIFICATION	SUPERSEDES:	PAGE 1 OF 2	
MIL-N-25027	NAS1067 IN PART (STATUS NOTE)		

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5310-1596

CONFIGURATION OF NUT OPTIONAL WITHIN THE LIMITATIONS IMPOSED BY DIMENSIONS AND REQUIREMENTS AS SPECIFIED HEREIN.



SHAPE OF CORNER OPTIONAL MAY BE SQUARE, ROUNDED OR CTSK WITHIN THE LIMITS OF ØP. SEE REQ'T B

TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBERS	PLAIN RIVET HOLES		DIMPLED RIVET HOLES		T	A	B		C	ØD	F	ØG	J	ØP	V	H	AXIAL STRENGTH LBS/IN	HEIGHT LBS/100
	ØK	ØK	ØK	ØK			MAX	MIN										
08	1.08	1.08	0.8K	1.08K	164-32 UNF-30	.486	.797	.275	.234	.168	.100	.200	.219	.098	.047	.437	1,720	.23
1	1.3	1.3	1.3K	1.3K	190-32 UNF-30	.521	.328	.298	.250	.194	.100	.200	.219	.098	.047	.437	2,460	.28
4	1.4	1.4	1.4K	1.4K	250-28 UNF-30	.591	.414	.380	.281	.254	.100	.200	.219	.098	.053	.437	4,360	.45
5	1.5	1.5	1.5K	1.5K	3175-24 UNF-30	.747	.505	.475	.359	.317	.125	.230	.269	.130	.417	.537	7,390	.78
6	1.6	1.6	—	—	3775-24 UNF-30	.856	.614	.580	.414	.379	.125	.230	.269	.130	.505	.537	11,450	1.05

MINIMUM "B" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS OF SPECIFICATION.
 CENTER OF THE DIMPLED HOLE SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES BY MORE THAN .005.
 DIMPLED RIVET HOLE TOLERANCES PER Ø .015 ±.015 ±.000.

APPROVED 5 APR 65 REVISED 30 SEP 87

12788

FED SUP CLASS
5310

REQUIREMENTS:

1. **MATERIAL:** CARBON STEEL, COMPOSITIONS 1035 (UNS G10350), 1040 (UNS G10400) AND 1050 (UNS G10500), IN ACCORDANCE WITH QQ-S-635; 1042 (UNS G10420), IN ACCORDANCE WITH ASTM A29. ALLOY STEEL, GRADES 4130 (UNS G41300), 4340 (UNS G43400) AND 8740 (UNS G87400), IN ACCORDANCE WITH ASTM A29.
2. **FINISH:** CHROMIUM PLATE IN ACCORDANCE WITH QQ-P-416 TYPE II, CLASS 2. FOR DRY FILM LUBRICATED NUTS, THE TYPE AND CLASS ARE OPTIONAL IF THE NUTS MEET THE SALT SPRAY REQUIREMENTS OF QQ-P-416 TYPE II.
3. **LUBRICANT:** DRY FILM LUBRICANT APPROVED IN ACCORDANCE WITH MIL-N-25027. NON-DRY FILM LUBRICANTS SHALL BE SOLUBLE IN THE CLEANER SPECIFIED IN MIL-S-8802.
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-S-8879.
7. **SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL NOT EXCEED 125 MICROINCHES, IN ACCORDANCE WITH ANSI B46.1.
8. **COUNTERBORE:** ON SIZE .164 AND LARGER, THREAD RELIEF SHALL BE .062 MINIMUM.
9. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS21086LAK

DASH NUMBER

BASIC MS NUMBER

MS21086LAK INDICATES: NUT, SELF-LOCKING, PLATE, SIDE BY SIDE, REDUCED RIVET SPACING, LOW HEIGHT, STEEL, 125 KSI FTU, 450° F; .250-28 UNF-3B; DRY FILM LUBRICANT; COUNTERSUNK OR DIMPLED HOLES.

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 MS33588. ONLY NUTS FOR WHICH THERE ARE QUALIFIED PRODUCTS LISTED ON QPL 25027 SHALL BE USED.

INTERCHANGEABILITY RELATIONSHIP

MS21086 NUTS CAN UNIVERSALLY REPLACE NAS1067 NUTS OF LIKE MATERIAL, THREAD SIZE, PLATING LUBRICANTS (DRY FILM OR NON-DRY FILM), RIVET SPACING AND FASTENING METHOD (PLAIN RIVET HOLES; DIMPLED OR COUNTERSUNK RIVET HOLES OR PROTECTION WELDING), BUT THESE NAS1067 NUTS CANNOT UNIVERSALLY REPLACE MS21086 NUTS.

INTERCHANGEABILITY TABLE

CANCELLED PART NUMBERS	SUBSTITUTIVE PART NUMBERS
NAS1067X08	MS21086-08
NAS1067X08K	MS21086-08K
NAS1067A08	MS21086L08
NAS1067A08K	MS21086L08K
NAS1067X3	MS21086-3
NAS1067X3K	MS21086-3K
NAS1067A3	MS21086L3
NAS1067A3K	MS19086L3K
NAS1067X4	MS21086-4
NAS1067X4K	MS21086-4K
NAS1067A4	MS21086L4
NAS1067A4K	MS21086L4K
NAS1067X5	MS21086-5
NAS1067X5K	MS21086-5K
NAS1067A5	MS21086L5
NAS1067A5K	MS21086L5K
NAS1067X6	MS21086-6
NAS1067A6	MS21086L6

APPROVED 5 APR 65 REVISED 5 APR 65 (B) FOR CHANGES SEE PAGES I AND 2

P.A. NAVY-AS Other: GUST ARMY-AV AIR FORCE-II	INTERNATIONAL INTEREST	TITLE NUT, SELF-LOCKING, PLATE, SIDE BY SIDE, REDUCED RIVET SPACING, LOW HEIGHT, STEEL, 125 KSI FTU, 450° F	MILITARY STANDARD MS21086
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES: NAS 1067 IN PART (STATUS NOTE)	PAGE 2 OF 2	

DD FORM 1 MAY 11 672-1 (COORDINATED)

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