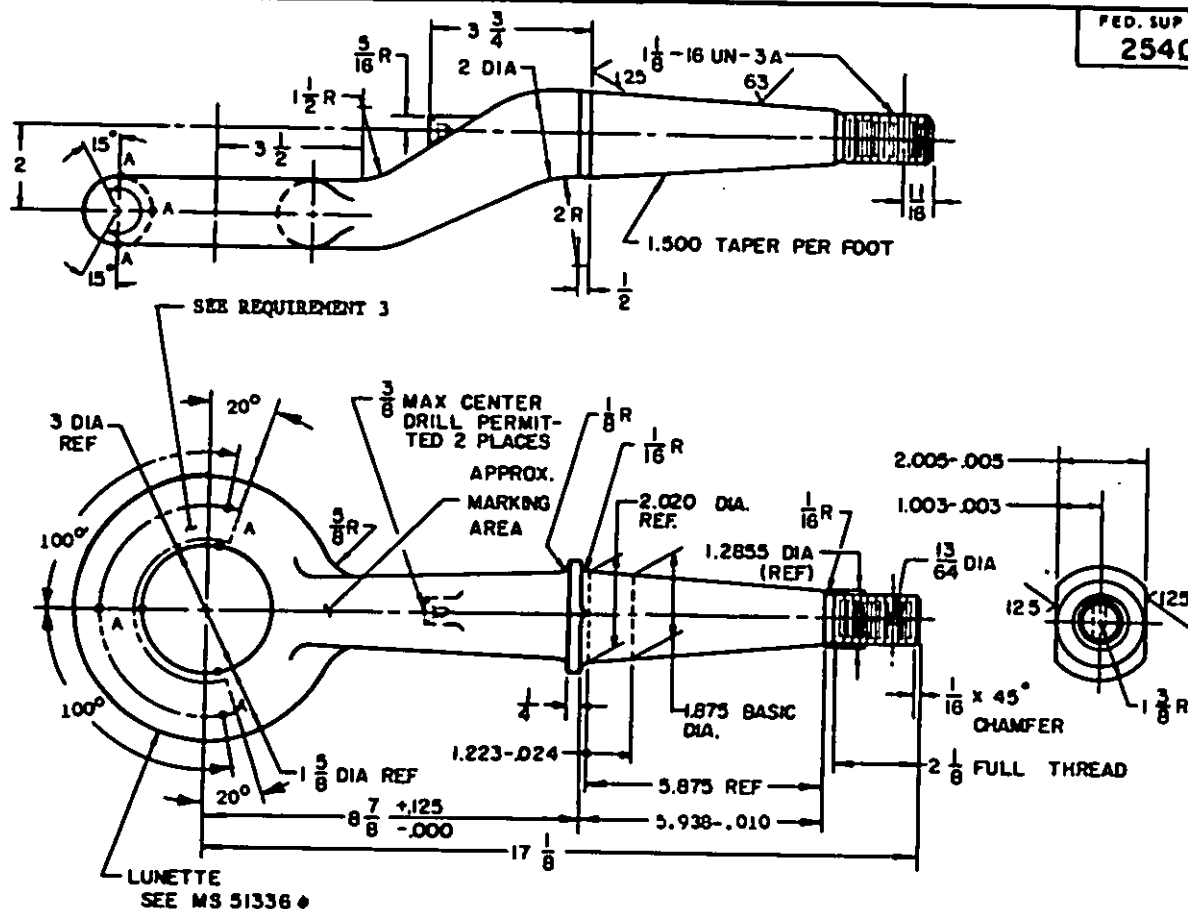


FED. SUP CLASS
2540

REQUIREMENTS:

1. MATERIAL: STEEL ALLOY FORGING, A140H, A340 PER MIL-S-46172, GRADE OPTIONAL. WAIVE MECHANICAL PROPERTIES REQUIREMENTS OF SPECIFICATION.
2. HEAT TREATMENT: QUENCH & TEMPER ROCKWELL HRC 28-32.
- (H) 3. SURFACE HARDEN AS SHOWN, 1/16 MIN TO 3/16 MAX DEPTH, IN ACCORDANCE WITH MIL-S-12515 (OPTIONAL HARDNESS PATTERN 360°). HARDNESS CHECKS TO BE MADE AT LOCATIONS MARKED "M" (9 PLACES). HARDNESS RANGE ROCKWELL HRC 48-52.
- (H) 4. FINAL FINISH: PHOSPHATE COAT, TYPE I, TT-C-490; PRIME, TT-P-636; FOREST GREEN PER MIL-E-52798 OR MIL-E-52835.
5. REMOVE BURRS & SHARP EDGES.
- (H) 6. 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

GAS POROSITY
SAND AND INCLUSIONS
SHRINKAGETYPE 1
TYPE 2
TYPE 3
TYPE 4CRACKS
HOT TEAR
INTERNAL CHILL, UNFUSED CHAPLETS, INSERTS

SEVERITY LEVEL

A-2
B-2CA-2
CB-2
CC-2
CD-2NOT ACCEPTABLE
NOT ACCEPTABLE
NOT ACCEPTABLE

(H) DENOTES CHANGES

MS PART NO.	REF. DRAWING
MS 51339- 3	11592597

P.A. ARMY - AT Other Cess	TITLE COUPLER, DRAWBAR, RING: OFFSET (TAPER SHANK), 60,000 LB GVW	MILITARY STANDARD MS 51339
PROCUREMENT SPECIFICATION	SUPERSEDES: MS 51339 (ORD)	SHEET 1 OF 2

FED. SUP CLASS
2540

7. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES: TOLERANCES: $\pm 1/32$ ON FRACTIONS; $\pm .005$ ON DECIMALS; $\pm 5^\circ$ ON ANGULAR DIMENSIONS.
8. SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2.
9. MARKINGS SHALL CONSIST OF THE MS PART NUMBER AND THE MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH MIL-STD-130.

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.

APPROVED 9 JAN. 1961 REVISED (H) SEE SHEET 1 FOR CHANGES

P.A. ARMY-AT
Other Cust

TITLE

COUPLER, DRAWBAR, RING: OFFSET
(TAPER SHANK), 60,000 LB GVW

MILITARY STANDARD

MS 51339

PROCUREMENT SPECIFICATION

SUPERSEDES:

MS 51339 (ORD)

SHEET 2 OF 2