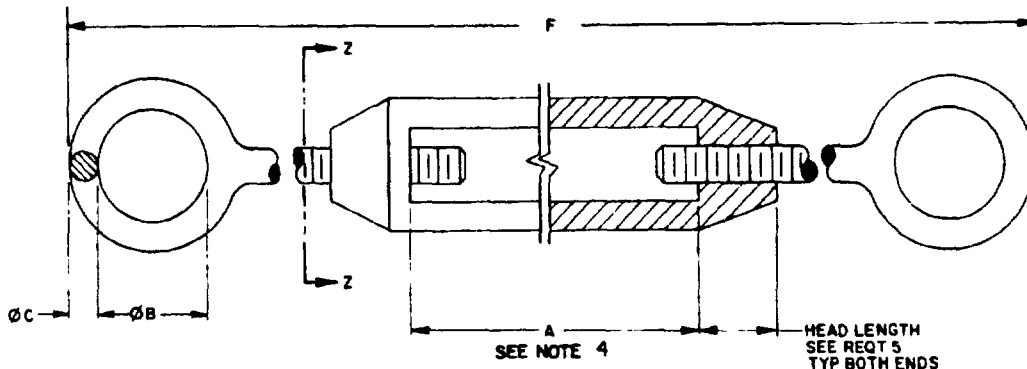


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USER ACTIVITIES:
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TURNBUCKLE ASSEMBLY

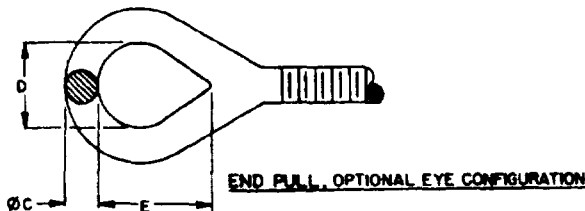


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	SECTIONAL THREAD SIZE	A MIN	EYE				F LENGTH MIN
			ϕ B MIN	ϕ C MIN	D MIN	E MIN	
1	.250-20	4	.500	.218	.344	.687	8.25
2	.3125-18	4.5	.625	.281	.437	.812	9.5625
3	.375-16	6	.750	.344	.531	.937	11.875
4	.500-13	6	1.000	.437	.718	1.187	16.3125
5		9					
6		12					
7	.625-11	6	1.250	.500	.875	1.375	18.5
8		9					
9		12					
10	.750-10	18	1.500	.625	1.000	1.625	23.0
11		6					
12		9					
13		12					
14		18					
15		24					
16	.875-9	12	1.750	.750	1.250	1.875	27.625
17		18					
18		24					
19	1.000-8	12	2.000	.875	1.437	2.250	29.625
20		18					
21		24					
22		36					

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AIR FORCE-B2
DLA-IS

P. A. ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, EYE AND EYE (TYPE I, FORM I, CLASS 4)	MILITARY STANDARD MS51561
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDES:	PAGE 1 OF 3	

NSC N/A

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5340 - 1501

APPROVED 9 FEB 1980 REVISED

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TABLE 1. DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	EYE				
			Ø B MIN	Ø C MIN	D MIN	E MIN	F LENGTH NOM
23 24 25 26	1.250-7	12 18 24 36	2.125	1.062	1.687	2.562	35.875
27 28 29 30 31	1.500-6	12 18 24 36 48	2.250	1.250	2.125	3.250	38.375
32 33 34 35	1.750-5	18 24 36 48	2.500	1.437	2.375	3.750	44.750
36 37 38	2.000-4.5	24 36 48	3.000	1.625	2.687	4.375	51.750
39 40 41	2.250-4.5	24 36 48	3.250	1.812	2.937	5.187	54.0
42 43 44	2.500-4	24 36 48	3.500	2.000	3.125	6.000	58.5

REQUIREMENTS:

- MATERIAL:** TURNBUCKLE BODY AND EYES SHALL BE MANUFACTURED FROM STEEL OF A COMPOSITION CAPABLE OF WITHSTANDING THE SPECIFIED IMPACTING STRENGTH IN THE PROCUREMENT SPECIFICATION.
- FABRICATION METHOD:** THE TURNBUCKLE BODY AND EYES SHALL BE HOT FORGED.
- FINISH:**
RUST INHIBITOR - TURNBUCKLE BODY AND EYES SHALL BE TREATED WITH RUST INHIBITOR IN ACCORDANCE WITH MIL-C-85054 OR EQUIVALENT.
ZINC COATING - TURNBUCKLE BODY AND END PULLS SHALL BE ZINC COATED AS SPECIFIED IN PROCUREMENT SPECIFICATION, ASTM A633, TYPE II, Fe/Zn 13.
- THREADS:** ONE END PULL AND THE CORRESPONDING HEAD BODY SHALL HAVE RIGHT HAND THREAD AND THE OTHER LEFT HAND. THE THREAD SHALL BE MACHINED AFTER FABRICATION OF END PULL AND THE HEAD BODY.
- LENGTH OF HEAD:** THE LENGTH OF THE HEAD OF THE TURNBUCKLE BODY SHALL BE NOT LESS THAN 1 1/2 TIMES THE NOMINAL THREAD SIZE FOR SIZES UP TO 1.250, AND 1 1/4 TIMES FOR SIZES GREATER THAN 1.250 NOMINAL THREAD SIZE.
- IMPACTING STRENGTH:** THE IMPACTING STRENGTH OF THE TURNBUCKLE SHALL BE NOT LESS THAN THE VALUE SPECIFIED IN THE PROCUREMENT SPECIFICATION FOR TYPE I, FORM 1, WITH EYE END PULLS.
- BENDING STRENGTH:** THE BENDING STRENGTH SHALL BE AS SPECIFIED IN THE PROCUREMENT SPECIFICATION.
- LENGTH OF THREAD:** THE LENGTH OF THE THREAD ON THE TWO END PULLS SHALL BE GREAT ENOUGH SO THAT THE ENDS OF THE END PULLS CAN BE BROUGHT INTO CONTACT WITH EACH OTHER AT THE MIDDLE OF THE BODY LENGTH.
- PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER, FOLLOWED BY A DASH NUMBER FROM TABLE I AND THE FINISH CODE BELOW:

FINISH CODE:

- F - RUST INHIBITOR TREATMENT
Z - ZINC COATED.

EXAMPLE: MS51561-Z

FINISH CODE
DASH NUMBER
BASIC MS NUMBER

MS51561-98 INDICATES TURNBUCKLE, ROUND BODY, EYE ENDS; 625-11 THREAD; 12-INCH CLEAR OPENING BETWEEN HEADS; ZINC COATED

U.S. ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL SYMBOLS	TITLE TURNBUCKLE, ROUND BODY, EYE AND EYE (TYPE I, FORM I, CLASS 4)	MILITARY STANDARD MS51561
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDES:	PAGE 2 OF 3	

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NOTES.

1. ALL DIMENSIONS ARE IN INCHES. TOLERANCES SHALL BE IN ACCORDANCE WITH STANDARD MANUFACTURING PRACTICES FOR TURNBUCKLES.
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. DIMENSION "A" IS THE TAKE UP LENGTH OR CLEAR OPENING INSIDE OF THE BODY.

USER ACTIVITIES:
ARMY-ME
NAVY-AS, MC, OS, YD

REVIEWER ACTIVITIES:
ARMY-CR
AIR FORCE-82
DLA-IS

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APPROVED 9 FEB 1988 REVISED

P. A. ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, EYE AND EYE (TYPE I, FORM I, CLASS 4)	MILITARY STANDARD
			MS51561
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDED	PAGE 3 OF 3	

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