

FED SUP CLASS  
5340

USAR ACTIVITY  
ARMY-WE  
NAVY-AS, MC, OS, YD

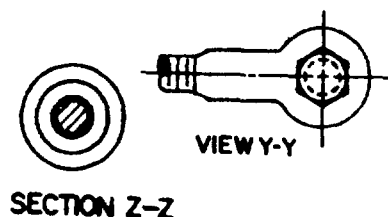
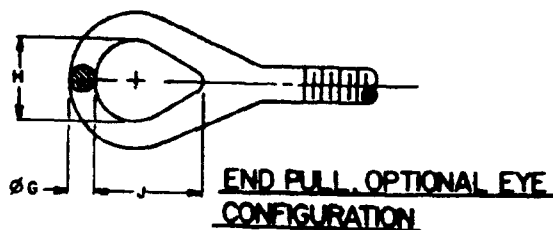
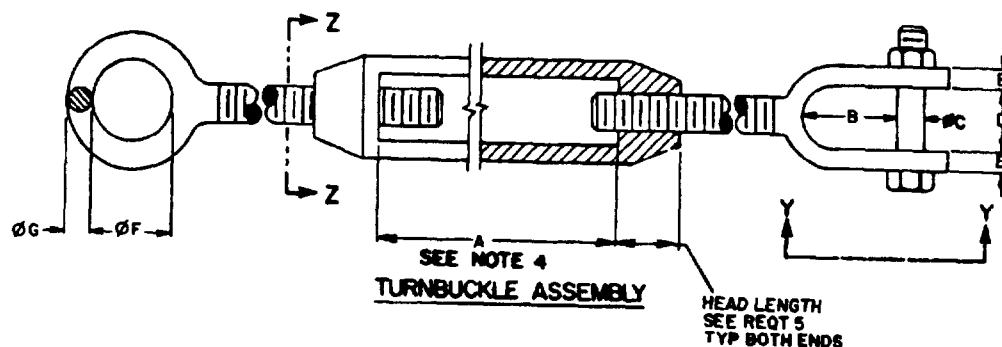


TABLE 1. DIMENSIONS AND CONNECTIONS

DIMENSION NUMBER	SECTION TENSILE SIZE	A INCH	JAW				EYE			
			B INCH	ØC INCH	D INCH	E INCH	ØF INCH	ØG INCH	H INCH	J INCH
1	.250-30	4	.625	.250	.375	.125	.500	.218	.344	.687
2	.312-24	4.5	.718	.250	.406	.156	.625	.281	.437	.812
3	.375-18	6	.812	.312	.500	.187	.750	.344	.531	.937
4	.500-13	6	1.032	.375	.625	.250	1.000	.437	.718	1.187
5		9								
6		12								
7	.625-11	6	1.250	.500	.750	.312	1.250	.500	.875	1.375
8		9								
9		12								
10		18								
11	.750-10	6	1.500	.625	.937	.375	1.500	.625	1.000	1.625
12		9								
13		12								
14		18								
15		24								
16	.875-9	12	1.750	.750	1.125	.437	1.750	.750	1.250	1.875
17		18								
18		24								
19	1.000-8	12	2.000	.875	1.187	.500	2.000	.875	1.437	2.250
20		18								
21		24								
22		36								

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NMC M/A

U.S. ARMY-AR  
Other Code  
NAVY-SH  
AIR FORCE-99

INTERNATIONAL  
INTEREST

TITLE

TURNBUCKLE, ROUND BODY,  
JAW AND EYE  
(TYPE I, FORM I, CLASS 8)

MILITARY STANDARD

MS51563

PROCUREMENT SPECIFICATION  
FF-T-791

SUPERSEDES:

PAGE 1 OF 3

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5340-1803

APPROVED 10 FEB 1968 REVISED

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

REVIEWER ACTIVITIES:  
ARMY-CR  
AIR FORCE-82  
DLA-15

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TABLE I DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	NOMINAL THREAD SIZE	JAW					EYE			
		A MIN	B MIN	C MIN	D MIN	E MIN	F MIN	G MIN	H MIN	J MIN
23 24 25 26	1.250-7	12 18 24 36	2.375	1.125	1.750	.625	2.125	1.062	1.687	2.562
27 28 29 30 31	1.500-6	12 18 24 36 48	2.750	1.375	2.062	.687	2.250	1.250	2.125	3.250
32 33 34 35	1.750-5	18 24 36 48	3.000	1.625	2.375	.750	2.500	1.437	2.375	3.750
36 37 38	2.000-4.5	24 36 48	3.750	1.875	2.500	.812	3.000	1.625	2.687	4.375
39 40 41	2.250-4.5	24 36 48	4.000	2.062	2.625	.875	3.250	1.812	2.937	5.187
42 43 44	2.500-4	24 36 48	4.250	2.250	2.875	1.000	3.500	2.000	3.125	6.000

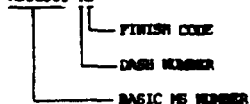
**REQUIREMENTS:**

- MATERIAL:** TURNBUCKLE BODY AND END PULLS SHALL BE MANUFACTURED FROM STEEL OF A COMPOSITION CAPABLE OF WITHSTANDING THE SPECIFIED BREAKING STRENGTH IN THE PROCUREMENT SPECIFICATION.
- FABRICATION METHOD:** THE TURNBUCKLE BODY AND END PULLS SHALL BE HOT FORGED.
- FINISH:**  
RUST INHIBITOR - TURNBUCKLE BODY AND END PULLS SHALL BE TREATED WITH RUST INHIBITOR IN ACCORDANCE WITH MIL-C-84654 OR EQUIVALENT.  
ZINC COATING - TURNBUCKLE BODY AND END PULLS SHALL BE ZINC COATED AS SPECIFIED IN PROCUREMENT SPECIFICATION, AFN 8633, 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 FINISHED 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.
- BREAKING STRENGTH:** THE BREAKING STRENGTH OF THE TURNBUCKLE SHALL BE NOT LESS THAN THE VALUE SPECIFIED IN THE PROCUREMENT SPECIFICATION FOR TYPE I, FORM 1, WITH JAW AND 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: MS51563-Z



MS51563-Z INDICATES TURNBUCKLE, ROUND BODY, JAW AND EYE END PULLS, .625-11 THREAD; 6-INCH CLEAR OPENING BETWEEN HEADS; ZINC COATED

APPROVED 10 FEB 1986 REVISED

P A ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, JAW AND EYE (TYPE I, FORM I, CLASS 8)	MILITARY STANDARD MS51563
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDES	PAGE 2 OF 3	

DD FORM 672-1 (COORDINATED)

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

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

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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 OF THE BODY.

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APPROVED 10 FEB 1968 BY 108

P. A. ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, JAW AND EYE (TYPE I, FORM I, CLASS 8)	MILITARY STANDARD MS51563
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