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AMSC N/A

USER ACTIVITIES:

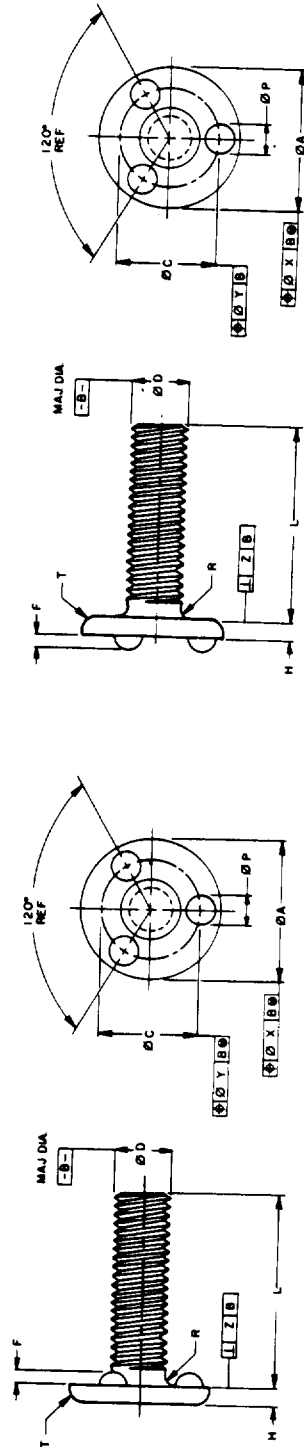
NSA-NS

REVIEWER ACTIVITIES:

ARMY-AT

AIR FORCE-82

DLA-IS



**TYPE B**

**TYPE A**

**(A) ENTIRE STANDARD REVISED**

P.A. ARMY-AR	INTERNATIONAL INTEREST	TITLE
Other Cust		BOLT, WELDING-COARSE THREAD
AIR FORCE-99		
PROCUREMENT SPECIFICATION	SUPERSEDES	
NONE		BAWX1 IN PART AND BAWX2 IN PART
		PAGE 1 OF 2
		MILITARY STANDARD MS 51934

TABLE 1. DASH NUMBERS AND DIMENSIONS

	TYPE A					TYPE B				
	32 UNC-2A	24 UNC-2A	18 UNC-2A	16 UNC-2A	13 UNC-2A	32 UNC-2A	24 UNC-2A	18 UNC-2A	16 UNC-2A	13 UNC-2A
THREADS PER INCH	32	24	18	16	13	32	24	18	16	13
MINOR DIA	.1372	.1571	.1818	.2049	.2489	.1372	.1571	.1818	.2049	.2489
Ø A	.1372	.1571	.1818	.2049	.2489	.1372	.1571	.1818	.2049	.2489
Ø C	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
Ø P	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
Ø D	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
F	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
H	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
R	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
T	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
X	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
Z	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
L LENGTH/	.0449	.0750	.0975	.1175	.1500	.0449	.0750	.0975	.1175	.1500
DASH NUMBERS	32	24	18	16	13	32	24	18	16	13
1/2	32	24	18	16	13	32	24	18	16	13
3/4	32	24	18	16	13	32	24	18	16	13
1	32	24	18	16	13	32	24	18	16	13
1 1/2	32	24	18	16	13	32	24	18	16	13
2	32	24	18	16	13	32	24	18	16	13
2 1/2	32	24	18	16	13	32	24	18	16	13
3	32	24	18	16	13	32	24	18	16	13
3 1/2	32	24	18	16	13	32	24	18	16	13
4	32	24	18	16	13	32	24	18	16	13
4 1/2	32	24	18	16	13	32	24	18	16	13
5	32	24	18	16	13	32	24	18	16	13
5 1/2	32	24	18	16	13	32	24	18	16	13
6	32	24	18	16	13	32	24	18	16	13
6 1/2	32	24	18	16	13	32	24	18	16	13
7	32	24	18	16	13	32	24	18	16	13
7 1/2	32	24	18	16	13	32	24	18	16	13
8	32	24	18	16	13	32	24	18	16	13
8 1/2	32	24	18	16	13	32	24	18	16	13
9	32	24	18	16	13	32	24	18	16	13
9 1/2	32	24	18	16	13	32	24	18	16	13
10	32	24	18	16	13	32	24	18	16	13
10 1/2	32	24	18	16	13	32	24	18	16	13
11	32	24	18	16	13	32	24	18	16	13
11 1/2	32	24	18	16	13	32	24	18	16	13
12	32	24	18	16	13	32	24	18	16	13
12 1/2	32	24	18	16	13	32	24	18	16	13
13	32	24	18	16	13	32	24	18	16	13
13 1/2	32	24	18	16	13	32	24	18	16	13
14	32	24	18	16	13	32	24	18	16	13
14 1/2	32	24	18	16	13	32	24	18	16	13
15	32	24	18	16	13	32	24	18	16	13
15 1/2	32	24	18	16	13	32	24	18	16	13
16	32	24	18	16	13	32	24	18	16	13
16 1/2	32	24	18	16	13	32	24	18	16	13
17	32	24	18	16	13	32	24	18	16	13
17 1/2	32	24	18	16	13	32	24	18	16	13
18	32	24	18	16	13	32	24	18	16	13
18 1/2	32	24	18	16	13	32	24	18	16	13
19	32	24	18	16	13	32	24	18	16	13
19 1/2	32	24	18	16	13	32	24	18	16	13
20	32	24	18	16	13	32	24	18	16	13
20 1/2	32	24	18	16	13	32	24	18	16	13
21	32	24	18	16	13	32	24	18	16	13
21 1/2	32	24	18	16	13	32	24	18	16	13
22	32	24	18	16	13	32	24	18	16	13
22 1/2	32	24	18	16	13	32	24	18	16	13
23	32	24	18	16	13	32	24	18	16	13
23 1/2	32	24	18	16	13	32	24	18	16	13
24	32	24	18	16	13	32	24	18	16	13
24 1/2	32	24	18	16	13	32	24	18	16	13
25	32	24	18	16	13	32	24	18	16	13
25 1/2	32	24	18	16	13	32	24	18	16	13
26	32	24	18	16	13	32	24	18	16	13
26 1/2	32	24	18	16	13	32	24	18	16	13
27	32	24	18	16	13	32	24	18	16	13
27 1/2	32	24	18	16	13	32	24	18	16	13
28	32	24	18	16	13	32	24	18	16	13
28 1/2	32	24	18	16	13	32	24	18	16	13
29	32	24	18	16	13	32	24	18	16	13
29 1/2	32	24	18	16	13	32	24	18	16	13
30	32	24	18	16	13	32	24	18	16	13
30 1/2	32	24	18	16	13	32	24	18	16	13
31	32	24	18	16	13	32	24	18	16	13
31 1/2	32	24	18	16	13	32	24	18	16	13
32	32	24	18	16	13	32	24	18	16	13

1/2 TOLERANCE +.015, -0  
TOLERANCE +0, -.011 THRU 1"; +0, -.125 OVER 1".

APPROVED 5 APR 63 REVISED (A) 17 AUG 87

5306-1103

050914

FED SUP CLASS  
5306

## REQUIREMENTS:

1. **MATERIAL:** BOLT SIZES .138; 164 AND .190 SHALL BE STEEL GRADE C1010 (UNS G10100), IN ACCORDANCE WITH ASTM A545.  
BOLT SIZES .250 AND LARGER SHALL BE STEEL GRADE C1015 (UNS G10150), IN ACCORDANCE WITH ASTM A108.
2. **PROTECTIVE COATING AND SURFACE TREATMENT:** UNCOATED. (NONE)
3. **THREADS:** THREADS SHALL BE IN ACCORDANCE WITH FED STD H28/2 ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD H28/20, SYSTEM 21. BOLT SHALL BE THREADED AS CLOSE TO THE HEAD AS PRACTICABLE.
4. **TENSILE STRENGTH:** TENSILE STRENGTH SHALL BE 60,000 PSI MINIMUM.
5. **MARKING:** MANUFACTURER'S IDENTIFICATION MARKING SHALL BE IN ACCORDANCE WITH MIL-STD-130.
6. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS1934-23

└── DASH NUMBER  
└── BASIC MS NUMBER

MS1934-23 INDICATES: BOLT, WELDING-COARSE THREAD; .250-20 UNC-2A, TYPE A; LENGTH 1 INCH.

## NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. SLIGHT RADIUS IS PERMISSIBLE AT JUNCTION OF PROJECTIONS AND WELDING SURFACE.
3. 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.
4. 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.

USER ACTIVITIES:  
NSA-NSREVIEWER ACTIVITIES:  
ARMY-AT  
AIR FORCE-82  
DLA-IS

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P.A. <b>ARMY-AR</b> Other Cast	INTERNATIONAL INTEREST	TITLE <b>BOLT, WELDING-COARSE THREAD</b>	<b>MILITARY STANDARD</b>
<b>AIR FORCE-99</b>			<b>MS 51934</b>
PROCUREMENT SPECIFICATION <b>NONE</b>	SUPERSEDES	<b>BAWXI IN PART AND BAWX2 IN PART</b>	PAGE 2 OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1103

APPROVED 5 APR 63 REVISED (A) FOR CHANGES SEE PAGES 1 AND 2