

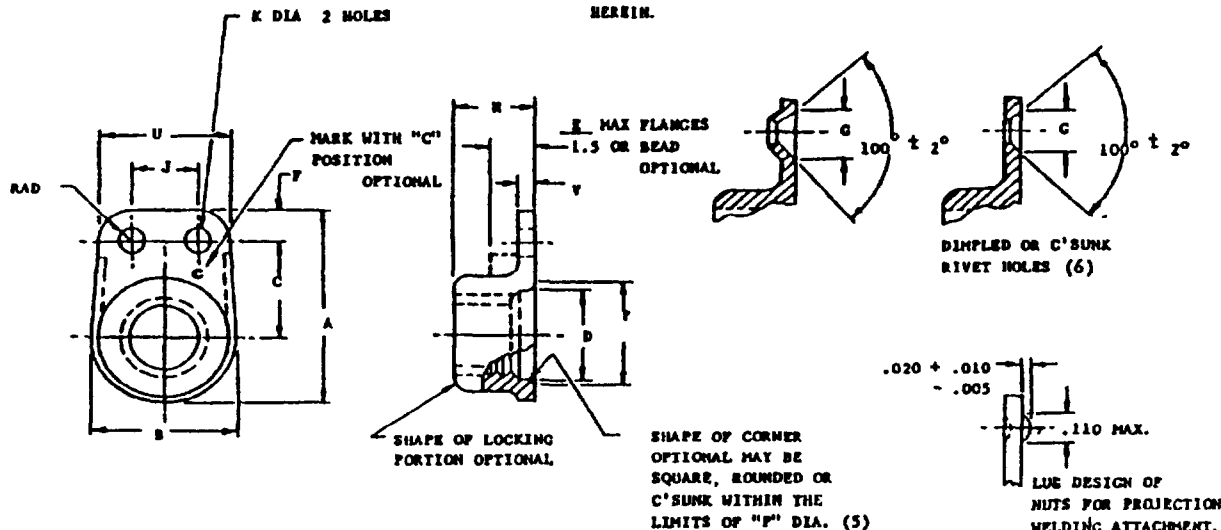
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 AMSC N/A

CONFIGURATION OF NUT OPTIONAL
 WITHIN THE LIMITATIONS IMPOSED BY
 DIM. 'B' AND REQUIREMENTS AS SPECIFIED
 HEREIN.

FED SUP CLASS
 5310



(1) (2) THREAD SIZE	A MAX.	B		(4) C + .005	D MIN	(3) H MAX		F MIN	G DIA ± .010	U MAX	J + .002	K(6) DIA + .005 - .000	P DIA MAX	V MAX	AXIAL STRENGTH LBS MIN	WEIGHT LBS/100
		MAX	MIN			MAX	MIN									
8-32 UNC-3B	.486	.297	.235	.234	.168	.250	.100	.200	.437	.219	.098	.248	.047		1720	23
10-32 UNF-3B	.521	.328	.298	.250	.194	.250	.100	.200	.437	.219	.098	.274	.047		2460	28
1/4-28 UNF-3B	.591	.414	.380	.281	.254	.281	.100	.200	.437	.219	.098	.344	.055		4580	45
5/16-24 UNF-3B	.747	.505	.475	.359	.317	.328	.125	.230	.537	.269	.130	.417	.065		7390	78
3/8-24 UNF-3B	.856	.614	.580	.414	.379	.344	.125	.230	.537	.269	.130	.505	.075		11450	105

- (1) THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION
- (2) THREADS IN ACCORDANCE WITH MIL-S-7742 ARE ACCEPTABLE UNTIL 31 DECEMBER 1969.
- (3) MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENT OF SPECIFICATION
- (4) CENTER OF TAPPED HOLE SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES BY MORE THAN .005.
- (5) ON SIZE NO. 8 AND LARGER COUNTERBORE THREAD "D" DIA. X.062 DEEP MIN. THREAD RELIEF ON SIZE NO 6 AND SMALLER C'SINK TO "P" DIA. WITHIN THE LIMITS OF F AND D.
- (6) DIMPLED RIVET HOLE TOLERANCE FOR "K" IS +.015 - .000.

(A) MATERIAL: CORROSION RESISTANT STEEL, (A286) AMS5735 OR AMS5737 OR AMS 5525.

HARDNESS: ROCKWELL C49 MAX

PLATING: 800°F NUTS. SILVER PLATE IN ACCORDANCE WITH AMS2410. PLATE THICKNESS, MEASURED ON ANY EXTERNAL SURFACE OF THE NUT, SHALL NOT BE LESS THAN 0.0002 IN. THREADS SHALL SHOW COMPLETE COVERAGE BUT THICKNESS REQUIREMENT ON THREAD IS WAIVED NO SILVER PLATE ON WELD NUTS.

LUBRICANT: 450°F NUTS, DRY FILM LUBRICANT IN ACCORDANCE WITH MIL-N-25027 -FOR USAF APPLICATIONS NUTS TREATED WITH DRY FILM LUBRICANTS SHALL NOT BE USED IN INTERNAL FUEL SYSTEMS (NO SILVER PLATE).

(B) MAGNETIC PERMEABILITY: SHALL BE LESS THAN 2.0 (AIR=1.0) FOR A FIELD STRENGTH H=200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214

DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED.

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.

PERFORMANCE. SEE PROCUREMENT SPECIFICATION, EXCEPT 450°F DRY FILM LUBRICATED NUTS LIMITED TO FIVE REUSE CYCLES

SURFACE ROUGHNESS IN ACCORDANCE WITH ANSI/ASME B46.1, UNLESS OTHERWISE SPECIFIED, THE SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICRO INCHES.

INTERCHANGEABILITY RELATIONSHIP: MS21087 NUTS CAN UNIVERSALLY REPLACE MS1067 NUTS OF LIKE MATERIAL, THREAD SIZE, LUBRICANT (SILVER PLATE OR DRY FILM LUBRICANT), AND FASTENING METHOD (PLAIN RIVET HOLES; DIMPLED OR C'SUNK RIVET HOLES; OR PROJECTION WELDING). BUT THESE MS1067 NUTS CANNOT UNIVERSALLY REPLACE MS21087 NUTS.

(B) DENOTES CHANGES

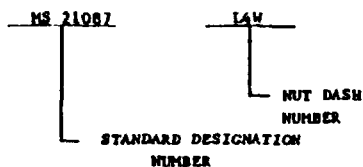
P A NAVY - AS Other Cust USAF - 11 ARMY - AV	TITLE NUT, SELF-LOCKING, PLATE, SIDE BY SIDE REDUCED RIVET SPACING, LOW HEIGHT, CRES, 125 KSI FTU, 450° & 800° F.	MILITARY STANDARD	
		MS21087	
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES IN PART MS1067 (STATUS NOTE)	SHEET	1 OF 2

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- ① BIDS SHALL BE SOLICITED ONLY FROM THE MANUFACTURERS LISTED ON QPL-25027.
- 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.

THREAD SIZE	DASH NUMBERS					
	450°F			800°F		
	PLAIN HOLES	COUNTER SUNK OR DIMPLED HOLES	WELDING PROJECTION	PLAIN HOLES	COUNTER SUNK OR DIMPLED HOLES	WELDING PROJECTION
8-32UNC-3B	L08	L08K	L08W	-08	-08K	-08W
10-32UNF-3B	L3	L3K	L3W	-3	-3K	-3W
1/4-28UNF-3B	L4	L4K	L4W	-4	-4K	-4W
5/16-24UNF-3B	L5	L5K	L5W	-5	-5K	-5W
3/8-24UNF-3B	L6		L6W	-6	-6	-6W

EXAMPLE OF PART NUMBERS



1/4-28UNF-3B NUT SELF LOCKING, ALL METAL
DRY FILM LUBRICANT, C'SUNK OR DIMPLED RIVET
HOLES, 450°F.

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APPROVED 5 April 65 REVISED (B) FOR CHANGES SEE SHEETS 1 AND 2

P A NAVY - AS Other Cust USAP - 11 ARMY - AV	TITLE NUT, SELF-LOCKING, PLATE, SIDE BY SIDE REDUCED RIVET SPACING, LOW HEIGHT, CRES, 125 KSI FTU, 450°F & 800°F.	MILITARY STANDARD	
		MS21087	
PROCUREMENT SPECIFICATION MIL-H-25027	SUPERSEDES IN PART NAS1067 (STATUS NOTE)	SHEET 2	OF 2