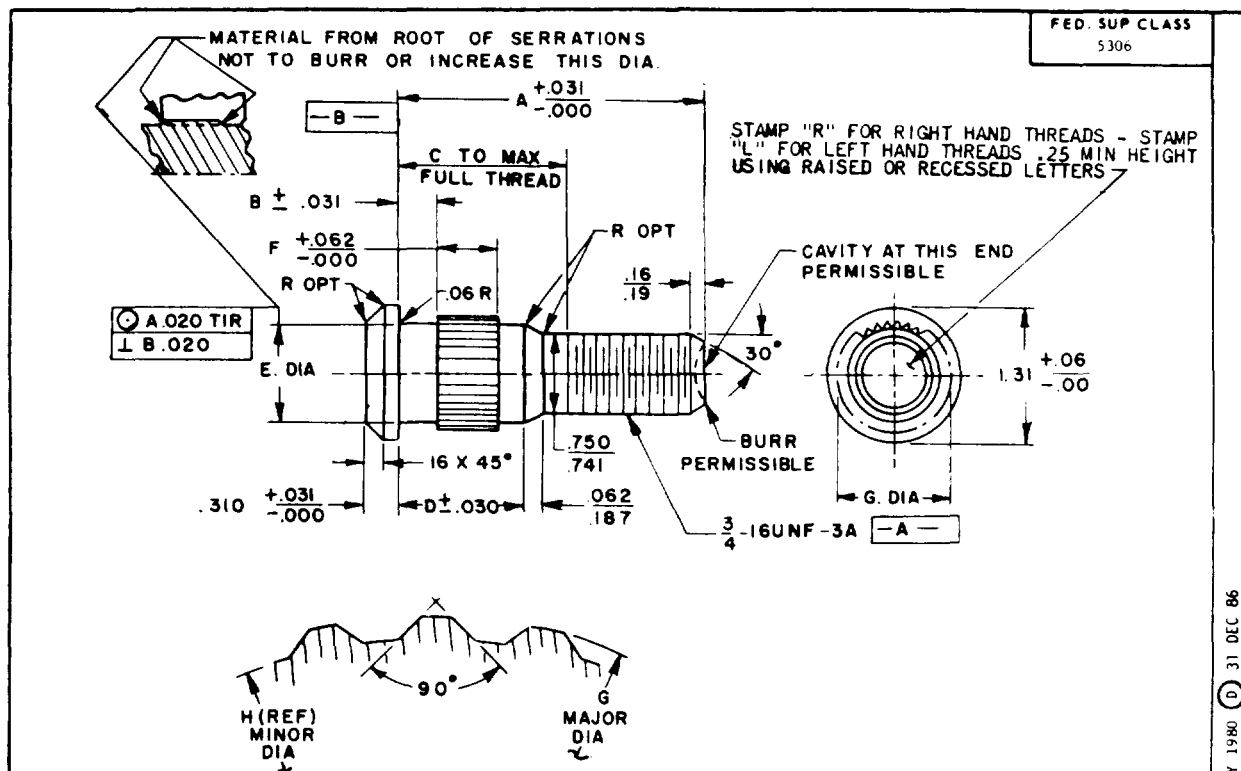


REVIEW ACTIVITY: DLA-IS  
USER ACTIVITY: ARMY-ME



MS PART NO.	FORMER PART NO.	A	B	C	D	E +.005 -.000	F	G +.005	H REF.	PITCH	SERRATION	THREAD
MS 51946-1	7339239	2.47	.125	1.41	.88	.835	.625	.881	.824	35/70	29-31	LH
MS 51946-2	7339238	2.47	.125	1.41	.88	.835	.625	.881	.824			RH
MS 51946-9	7339238-2	3.219	.125	1.41	.88	.835	.625	.881	.824	35/70	29-31	LH
MS 51946-10	7339238-1	3.219	.125	1.41	.88	.835	.625	.881	.824			RH
MS 51946-3	7521660	2.56	.28	1.39	.94	.971	.56	1.003	.946	37/74	35-37	LH
MS 51946-4	7521661	2.56	.28	1.39	.94	.971	.56	1.003	.946			RH
MS 51946-5	7409554	2.81	.38	1.62	1.19	.971	.56	1.003	.946	37/74	35-37	LH
MS 51946-6	7409555	2.81	.38	1.62	1.19	.971	.56	1.003	.946			RH
MS 51946-7	7411179	4.19	.38	3.00	2.69	.971	.56	1.003	.946	37/74	35-37	LH
MS 51946-8	7411180	4.19	.38	3.00	2.69	.971	.56	1.003	.946			RH
MS 51946-11	8333780	1.437	.187	.883	0.60	.835	.25	.875	.800	30/60	24-26	RH

- REQUIREMENTS:
1. MATERIAL: STEEL ALLOY 4135, 4137, 4140, 8637, 8640, 8740, PER ASTM-A-322, ASTM-A-331, ASTM-A-547, OR MIL-S-46172, GRADE D.
  2. HEAT TREAT: HARDEN AND TEMPER TO CORE HARDNESS OF BRINELL 255-321. RESTORE SURFACE CARBON IF NECESSARY TO PRODUCE A SURFACE HARDNESS RANGE OF 15N78-84 OR EQUIVALENT. DEPTH OF SURFACE HARDNESS: .004 TO .012. HEAT TREATMENT SHALL NOT BE ACCOMPLISHED IN THE PRESENCE OF NITROGEN COMPOUNDS.
  3. PROTECTIVE FINISH: ZINC PLATE PER TYPE 11 CLASS FE/ZNS OF ASTM B 633 OR TYPE 11 CLASS 3 OF MIL-C-81562. HYDROGEN EMBRITTLEMENT RELIEF REQUIRED WITHIN FOUR HOURS AFTER PLATING.
  4. SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH ANSI B46.1-1978.
  5. SCREW THREADS AND DIAMETER E SHALL HAVE A SURFACE FINISH OF 63 MICRO INCHES, AND ALL OTHER SURFACES 125 MICRO INCHES.
  6. SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2.
  7. MARKING SHALL CONSIST OF THE MS PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH MIL-STD-130.

- NOTES:
1. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE  $\pm .01$  ON DECIMALS,  $\pm 1^\circ$  ON ANGULAR DIMENSIONS. THIS STANDARD IS NOT INTENDED TO LIMIT CONSTRUCTION TO FEATURES OTHER THAN AS SHOWN HEREON BY DIMENSIONS, NOTATIONS, AND REFERENCED DOCUMENTS.
  2. REFERENCED 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.
  3. THE USE OF RECYCLED MATERIALS WHICH MEET THE REQUIREMENTS OF THE APPLICABLE MATERIAL SPECIFICATIONS WITHOUT JEOPARDIZING THE INTENDED USE OF THE ITEM SHALL BE ENCOURAGED.
  4. 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.
- (D) DENOTES CHANGES

P. A. ARMY-AT Other Cust	TITLE <b>BOLT, RIBBED SHOULDER; SPLINED, 3/4 INCH</b>	<b>MILITARY STANDARD</b> <b>MS51946(AT)</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES	SHEET OF 1

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