

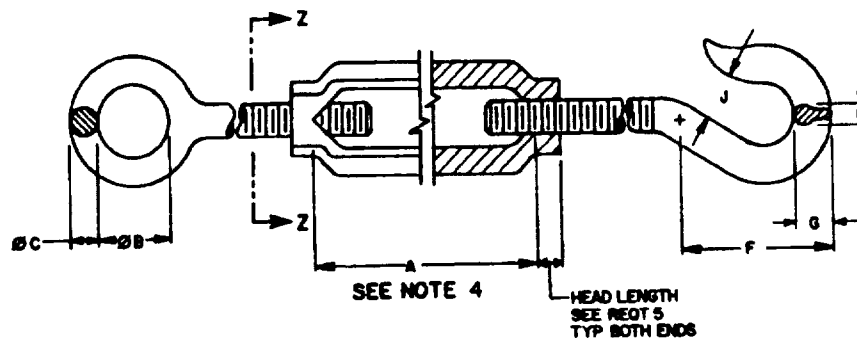
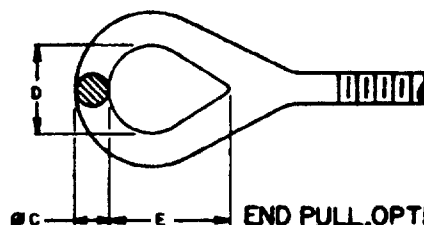
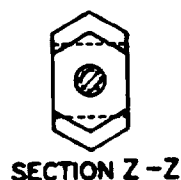
FED SUP CLASS  
5340USE ACTIVITIES:  
ARMY-ME  
NAVY-AS, MC, OS, YDREVIEWER ACTIVITIES:  
ARMY-CR  
AIR FORCE-82  
DLA-IS**TURNBUCKLE ASSEMBLY****END PULL OPTIONAL EYE CONFIGURATION**

TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	EYE				HOOK			
			Ø B MIN	Ø C MIN	D MIN	E MIN	F MIN	G MIN	H MIN	J MIN
1	.750-20	4	.500	.218	.344	.687	1.000	.343	.187	.437
2	.875-18	4.5	.625	.281	.437	.812	1.250	.437	.250	.500
3	.975-16	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	.750-10	18	1.500	.625	1.000	1.625	2.937	.937	.625	.968
11		6								
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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NMC M/A

P. A.  
ARMY-AR  
Other Code  
NAVY-SH  
AIR FORCE-99INTERNATIONAL  
INTEREST

TITLE

TURNBUCKLE, SPREAD BODY,  
HOOK AND EYE  
(TYPE I, FORM 2, CLASS 6)

MILITARY STANDARD

MS51568

PROCUREMENT SPECIFICATION  
FF-T-791

SUPERSEDES

PAGE 1 OF 3

DD FORM 672-1 (COORDINATED)  
1 MAY 75

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5340-1808

APPROVED 12 FEB 1968

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

REVIEWER ACTIVITIES:  
ARMY - CR  
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TABLE I DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	EYE				HOOK			
			ΦB MIN	ΦC MIN	D MIN	E MIN	F MIN	G MIN	H MIN	J MIN
23	1.250-7	12	2.125	1.062	1.687	2.562	4.937	1.437	1.000	1.500
24		18								
25		24								
26		36								
27	1.500-6	12	2.250	1.250	2.125	3.250	5.875	1.750	1.187	1.875
28		18								
29		24								
30		36								
31		48								
32	1.750-5	18	2.500	1.437	2.375	3.750	6.937	2.125	1.437	2.375
33		24								
34		36								
35		48								
36	2.000-4.5	24	3.000	1.625	2.687	4.375	8.000	2.562	1.687	3.000
37		36								
38		48								
39		60								
40	2.250-4.5	24	3.250	1.812	2.937	5.187	9.062	3.062	2.000	3.750
41		36								
42		48								
43		60								
44	2.500-4	24	3.500	2.000	3.125	6.000	10.125	3.625	2.312	4.625
45		36								
46		48								
47		60								

**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:**  
BODY - THE TURNBUCKLE BODY SHALL BE FABRICATED OF ONE PIECE OF MATERIAL AS SPECIFIED IN THE PROCUREMENT SPECIFICATION.  
END PULLS - THE 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 B633, 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.
- BREAKING STRENGTH:** THE BREAKING STRENGTH OF THE TURNBUCKLE SHALL BE NOT LESS THAN THE VALUE SPECIFIED IN THE PROCUREMENT SPECIFICATION FOR TYPE 1, FORM 2, 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.

APPROVED 12 FEB 1988 REVISED

U.S. ARMY - AR NAVY - SH AIR FORCE - 99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, SPREAD BODY, HOOK AND EYE (TYPE I, FORM 2, CLASS 6)	MILITARY STANDARD MS51568
PROCUREMENT SPECIFICATION FF-T-791		SUPERSEDES	PAGE 2 OF 3

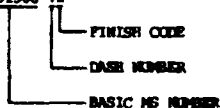
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5340

9. **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:**

P - RUST INHIBITOR TREATMENT.  
Z - ZINC COATED

EXAMPLE: MS51568-7Z



MS51568-7Z INDICATES TURNBUCKLE, SPREAD BODY, HOOK AND EYE END FULLS; .625-11 THREAD, 6-INCH CLEAR OPENING BETWEEN HEADS; ZINC COATED

**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

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

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P A. ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE  TURNBUCKLE, SPREAD BODY, HOOK AND EYE (TYPE I, FORM 2, CLASS 6)	MILITARY STANDARD
			MS51568
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