

Review activities:
ARMY - MI, AV, GL
NAVY - SH, AT, ME
AIR FORCE - 82, II
NSA - NS
DLA - IS

User activities:
ARMY - ER, AT, ME
NAVY - MC

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FED. SUP CLASS
5307

TABLE I (COARSE THREAD NUT END)

DASH NO.	A NUT END THREAD UNJC-3A	B STUD END THREAD MOD MINOR DIA		C* ± .030	Ø D (GRIP DIA) ± .015	E ± .010	Ø F ± .010	G ± .020	H ± .010	Ø J ± .010	K ± .002	KEY DIMENSIONS		
	SIZE	SIZE	MINOR DIA ± .004									M ± .002	N ± .004	P ± .015
-101	.1640-32	.3125-18UNC-2A	.256 .249	.410	.163 .160	.312	.250	.030 .010	--	--	.223 .216	.068	.040	.130
-102	.1900-24	.3750-16UNC-2A	.320 .312	.410	.189 .186	.312	.310	.040 .020	.141	.070	.288 .281	.068	.040	.130
-103	.2500-20	.4375-14UNC-2A	.383 .375	.470	.249 .246	.375	.375	.040 .020	.156	.076	.349 .341	.068	.040	.190
-104	.3125-18	.5000-13UNC-2A	.440 .432	.530	.312 .309	.437	.430	.060 .030	.172	.076	.411 .403	.068	.040	.190
-105	.3750-16	.5625-12UNC-2A	.503 .495	.640	.374 .371	.500	.495	.060 .030	.172	.106	.473 .465	.068	.040	.190
-106	.4375-14	.6250-11UNC-2A	.565 .551	.660	.437 .433	.625	.550	.060 .030	.172	.106	.536 .528	.068	.040	.190
-107	.5000-13	.6875-11UNS-2A	.625 .615	.780	.499 .495	.688	.615	.060 .030	.172	.106	.598 .590	.068	.040	.190
-108	.5625-12	.8125-16UN-2A	.752 .744	.910	.562 .558	.812	.745	.060 .030	.220	.141	.724 .716	.068	.040	.190
-109	.6250-11	.8750-14UNF-2A	.815 .807	.950	.624 .620	.875	.805	.060 .030	.220	.141	.786 .778	.068	.040	.190
-110	.7500-10	1.1250-12UNF-2A	1.050 1.040	1.090	.749 .745	1.125	1.040	.090 .060	.220	.141	.980 .970	.103	.070	.250
-111	.8750-9	1.2500-12UNF-2A	1.175 1.165	1.250	.874 .870	1.250	1.165	.090 .060	.270	.141	1.105 1.095	.103	.070	.250
-112	1.0000-8	1.3750-12UNF-2A	1.300 1.290	1.370	.999 .993	1.375	1.290	.090 .060	.280	.141	1.230 1.220	.103	.070	.250

*THIS DIMENSION DOES NOT APPLY TO DASH NUMBERS IN TABLE III ABOVE THE HEAVY LINES.

(D) ENTIRE STANDARD REVISED

P.A. Other Cust AS 99	TITLE STUD, LOCKED IN - KEY LOCKED, HEAVY DUTY	MILITARY STANDARD MS 51834
PROCUREMENT SPECIFICATION MIL-S-45915	SUPERSEDES:	PAGE 1 OF 4

DD FORM 672-1 (Coordinated)
PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.
5307-0337

APPROVED 1 DEC 1967 REVISED A 25 NOV 1970 B 21 APRIL 1980 C 27 OCT 1980 D 7 DEC 84

User activities:
ARMY-ER, AT, ME
NAVY-MC

Review activities:
ARMY-MI, AV, GL
NAVY-SH
AIR FORCE - 82, II
NSA-NS
DLA-1S

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TABLE 11 (FINE THREAD NUT END)

FED. STD CLASS
5307

DASH NO.	A NUT END THREAD UNF-3A SIZE	B STUD END THREAD MOD MINOR DIA		C ▲.030	Ø D (GRIP DIA)	E ▲.015	Ø F ▲.010	G	H ±.020	Ø J ▲.010	K	KEY DIMENSIONS		
		SIZE	MINOR DIA									M ±.002	N ±.004	P ±.015
-201	.1640-36	.3125-18UNC-2A	.256 .249	.410	.163 .160	.312	.250	.030 .010	--	--	.223 .216	.068	.040	.130
-202	.1900-32	.3750-16UNC-2A	.320 .312	.410	.189 .186	.312	.310	.040 .020	.141	.070	.288 .280	.068	.040	.130
-203	.2500-28	.4375-14UNC-2A	.383 .375	.470	.249 .246	.375	.375	.040 .020	.156	.076	.349 .341	.068	.040	.190
-204	.3125-24	.5000-13UNC-2A	.440 .432	.530	.312 .309	.437	.430	.040 .030	.172	.076	.411 .403	.068	.040	.190
-205	.3750-24	.5625-12UNC-2A	.503 .495	.640	.374 .371	.500	.495	.040 .030	.172	.106	.473 .465	.068	.040	.190
-206	.4375-20	.6250-11UNC-2A	.565 .551	.660	.437 .433	.625	.550	.040 .030	.172	.106	.536 .528	.068	.040	.190
-207	.5000-20	.6875-11UNC-2A	.625 .615	.780	.499 .495	.688	.615	.040 .030	.172	.106	.598 .590	.068	.040	.190
-208	.5625-18	.8125-16UNC-2A	.752 .744	.910	.562 .558	.812	.745	.040 .030	.220	.141	.724 .716	.068	.040	.190
-209	.6250-18	.8750-14UNF-2A	.815 .807	.950	.624 .620	.875	.805	.040 .030	.220	.141	.786 .778	.068	.040	.190
-210	.7500-16	1.125-12UNF-2A	1.050 1.040	1.090	.749 .745	1.125	1.040	.090 .040	.220	.141	.980 .970	.103	.070	.230
-211	.8750-14	1.250-12UNF-2A	1.175 1.165	1.250	.874 .870	1.250	1.165	.090 .040	.270	.141	1.105 1.095	.103	.070	.230
-212	1.000-12	1.375-12UNF-2A	1.300 1.290	1.370	.999 .993	1.375	1.290	.090 .040	.280	.141	1.230 1.220	.103	.070	.230

REQUIREMENTS:

1. MATERIAL:

STEEL, CORROSION-RESISTANT, TYPE 303 (UNS S30300) IN ACCORDANCE WITH AMS 5640M-79 OR ASTM A582-80.

STEEL, ALLOY, GRADE 4140 (UNS G41400) IN ACCORDANCE WITH MIL-S-5626.

STEEL, CORROSION-RESISTANT, TYPE A286 (UNS S66286) IN ACCORDANCE WITH AMS 5734D-76.

LOCKING KEYS: STEEL, CORROSION-RESISTANT, TYPE 302 (UNS S30200) IN ACCORDANCE WITH QQ-W-423.

2. PROTECTIVE COATING OR TREATMENT:

ALLOY STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 3.

CORROSION-RESISTANT STEEL SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380-78.

3. SURFACE ROUGHNESS:

MACHINED SURFACES SHALL BE IN ACCORDANCE WITH ANSI B46.1-78, UNLESS OTHERWISE SPECIFIED. MACHINED SURFACES SHALL BE 125 MICROINCHES.

4. THREADS:

NUT END THREADS SHALL CONFORM TO MIL-S-8879. STUD END THREADS SHALL CONFORM TO FED-STD-H28/2 EXCEPT MINOR DIAMETERS SHALL BE MODIFIED AS SPECIFIED HEREIN.

P. A. Other Cust	AR AS 99	INTERNATIONAL INTEREST	TITLE STUD, LOCKED IN-KEY LOCKED, HEAVY DUTY	MILITARY STANDARD
				MS 51834
PROCUREMENT SPECIFICATION MIL-S-45915		SUPERSEDES		PAGE 2 OF 4

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5307-0337

APPROVED 1 DEC 1967 REVISED 1 FOR CHANGES SEE PAGES 1, 2, 3 AND 4

FED. SUP CLASS
5307User activities:
ARMY-ER, AT, ME
NAVY-MCReview activities:
ARMY-MJ, AV, GL
NAVY-SH
AIR FORCE - 82, 11
NSA-NS
DLA-IS

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5. HEAT TREATMENT: ALLOY STEEL STUDS, 4140 SHALL BE HEAT TREATED TO 160,000 PSI F_{tu} MINIMUM IN ACCORDANCE WITH MIL-H-6875, CORROSION-RESISTANT STEEL STUDS, A286 SHALL BE HEAT TREATED TO 140,000 PSI F_{tu} MINIMUM.
6. HARDNESS: ALLOY STEEL 4140 SHALL HAVE A HARDNESS RANGE OF 36-40 HRC.
7. PART NUMBER: THE MS PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBERS AND THE FOLLOWING AS APPLICABLE:

EXAMPLE: MS 51834 - 103 D 24

STUD, LOCKED IN-KEY LOCKED

1.500 LENGTH OF NUT END.
(SEE TABLE III)

DRILLED HOLE IN NUT END, USE "DASH" IN LIEU OF "D" IF DRILLED HOLE NOT REQUIRED

.2500-20 NUT END THREAD-.4375-14 STUD END THREAD.

MATERIAL: ALLOY STEEL, 4140
CRES, A286, ADD "A" IN LIEU OF DASH
CRES, 303, ADD "C" IN LIEU OF DASH

8. STUDS SHALL BE FREE FROM ALL HANGING BURRS AND SLIVERS WHICH MIGHT BECOME DISLODGED UNDER USAGE.
9. ALL DIMENSIONS ARE AFTER PROTECTIVE COATING OR TREATMENT.
10. TOLERANCE ON ANGLES IS $\pm 2^\circ$.
11. GRIP DIAMETER SHALL BE CONCENTRIC TO PITCH DIAMETER OF STUD END THREAD WITHIN .006 FIM.
12. STUDS WITH NUT END THREAD SIZE .1640, .1900 OR .2500 SHALL BE SUPPLIED WITH TWO (2) LOCKING KEYS SPACED 180° APART. ALL OTHER SIZES SHALL BE SUPPLIED WITH FOUR (4) LOCKING KEYS SPACED 90° APART.
13. MARKING: CRES 303 HAS NO IDENTIFYING MARK.
ALLOY STEEL 4140 SHALL BE IDENTIFIED ON TOP OF STUD BY TWO (2) PARALLEL DASH MARKS.
CRES A286 SHALL BE IDENTIFIED ON TOP OF STUD BY ONE DASH MARK.

NOTES:

- ALL DIMENSIONS ARE IN INCHES.
- INSTALLATION OF STUD SHALL BE IN ACCORDANCE WITH MS51835.
- FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
- REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.

P. A. Other Cont	AR AS 99	INTERNATIONAL INTEREST	TITLE STUD, LOCKED IN-KEY LOCKED, HEAVY DUTY	MILITARY STANDARD MS 51834
PROCUREMENT SPECIFICATION MIL-S-45915			SUPERSEDES	PAGE 3 OF 4

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TABLE III - TABULATED LENGTHS

L NUT END ± .030	LENGTH DASH NUMBER											
	NOMINAL DIA											
	.164	.190	.250	.3125	.375	.4375	.500	.5625	.625	.750	.875	1.000
.312	-5											
.375	-6	-6	-6									
.438	-7	-7	-7									
.500	-8	-8	-8	-8								
.562	-9	-9	-9	-9	-9							
.625	-10	-10	-10	-10	-10	-10						
.688	-11	-11	-11	-11	-11	-11						
.750	-12	-12	-12	-12	-12	-12	-12					
.812	-13	-13	-13	-13	-13	-13	-13	-13				
.875	-14	-14	-14	-14	-14	-14	-14	-14				
.938	-15	-15	-15	-15	-15	-15	-15	-15	-15			
1.000	-16	-16	-16	-16	-16	-16	-16	-16	-16			
1.062	-17	-17	-17	-17	-17	-17	-17	-17	-17			
1.125	-18	-18	-18	-18	-18	-18	-18	-18	-18	-18		
1.188	-19	-19	-19	-19	-19	-19	-19	-19	-19	-19		
1.250	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20	
1.312	-21	-21	-21	-21	-21	-21	-21	-21	-21	-21	-21	-21
1.375	-22	-22	-22	-22	-22	-22	-22	-22	-22	-22	-22	-22
1.438	-23	-23	-23	-23	-23	-23	-23	-23	-23	-23	-23	-23
1.500	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24
1.562	-25	-25	-25	-25	-25	-25	-25	-25	-25	-25	-25	-25
1.625	-26	-26	-26	-26	-26	-26	-26	-26	-26	-26	-26	-26
1.688	-27	-27	-27	-27	-27	-27	-27	-27	-27	-27	-27	-27
1.750	-28	-28	-28	-28	-28	-28	-28	-28	-28	-28	-28	-28
1.812	-29	-29	-29	-29	-29	-29	-29	-29	-29	-29	-29	-29
1.875	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30
1.938	-31	-31	-31	-31	-31	-31	-31	-31	-31	-31	-31	-31
2.000	-32	-32	-32	-32	-32	-32	-32	-32	-32	-32	-32	-32
2.125	-33	-33	-33	-33	-33	-33	-33	-33	-33	-33	-33	-33
2.250		-36	-36	-36	-36	-36	-36	-36	-36	-36	-36	-36
2.375		-38	-38	-38	-38	-38	-38	-38	-38	-38	-38	-38
2.500		-40	-40	-40	-40	-40	-40	-40	-40	-40	-40	-40
2.625		-42	-42	-42	-42	-42	-42	-42	-42	-42	-42	-42
2.750		-44	-44	-44	-44	-44	-44	-44	-44	-44	-44	-44
2.875		-46	-46	-46	-46	-46	-46	-46	-46	-46	-46	-46
3.000		-48	-48	-48	-48	-48	-48	-48	-48	-48	-48	-48
3.125		-50	-50	-50	-50	-50	-50	-50	-50	-50	-50	-50
3.250		-52	-52	-52	-52	-52	-52	-52	-52	-52	-52	-52
3.375		-54	-54	-54	-54	-54	-54	-54	-54	-54	-54	-54
3.500		-56	-56	-56	-56	-56	-56	-56	-56	-56	-56	-56
3.625		-58	-58	-58	-58	-58	-58	-58	-58	-58	-58	-58
3.750		-60	-60	-60	-60	-60	-60	-60	-60	-60	-60	-60
3.875		-62	-62	-62	-62	-62	-62	-62	-62	-62	-62	-62
4.000		-64	-64	-64	-64	-64	-64	-64	-64	-64	-64	-64

DASH NUMBERED PARTS ABOVE THE HEAVY LINE ARE THREADED TO THE STUD END AS SPECIFIED HEREIN. THE MAXIMUM DISTANCE FROM THE STUD END TO THE FIRST FULL THREAD SHALL BE EQUAL TO THE SUM OF THE MAXIMUM FILLET RADIUS AND A MAXIMUM OF TWO INCOMPLETE THREADS. INCOMPLETE THREADS NOT TO ENTER FILLET AREA.

P.A.	AR	TITLE	MILITARY STANDARD
Other Cust	AS	STUD LOCKED IN - KEY LOCKED, HEAVY DUTY	MS51834
99			
PROCUREMENT SPECIFICATION MIL-S-45915	SUPERSEDES:	PAGE	4 OF 4

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