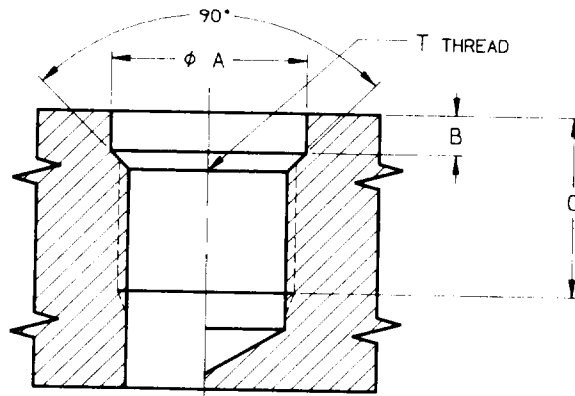


FED SUP CLASS
530P

REQUIREMENTS:

1. DIAMETER "A" AND MINOR DIAMETER OF THREAD TO BE CONCENTRIC WITHIN .003 FIM.
2. AXIS OF HOLE TO BE NORMAL TO ENTRY SURFACE OR PROVIDE SPOTFACE WHEN REQUIRED.
3. THREAD AS SHOWN PER MIL-8-8879 IS PREFERRED. ALTERNATE THREAD PER MIL-8-7742 CLASS 3B OR NATIONAL CLASS 3 IS ACCEPTABLE WHEN SPECIFIED BY DESIGN ACTIVITY.
4. UNLESS OTHERWISE SPECIFIED MACHINED SURFACES TO BE 125 MICROINCHES IN ACCORDANCE WITH ANSI/ASME B46.1.
5. REMOVE ALL BURRS AND SHARP EDGES.
6. TOLERANCES FOR LINEAR DIMENSIONS $\pm .005$, ANGULAR DIMENSIONS $\pm 5^\circ$.

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. PROCEDURE AND INSTALLATION OF RING LOCKED INSERTS, STUDS AND LOCKRINGS, SEE MSS1995.
3. GENERAL USE: FOR INSTALLATION OF RING LOCKED INSERTS (TABLE I) AND STUDS (TABLE II).
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.
5. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DDISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.

TABLE I - INSERT MSS1991

INSERT DASH NUMBER MSS1991	T THREAD CLASS 3B (SEE REQT 3)	ϕA +.003 -.000		B +.030 -.000	C MIN FULL THREAD DEPTH
		AL	MAG		
102 & 202	0.1900-24UNJC	.250	.258	.094	.285
103 & 203	0.2160-24UNJC	.281	.291	.109	.345
104 & 204	0.2500-20UNJC	.328	.337	.109	.415
105 & 205	0.3125-18UNJC	.375	.381	.141	.475
106 & 206	0.3750-16UNJC	.437	.448	.156	.535
107 & 207	0.5000-13UNJC	.515	.526	.172	.595
108 & 208	0.5625-12UNJC	.593	.601	.172	.655
109 & 209	0.6250-11UNJC	.734	.747	.218	.725
110 & 210	0.7500-10UNJC	.875	.888	.203	.785
311	0.8750-14UNJF	1.000	1.015	.203	.915
312.1	1.0000-12UNJF	1.125	1.139	.203	1.035
312	1.0000-14UNJS	1.125	1.139	.203	1.035
313	1.1250-12UNJF	1.281	1.298	.219	1.155
314	1.2500-12UNJF	1.406	1.427	.219	1.285
315	1.3750-12UNJF	1.562	1.579	.219	1.415

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

(A) ENTIRE STANDARD REVISED

P A Other Cust	AR AS 99	INTERNATIONAL INTEREST	TITLE HOLE PREPARATION- RING LOCKED INSERTS AND STUDS, STANDARD DIMENSIONS FOR	MILITARY STANDARD MS51994
PROCUREMENT SPECIFICATION NOT APPLICABLE		SUPERSEDES		PAGE 1 OF 2

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User activities:
Army - MI
Navy - MC, OSReview activities:
Army - AT, AV, ER, GL
Air Force - 11, 82
NSA - NS
DLA - IS

AMSC N/A

DD FORM 672-1 (COORDINATED)

530P-0199

APPROVED 17 AUG 66 REVISED (A) 12 FEB 88

FED. SUP. CLASS
53GP

TABLE II, STUD MS51551 & MS51989

STUD DASH NUMBER (REF)		T THREAD CLASS 3B (SEE REQ'T 3)	ϕ A +.003 -.000 AL MAG		B +.030 -.000	MIN FULL THREAD DEPTH			
						MS51551			MS51989 DASH 100 THRU 400 SERIES
						DASH 100 & 200 SERIES	DASH 100A & 200A SERIES	DASH 100B & 200B SERIES	
MS51551	MS51989								
----	102 302	0.1640-32UNJC	.250	.258	.094	----	----	----	.285
----	202 402	0.1640-36UNJF							
103 103A, 103B	103 303	0.1900-24UNJC	.281	.291	.109	.415	.535	.655	.415
203 203A, 203B	203 403	0.1900-32UNJF							
104 104A, 104B	104 304	0.2500-20UNJC	.328	.337	.109	.475	.595	.725	.475
204 204A, 204B	204 404	0.2500-28UNJF							
105 105A, 105B	105 305	0.3125-18UNJC	.375	.381	.141	.595	.725	.845	.595
205 205A, 205B	205 405	0.3125-24UNJF							
106 106A, 106B	106 306	0.3750-16UNJC	.437	.448	.156	.725	.915	1.095	.725
206 206A, 206B	206 406	0.3750-24UNJF							
107 107A, 107B	107 307	0.4375-14UNJC	.515	.526	.172	.785	.975	1.155	.785
207 207A, 207B	207 407	0.4375-20UNJF							
108 108A, 108B	108 308	0.5000-13UNJC	.593	.601	.172	.845	1.035	1.225	.845
208 208A, 208B	208 408	0.5000-20UNJF							
109 109A, 109B	109 309	0.5625-12UNJC	.734	.747	.188	.915	1.095	1.345	.915
209 209A, 209B	209 409	0.5625-18UNJF							
----	110 310	0.6250-11UNJC	.734	.747	.188	----	----	----	1.035
----	210 410	0.6250-18UNJF							
----	111 311	0.7500-10UNJC	.875	.888	.203	----	----	----	1.155
----	211 411	0.7500-16UNJF							
----	112 312	0.8750-9UNJC	1.000	1.015	.203	----	----	----	1.345
----	212 412	0.8750-14UNJF							

REVISED (A) FOR CHANGES SEE PAGES 1 AND 2
APPROVED 17 AUG 66

PA AR	INTERNATIONAL INTEREST	TITLE HOLE PREPARATION- RING LOCKED INSERTS AND STUDS, STANDARD DIMENSIONS FOR	MILITARY STANDARD
Other Cust AS 99			MS51994
PROCUREMENT SPECIFICATION NOT APPLICABLE	SUPERSEDES	PAGE 2 OF 2	

DD FORM 672-1

53GP-0199

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