

FED. SUP. CLASS  
5340

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

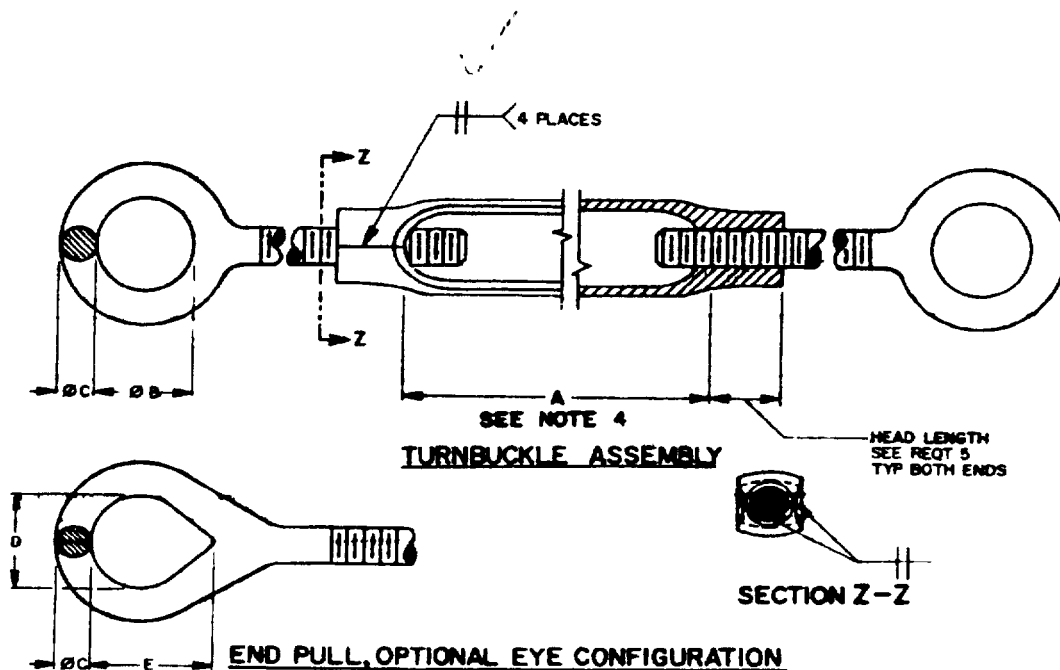


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	NOMINAL THREAD SIZE	A MIN	MIN			
			$\phi$ B MIN	$\phi$ C MIN	D MIN	E MIN
1	.750-20	4	.500	.218	.344	.687
2	.875-18	4.5	.625	.281	.437	.812
3	.975-16	6	.750	.344	.531	.937
4	.900-13	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	1.000	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				

APPROVED 16 FEB 1988 REVISED

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

U.S. ARMY - AR Other Code NAVY - SH AIR FORCE - 99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, FLAT BODY, EYE AND EYE (TYPE I, FORM 3, CLASS 4)	MILITARY STANDARD MS51571
PROCUREMENT SPECIFICATION FF-T-791	SUPersedes:	PAGE 1 OF 3	

AMSC N/A

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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	3.260
32 33 34 35	1.750-5	18 24 36 48	2.900	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 BY JOINING TWO FORMED PIECES OF MATERIAL BY EITHER THE FLASH OR UPSET WELDING PROCESS 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 I, FORM 3, 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

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U.S. ARMY-AR Other Govt NAVY-SH AIR FORCE-99	INTERNATIONAL INTEREST	TITLE TURNBUCKLE, FLAT BODY, EYE AND EYE (TYPE I, FORM 3, CLASS 4)	MILITARY STANDARD MS51571
PROCUREMENT SPECIFICATION FF-T-791	SUPERSEDES:	PAGE 2 OF 3	

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

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9. **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: MS51571-7Z

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      |
      |----- FINISH CODE
      |
      |----- DASH NUMBER
      |
      |----- BASIC MS NUMBER
  
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MS51571-7Z INDICATES: TURNBUCKLE, RESISTANCE WELD BODY, EYE AND EYE END PULLS;  
.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 THEREIN.
4. DIMENSION "A" IS THE TAKE UP LENGTH OR CLEAR OPENING INSIDE OF THE BODY.

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