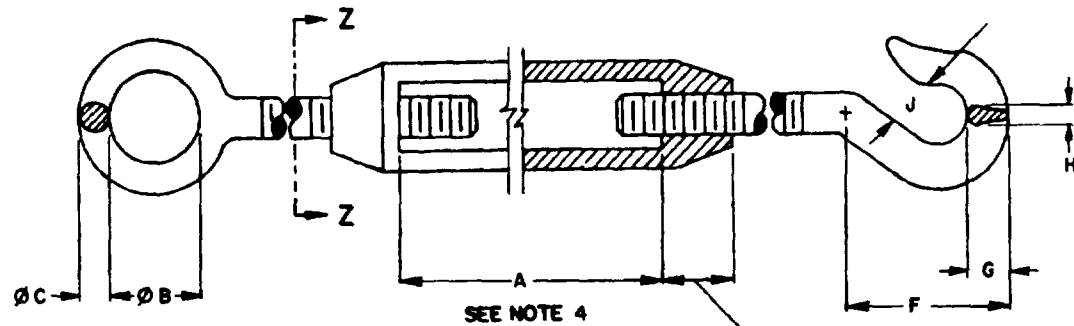
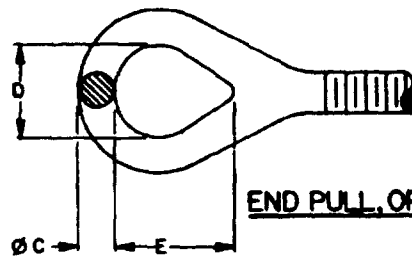
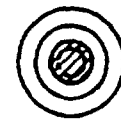


FED SUP CLASS  
5340

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



SEE NOTE 4

**TURNBUCKLE ASSEMBLY**HEAD LENGTH  
SEE REQ 5  
TYP BOTH ENDS**END PULL, OPTIONAL EYE CONFIGURATION**

SECTION Z-Z

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	EYE				HOOK			
			$\phi$ B MIN	$\phi$ C MIN	D MIN	E MIN	F MIN	G MIN	H MIN	J MIN
1	.250-20	4	.500	.218	.344	.687	1.000	.343	.187	.437
2	.3125-18	4.5	.625	.281	.437	.812	1.250	.437	.250	.500
3	.375-16	6	.750	.344	.531	.937	1.562	.437	.344	.562
4	.500-13	6	1.000	.437	.718	1.187	2.000	.625	.437	.625
5		9								
6		12								
7	.625-11	6	1.250	.500	.875	1.375	2.437	.750	.531	.812
8		9								
9		12								
10		18								
11	.750-10	6	1.500	.625	1.000	1.625	2.937	.937	.625	.968
12		9								
13		12								
14		18								
15		24								
16	.875-9	12	1.750	.750	1.250	1.875	3.437	1.000	.750	1.125
17		18								
18		24								
19	1.000-8	12	2.000	.875	1.437	2.250	3.875	1.187	.812	1.250
20		18								
21		24								
22		36								

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REVERSE ACTIVITIES:  
ARMY-CR  
AIR FORCE-B2  
DLA-IS

ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, HOOK AND EYE (TYPE I, FORM I, CLASS 6)	MILITARY STANDARD MS51565
PROCUREMENT SPECIFICATION FF-T-791		SUPERSEDES	PAGE 1 OF 3

NSC N/A

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APPROVED 11 FEB 1968 REVISED

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

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

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TABLE I DASH NUMBERS AND DIMENSIONS - CONTINUED

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DASH NUMBER	NOMINAL THREAD SIZE	A MIN	EYE				HOOK			
			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	2.125	1.062	1.687	2.562	4.937	1.437	1.000	1.500
27 28 29 30 31	1.500-6	12 18 24 36 48	2.250	1.250	2.125	3.250	5.875	1.750	1.187	1.875
32 33 34 35	1.750-5	18 24 36 48	2.500	1.437	2.375	3.750	6.937	2.125	1.437	2.375
36 37 38	2.000-4.5	24 36 48	3.000	1.625	2.687	4.375	8.000	2.562	1.687	3.000
39 40 41	2.250-4.5	24 36 48	3.250	1.812	2.937	5.187	9.062	3.062	2.000	3.750
42 43 44	2.500-4	24 36 48	3.500	2.000	3.125	6.000	10.125	3.625	2.312	4.625

## 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-85054 OR EQUIVALENT.  
ZINC COATING - TURNBUCKLE BODY AND END PULLS SHALL BE ZINC COATED AS SPECIFIED IN PROCUREMENT SPECIFICATION, ASTM A633, TYPE 11, 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.
- BREAKING STRENGTH:** THE BREAKING STRENGTH OF THE TURNBUCKLE SHALL BE NOT LESS THAN THE VALUE SPECIFIED IN THE PROCUREMENT SPECIFICATION FOR TYPE 1, FORM 1, WITH HOOK 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 MS51565-7Z  
 └───┬─── FINISH CODE  
 └───┬─── DASH NUMBER  
 └─── BASIC MS NUMBER

MS51565-7Z INDICATES TURNBUCKLE, ROUND BODY, HOOK AND EYE END PULLS; 625-11 THREAD, 6-INCH CLEAR OPENING BETWEEN HEADS, ZINC COATED

APPROVED 11 FEB 1988 REVISED

ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, ROUND BODY, HOOK AND EYE (TYPE I, FORM I, CLASS 6)	MILITARY STANDARD
			MS51565
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDES		PAGE 2 OF 3

FED SUP CLASS  
5340

## 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-NE  
NAVY-AS, MC, OS, YD  
DLA-IS

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

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APPROVED 11 FEB 1968 REVISED

P A ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE  TURNBUCKLE, ROUND BODY, HOOK AND EYE (TYPE I, FORM I, CLASS 6)	MILITARY STANDARD
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