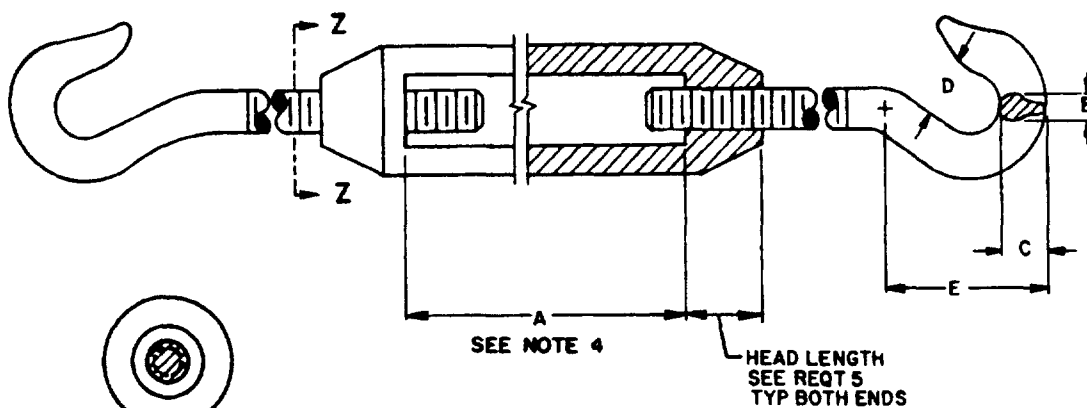


FED SUP CLASS
5340USDS ACTIVITIES
ARMY-ME
NAVY-AS, MC, OS, YD

SECTION Z-Z

TURNBUCKLE ASSEMBLY

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	NOMINAL THREAD SIZE	HOOK				
		A MIN	B MIN	C MIN	D MIN	E MIN
1	.250-20	4	.187	.343	.437	1.000
2	.3125-18	4.5	.250	.437	.500	1.250
3	.375-16	6	.344	.437	.562	1.562
4	.500-13	6	.437	.625	.625	2.000
5		9				
6		12				
7	.625-11	6	.531	.750	.812	2.437
8		9				
9		12				
10	.750-10	18	.625	.937	.968	2.937
11		6				
12		9				
13		12				
14		18				
15		24				
16	.875-9	12	.750	1.000	1.125	3.437
17		18				
18		24				
19	1.000-8	12	.812	1.187	1.250	3.875
20		18				
21		24				
22		36				

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

ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, HOOK AND HOOK (TYPE I, FORM I, CLASS 5)	MILITARY STANDARD MS51564
PROCUREMENT SPECIFICATION FF-T-791		SUPERSEDES	PAGE 1 OF 3

NMC N/A

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5340-1804

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TABLE 1 DASH NUMBERS AND DIMENSIONS - CONTINUED

FED SUP CLASS
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DASH NUMBER	HOOK					
	NOMINAL THREAD SIZE	A MIN	B MIN	C MIN	D MIN	E MIN
23 24 25 26	1 250-7	12 18 24 36	1 000	1 437	1.500	4 937
27 28 29 30 31	1.500-6	12 18 24 36 48	1.187	1.750	1 875	5.875
32 33 34 35	1 750-5	18 24 36 48	1.437	2.125	2.375	6 937
36 37 38	2.000-4.5	24 36 48	1.687	2 562	3.000	8 000
39 40 41	2 250-4 5	24 36 48	2 000	3 062	3 750	9.062
42 43 44	2.500-4	24 36 48	2.312	3 625	4.625	10.125

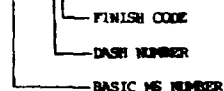
REQUIREMENTS

- MATERIAL** TURNBUCKLE BODY AND HOOK 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 HOOK PULLS SHALL BE HOT FORGED.
- FINISH.**
RUST INHIBITOR - TURNBUCKLE BODY AND HOOK PULLS SHALL BE TREATED WITH RUST INHIBITOR IN ACCORDANCE WITH MIL-C-55054 OR EQUIVALENT.
ZINC COATING - TURNBUCKLE BODY AND HOOK PULLS SHALL BE ZINC COATED AS SPECIFIED IN PROCUREMENT SPECIFICATION, ASTM B633, TYPE II, Fe/Zn 13.
- THREADS:** ONE END PULL AND THE CORRESPONDING HEAD BODY SHALL HAVE RIGHT THREAD AND THE OTHER LEFT END. THE THREAD SHALL BE MACHINED AFTER FABRICATION OF END PULL AND 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 I, WITH HOOK 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 1 AND THE FINISH CODE BELOW.

FINISH CODE

F - RUST INHIBITOR TREATMENT
Z - ZINC COATED

EXAMPLE MS51564-7Z



MS51564-7Z INDICATES TURNBUCKLE, ROUND BODY, HOOK END PULLS, 625-11 THREAD, 6-INCH CLEAR OPENING BETWEEN HEADS; ZINC COATED

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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.

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

REVIEWER ACTIVITIES:
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