

CAVITY AT THIS END PERMISSIBLE

STAMP "R" FOR RIGHT HAND THREAD
STAMP "L" FOR LEFT HAND THREAD
USING RAISED OR RECESSED LETTERS
.25 MINIMUM HEIGHT

2.219

.295
.275

55° 40°

.53

.7025R

1.031 DIA

1.195 DIA

.04 R

.875 R

.03 R

.03 FLAT OPTIONAL

1 1/8 -16 UN-2A

A.012 TIR

3/4-16 UNF-2B

1/2 DRILL PERMISSIBLE
(FOR CHIP CLEARANCE)

BURR PERMISSIBLE
.09 X 45°

1.00

.78 DIA

10°

.25 +.06
-.00

.44

1.25

1.41 +.03
-.00

1.88 MAX

MIN FULL THREAD

RUNOUT BETWEEN BALL SEAT AND THREADS NOT TO EXCEED .007 T.I.R.

-A-

MS PART NO.	THREAD	FORMER PART NO.
MS53068-1	LEFT HAND	10896739-1
MS53068-2	RIGHT HAND	10896739-2

- MATERIAL:
- A. ALLOY STEEL: STEEL ALLOY 4135, 4137, 4140, 5135, 5140, 8637, 8640, PER ASTM A322, A331, ASTM A545, A546, A547, A548, OR A549, OR MIL-S-46172. HARDEN AND TEMPER TO CORE HARDNESS OF BRINELL 223-277; RESTORE SURFACE CARBON, IF NECESSARY, TO PRODUCE A SURFACE HARDNESS OF 15N-78-84, OR EQUIVALENT.
- B. CARBON STEEL: SHALL CONFORM TO CHEMICAL COMPOSITION LIMITS SPECIFIED FOR GRADE 5 NUT IN SAE STANDARD J995, WITH THE EXCEPTION THAT MAXIMUM CARBON SHALL BE 0.35 PER CENT. CASE HARDEN 0.003 TO 0.008 DEEP. SURFACE HARDNESS ROCKWELL 15N-88-90 OR FILE HARD .55 PER SAE J864. 3/4 SIZE SHALL HAVE 45,000 LB MINIMUM PROOF LOAD: 1 1/8 SIZE SHALL HAVE 93,000 LB MINIMUM PROOF LOAD. PROOF LOAD STRESSES SHALL BE TESTED PER SAE STANDARD J995 OR ASTM A370.
- PROTECTIVE FINISH: ZINC PLATE PER QQ-Z-325, TYPE II, CLASS 2, EXCEPT THREADS WHICH ARE NOT FULLY PLATED, OR CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, HYDROGEN EMBRITTLEMENT RELIEF REQUIRED WITHIN ONE HOUR AFTER PLATING.
- THREADS SHALL BE IN ACCORDANCE WITH SCREW THREAD STANDARDS FOR FEDERAL SERVICES, HANDBOOK H28.
- UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE $\pm .010$ ON DECIMALS, $\pm 1^\circ$ ON ANGULAR DIMENSIONS.
- MARKING SHALL CONSIST OF THE MS PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH MIL-STD-120.

1. DIMENSIONS ARE IN INCHES.
2. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS, OR REQUEST FOR PROPOSAL EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF ISSUE ADOPTED.
3. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
4. THE MS PART NUMBER CONSISTS OF THE MS NUMBER, PLUS THE DASH NUMBER.
5. THE USE OF RECYCLED MATERIALS WHICH MEET THE REQUIREMENTS OF THE APPLICABLE MATERIAL SPECIFICATIONS WITHOUT JEOPARDISING THE INTENDED USE OF THE ITEM SHALL BE ENCOURAGED.

© DENOTES CHANGES

P.A. ARMY - AT	TITLE	MILITARY STANDARD
Other Cust 99	NUT,CAP,DUAL WHEEL MOUNTING	MS53068
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1