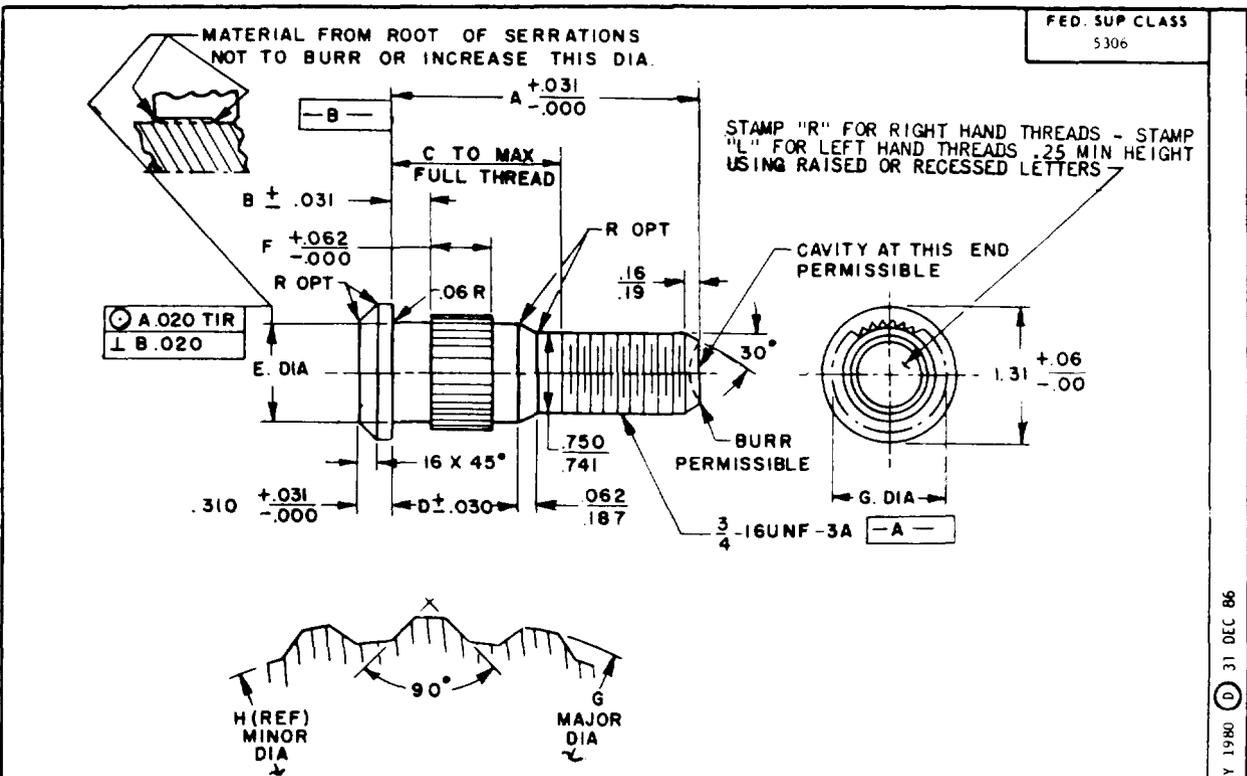


REVIEW ACTIVITY: DLA-IS
USER ACTIVITY: ARMY-ME



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	1.487	.187	.883	0.60	.835	.25	.875	.800	30/60	24-26	RH

- REQUIREMENTS:
- 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
 - 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.
 - PROTECTIVE FINISH: ZINC PLATE PER TYPE II CLASS FE/ZNS OF ASTM B 633 OR TYPE II CLASS 3 OF MIL-C-81562. HYDROGEN EMBRITTLEMENT RELIEF REQUIRED WITHIN FOUR HOURS AFTER PLATING.
 - SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH ANSI B46.1-1978.
 - SCREW THREADS AND DIAMETER E SHALL HAVE A SURFACE FINISH OF 63 MICRO INCHES, AND ALL OTHER SURFACES 125 MICRO INCHES.
 - SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2.
 - MARKING SHALL CONSIST OF THE MS PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH MIL-STD-130.
- NOTES:
- DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE ±.01 ON DECIMALS, ±1° ON ANGULAR DIMENSIONS. THIS STANDARD IS NOT INTENDED TO LIMIT CONSTRUCTION TO FEATURES OTHER THAN AS SHOWN HEREON BY DIMENSIONS, NOTATIONS, AND REFERENCED DOCUMENTS.
 - 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.
 - 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.
 - 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.
- Ⓧ DENOTES CHANGES

This military standard is approved for use by the US Army Tank-Automotive Command, Department of the Army, and is available for use by all Departments and Agencies of the Department of Defense. AMSC N/A
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P. A. ARMY-AT	TITLE	BOLT, RIBBED SHOULDER; SPLINED, 3/4 INCH		MILITARY STANDARD
Other Cust				MS51946(AT)
PROCUREMENT SPECIFICATION	SUPERSEDES	SHEET	OF	1
NONE				

APPROVED 8 AUGUST 1963 REVISED (A) 21 DECEMBER 1970 (B) 8 FEBRUARY 1972 (C) 10 JULY 1980 (D) 31 DEC 86