

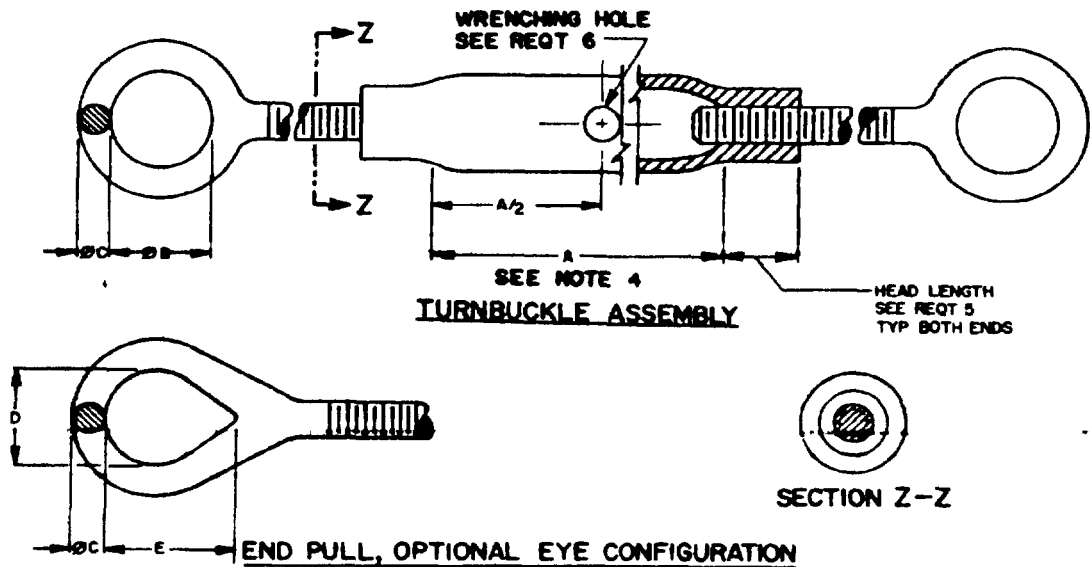
FED. SPEC. CLASS  
5340USER ACTIVITIES:  
ARMY - ME  
NAVY - AS, MC, OS, YDDEVELOPER ACTIVITIES:  
ARMY - CR  
AIR FORCE - 82  
DLA - IS

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	SIZE			
			Ø B MIN	Ø C MIN	D MIN	E MIN
1	.250-20	4	.500	.218	.344	.687
2	.3125-18	4.5	.625	.267	.437	.812
3	.375-16	6	.750	.344	.531	.937
4	.500-13	6	1.000	.437	.718	1.187
5		9				
6		12				
7	.625-11	6	1.250	.500	.875	1.375
8		9				
9		12				
10		18				
11	.750-10	6	1.500	.625	1.080	1.625
12		9				
13		12				
14		18				
15		24				
16	.875-9	12	1.750	.750	1.250	1.875
17		18				
18		24				
19	1.000-8	12	2.000	.875	1.437	2.250
20		18				
21		24				
22		36				

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Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

AMSC N/A

ARMY-AR Other Code NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, PIPE, BODY, EYE AND EYE (TYPE II, CLASS 4)	MILITARY STANDARD MS51570
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDES	PAGE 1 OF 3	

DD FORM 672-1 (COORDINATED)

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5340-1810

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FED SUP CLASS  
53 40

TABLE I DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	EYE			
			Ø B MIN	Ø C MIN	D MIN	E MIN
23 24 25 26	1.250-7	12 18 24 36	2.125	1.062	1.687	2.562
27 28 29 30 31	1.500-6	12 18 24 36 48	2.250	1.250	2.125	3.250
32 33 34 35	1.750-5	18 24 36 48	2.500	1.437	2.375	3.750
36 37 38	2.000-4.5	24 36 48	3.000	1.625	2.687	4.375
39 40 41	2.250-4.5	24 36 48	3.250	1.812	2.937	5.187
42 43 44	2.500-4	24 36 48	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**  
**BODY** - THE TURNBUCKLE BODY SHALL BE FABRICATED FROM A LENGTH OF PIPE, OF SUFFICIENT WALL THICKNESS, WITH THE HEAD AREA FORGED, SWAGED, SPUN, DRAWN OR UPSET TO THE PROPER DIAMETER TO OBTAIN THE SPECIFIED NOMINAL THREAD SIZE.  
**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.
- WRENCHING HOLE** THE WRENCHING HOLE IN THE BODY SHALL BE 1/4-INCH IN DIAMETER FOR SIZES UP TO AND INCLUDING .625 NOMINAL THREAD SIZE AND 1/2-INCH IN DIAMETER FOR SIZES LARGER THAN .625 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 II, WITH EYE 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.

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

REVIEWER 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, PIPE, BODY, EYE AND EYE (TYPE II, CLASS 4)	MILITARY STANDARD MS51570
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10. **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. MS51570-7Z

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  |
  |----- FINISH CODE
  |
  |----- DASH NUMBER
  |
  |----- BASIC MS NUMBER
  
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MS51570-7Z INDICATES: TURNBUCKLE, PIPE, EYE AND EYE ENDS 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.

USE ACTIVITIES:  
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 NAVY - AS, MC, DS, YD

REVIEWER ACTIVITIES:  
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