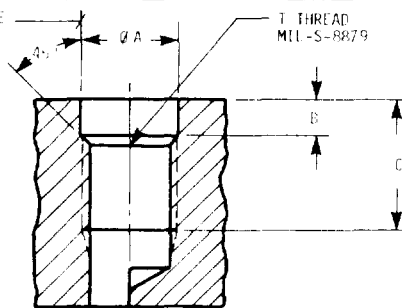


User activities:
Army - M1
Navy - MC, OS

Review activities:
Army - AI, AV, ER, GL
Air Force - 11, 82
NSA - NS
DLA - IS

This military standard is approved 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, when applicable.

TAP MARKS PERMISSIBLE
IN CORE AREA



FED. SUP CLASS
53GP

NOMINAL EXTERNAL THREAD SIZE OF INSERT AND STUD END THREAD SIZE OF STUD	INSERT DASH NUMBER MS51993	INSERT DASH NUMBER MS51498	STUD DASH NUMBER MS51992	STUD DASH NUMBER MS51497	T THREAD CLASS 3B INSERT AND STUD	Ø A INSERT AND STUD +.005 -.000	B INSERT AND STUD +.015 -.000	C MIN FULL THREAD DEPTH			
								INSERT		STUD	
								MS51993	MS51498	MS51992	MS51497
.3125-18	----	----	----	----	.3125-18UNJC	.328	.112	----	----	.561	----
			-802							.436	
			-502							.483	
.3125-24	----	----	-642	----	.3125-24UNJF	.328	.112	----	----		----
.3750-16		----	----	----	.3750-16UNJC	.390	.122		----	.723	----
	-803		-803					.588		.536	.436
	-503		-503	-502				.450		.608	.483
.3750-24	-643	----	-643	-642	.3750-24UNJF	.390	.122	.498	----	.561	
			-802								
.4375-14		----	----	----	.4375-14UNJC	.453	.151		----		----
	-804		-804					.781		.918	
	-504	-503	-504	-503				.592	.450	.677	.536
.4375-20	-644	----	-644	-643	.4375-20UNJF	.453	.151	.666	.498	.775	.608
		-802	-803					.588		.723	
.5000-13		----	----	----	.5000-13UNJC	.515	.174		----	1.126	----
	-805		-805					.982		.812	.677
	-505	-504	-505	-504				.728	.592	.943	.775
.5000-20	-645	----	-645	-644	.5000-20UNJF	.515	.174	.826	.666	.918	
		-804	-804					.781			
.6250-11		----	----	----	.6250-11UNJC	.625	.174		----	1.206	----
	-806		-806					1.111		.858	.812
	-506	-505	-506	-505				.800	.728	.998	.943
.6250-18	-646	----	-646	-645	.6250-18UNJF	.625	.174	.922	.826	1.126	
		-805	-805					.982			
.7500-10		----	----	----	.7500-10UNJC	.750	.178		----	1.317	----
	-807		-807					1.206		.933	.858
	-507	-506	-507	-506				.863	.800	1.088	.998
.7500-16	-647	----	-647	-646	.7500-16UNJF	.750	.178	.998	.922	1.206	
		-806	-806					1.111			
.8750-9		----	----	----	.8750-9UNJC	.875	.230		----	1.706	----
	-808		-808					1.383		1.203	.933
	-508	-507	-508	-507				.998	.863	1.414	1.088
.8750-14	-648	----	-648	-647	.8750-14UNJF	.875	.230	1.151	.998	1.317	
		-807	-807					1.205		1.203	
	-508	-508	-508					.998		1.414	
1.0000-12	----	----	----	-648	1.0000-12UNJF	1.000	.230	----	1.151	----	1.706
		-808	-808					1.383			

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. Unless otherwise specified machined surfaces to be 125 microinches in accordance with ANSI B46.1.
4. Remove all burrs and sharp edges.
5. Tolerances for linear dimension $\pm .005$, angular dimensions $\pm 5^\circ$.

NOTES:

1. Dimensions are in inches.
2. Procedure and installation of ring locked inserts, studs, and lockrings, see MS51995.
3. Nominal use: For installation of ring locked inserts and studs, high strength.
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 (DoDISS) specified in the solicitation form a part of this standard to the extent specified herein.

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

Ⓐ ENTIRE STANDARD REVISED

P. A.	AR	INTERNATIONAL INTEREST	TITLE HOLE PREPARATION- RING LOCKED INSERTS AND STUDS, HIGH STRENGTH, STANDARD DIMENSIONS FOR	MILITARY STANDARD
Other Cust	AS			MS51996
99				
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:			PAGE 1 OF 1

DD FORM 672-1 (COORDINATED)

THE VALUES SHOWN IN THIS FORM ARE IN INCHES

53GP-0148

APPROVED 12 DEC 67
REVISED Ⓐ 11 MAR 85