

REVIEWER: MI, AT, ME, AV, IS, ASA
USER: EL, GL, ID, MC

FED. SUP CLASS
53GP

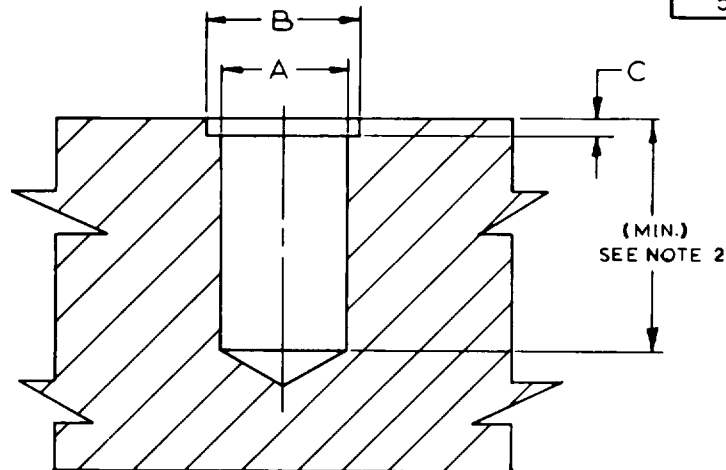


FIGURE I

1. AXIS OF HOLE TO BE NORMAL TO ENTRY SURFACE OR PROVIDE SPOTFACE WHEN REQUIRED.
2. MINIMUM HOLE DEPTH TO BE LENGTH OF INSERT PLUS .06.
3. SURFACE ROUGHNESS: UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES IN ACCORDANCE WITH USA STANDARD B46.1.
4. REMOVE ALL BURRS AND SHARP EDGES.
5. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES, LINEAR DIMENSIONS $\pm .005$.

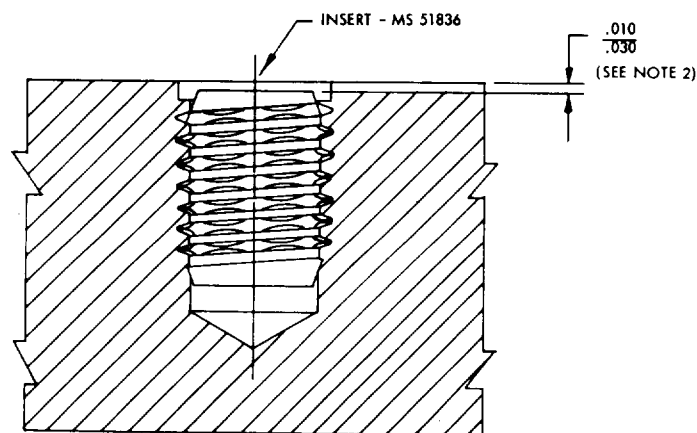


FIGURE II

1. HOLE PREPARATION IN ACCORDANCE WITH FIGURE I AND TABLE I.
2. INSTALL INSERT TO DEPTH SHOWN.
3. TYPICAL DRAWING CALLOUT TO BE LOCATED IN VICINITY OF PART IDENTIFICATION.

THIS IS A DESIGN STANDARD AND SHALL
NOT BE USED AS A PART NUMBER.

INSTALL INSERT IN ACCORDANCE WITH MS 51837.
INSERT VIEW

This military standard has been approved by the Department of Defense and is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

P.A. WC	TITLE	MILITARY STANDARD
Other Cust AS 82	INSERT, SCREW THREAD - THREAD FORMING HOLE DIMENSIONS FOR AND INSTALLATION OF	MS 51837
PROCUREMENT SPECIFICATION NOT APPLICABLE	SUPERSEDES:	SHEET 1 OF 2

DD FORM 1 SEP 57 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

APPROVED 1 DEC 1967 REVISED

FED. SUP CLASS
53GPTABLE I
DRILLED HOLE SIZES FOR MS 51836 INSERTS

NOMINAL INTERNAL THREAD SIZE (MS 51836) (REF)	GROUP A MATERIALS			GROUP B MATERIALS			GROUP C MATERIALS		
	A DIA	B DIA	C +.010	A DIA	B DIA	C +.010	A DIA	B DIA	C +.010
.086-56 .086-64	.121 .118	.162 .158	.020	.127 .124	.162 .158	.020	.127 .124	.162 .158	.020
.112-40 .112-48	.150 .146	.173 .169	.040	.162 .158	.180 .176	.040	.164 .160	.180 .176	.040
.138-32 .138-40	.191 .187	.216 .212	.040	.204 .200	.224 .220	.040	.209 .205	.224 .220	.040
.164-32 .164-36	.224 .220	.254 .249	.040	.240 .235	.265 .260	.040	.244 .239	.265 .260	.040
.190-24 .190-32	.243 .238	.285 .280	.050	.262 .257	.294 .289	.050	.264 .259	.294 .289	.050
.250-20 .250-28	.332 .327	.372 .367	.050	.348 .343	.379 .374	.050	.352 .347	.379 .374	.050
.3125-18 .3125-24	.403 .398	.472 .467	.050	.417 .412	.472 .467	.050	.425 .420	.472 .467	.050
.375-16 .375-24	.488 .483	.567 .562	.060	.521 .515	.568 .562	.060	.531 .526	.568 .562	.060

MATERIAL GROUPS: GROUP A - SOFT PLASTICS
 GROUP B - CAST ALUMINUM, MAGNESIUM AND HARD PLASTICS
 GROUP C - HIGH STRENGTH ALUMINUM ALLOYS (EXAMPLE: 2024-T4)

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P.A. WC Other Cust AS 82	TITLE INSERT, SCREW THREAD - THREAD FORMING HOLE DIMENSIONS FOR AND INSTALLATION OF	MILITARY STANDARD MS 51837
PROCUREMENT SPECIFICATION NOT APPLICABLE	SUPERSEDES	SHEET 2 OF

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APPROVED 1 DEC 1987 REVISED