

REVIEW ACTIVITIES: DLA-CS
USER ACTIVITIES: NAVY-YD MC

FED. SUP CLASS
2540

HARDEN AS NOTED

15/64 DIA THRU

1/16 X 45° CHAMFER

7/8

1/4

1/32

1/8

1/16 R

1/8

1/8-12 UNF-2A THREAD

2 DIA

16 7/8

10 1/2

4 7/8

1 1/8

1/4

1/2 R

125

1500 +.000/-0.005 DIA

1 3/8

FULL THREAD

3/8 MAX CENTER DRILL PERMITTED THIS END

220°

10°

3 DIA REF

15/8 DIA REF

1 3/4 R

LUNETTE
SEE MS 51336

APPROX MARKING AREA

REQUIREMENTS:

1. MATERIAL: STEEL FORGING 4140H, 4340 PER MIL-S-46172, GRADE OPTIONAL. WAIVE MECHANICAL PROPERTY REQUIREMENTS OF SPECIFICATION.
2. HEAT TREATMENT: QUENCH AND TEMPER TO ROCKWELL HRC 28-32.
3. SURFACE HARDEN AS SHOWN, 1/16 MIN TO 3/16 MAX DEPTH. CHECK TO BE MADE AT LOCATIONS MARKED "A" (9 PLACES). HARDNESS RANGE ROCKWELL HRC 48-52, MIL-S-12515 (360° SURFACE HARDEN OPTIONAL).
4. CLEAN AND TREAT TYPE 1, TT-C-490; PRIME PER MIL-P-52192, MIL-P-53030 OR MIL-P-53022, 0.08 - 1.2 MILS THICK; TOPCOAT COLOR GREEN 383 PER MIL-C-46148 OR MIL-C-53039, 1.8 MILS THICK MINIMUM.
5. OPTIONAL MATERIAL: STEEL CASTING, SAND OR PRECISION, GRADE 150-135 (0.37% MIN CARBON), QQ-S-681. RADIOGRAPHIC INSPECTION IN ACCORDANCE WITH ASTM E142 AND TO THE FOLLOWING SEVERITY LEVELS PER ASTM E446:

CRITERION	SEVERITY LEVEL
GAS POROSITY	A-2
SAND AND INCLUSIONS	B-2
SHRINKAGE	
TYPE 1	CA-2
TYPE 2	CB-2
TYPE 3	CC-2
TYPE 4	CD-2
CRACKS	NOT ACCEPTABLE
HOT TEAR	NOT ACCEPTABLE
INTERNAL CHILL, UNFUSED CHAPLETS, INSERTS	NOT ACCEPTABLE
6. MUST BE FREE OF BURRS, SHARP CORNERS, LOOSE SCALE, LAPS, COLD SHUTS, AND ANY INDICATION OF OVERHEATING OR BURNING.
7. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES; TOLERANCES: ±1/32 ON FRACTIONS; ±.005 ON DECIMALS; ±5° ON ANGULAR DIMENSIONS.
8. SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2.
9. MARKING SHALL CONSIST OF THE MS PART NUMBER AND THE MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH MIL-STD-130.

(F) DENOTES CHANGES

MS PART NO.
MS 51338-1

P.A. AT Other Cust	INTERNATIONAL INTEREST	TITLE COUPLER, DRAWBAR, RING: LIGHT DUTY, 60,000 LB GVW	MILITARY STANDARD MS 51338
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 2	

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E NOTES:

1. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
2. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
3. APPLICABLE PROVISIONS OF ASCC AIR STD 11/8, STANAG 4101 AND QSTAG 264 ARE MARKED *.
4. THE USE OF RECYCLED MATERIALS WHICH MEET THE REQUIREMENTS OF THE APPLICABLE MATERIAL SPECIFICATIONS WITHOUT JEOPARDIZING THE INTENDED USE OF THE ITEM SHALL BE ENCOURAGED.

CERTAIN PROVISIONS OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENTS ASCC AIR STD 11/8, STANAG 4101 AND QSTAG 264. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED WHICH WILL AFFECT OR VIOLATE THE INTERNATIONAL AGREEMENT CONCERNED, THE PREPARING ACTIVITY WILL TAKE APPROPRIATE RECONCILIATION ACTION THROUGH INTERNATIONAL STANDARDIZATION CHANNELS, INCLUDING DEPARTMENTAL STANDARDIZATION OFFICES, IF REQUIRED.

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APPROVED 9 JANUARY 1961. REVISED (F) SEE SHEETS 1&2 FOR CHANGES

P.A. Other Cust AF-84	TITLE COUPLER, DRAWBAR, RING: LIGHT DUTY, 60,000 LB GVW	MILITARY STANDARD MS 51338
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 2 OF 2