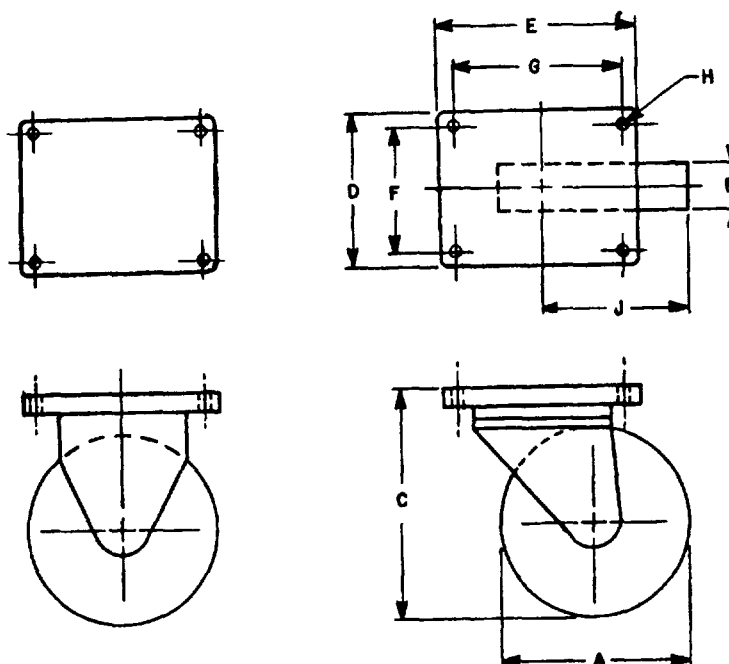


FED. SUP CLASS  
5340USER ACTIVITIES:  
ARMY - CE, GL, MEREVIEWER ACTIVITIES:  
DLA - IS

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RIGID

SWIVEL

## REQUIREMENTS:

1. MATERIAL. CASTERS IN ALL CLASSES SHALL BE MADE FROM STEEL, CAST IRON OR ALUMINUM. THE MOUNTING PLATE SHALL BE MADE OF FORGED OR FLAT ROLLED SHEET STEEL NOT LESS THAN 0.170 IN. THICK, WITH NO SHARP CORNERS.
2. FINISH. EXCEPT FOR ALUMINUM, EXTERIOR METAL SURFACES OF THE CASTERS SHALL BE CADMIUM PLATED OR ZINC COATED. CASTERS SHALL ALSO BE PAINTED, LACQUERED OR ENAMELED WHEN SPECIFIED.
3. THREADS. THREADS FOR AXLE BOLTS AND NUTS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2.
4. TYPES. TYPE I, RIGID CASTERS OF THIS TYPE SHALL CONSIST OF A NON-SWIVELING CASTER ASSEMBLY AND A WHEEL ASSEMBLY IN ACCORDANCE WITH FF-C-88C. TYPE II, SWIVEL CASTERS OF THIS TYPE SHALL CONSIST OF A FLAT MOUNTING PLATE, A SWIVEL ASSEMBLY, A HORN ASSEMBLY AND WHEEL ASSEMBLY IN ACCORDANCE WITH FF-C-88C.
5. TOLERANCES MOUNTING PLATE OVERALL SIZE  $\pm .25$ .  
HOLE SPACING - LIGHT DUTY, LIGHT MEDIUM DUTY  $\pm .016$ .  
MEDIUM DUTY, HEAVY MEDIUM DUTY  $\pm .031$ .  
HEAVY DUTY  $\pm .062$ .  
OVERALL HEIGHT - WHEEL DIAMETER 2" TO 5"  $\pm .062$ .  
WHEEL DIAMETER 6" TO 8"  $\pm .125$ .  
WHEEL DIAMETER 10" TO 12"  $\pm .250$ .  
MOUNTING BOLT DIAMETER - NORMAL COMMERCIAL TOLERANCES.
6. PART NUMBER. THE PART NUMBER CONSISTS OF THE BASIC MS SHEET NUMBER FOLLOWED BY THE CASTER TYPE CODE, WHEEL STYLE CODE AND A DASH NUMBER TAKEN FROM TABLE I.

EXAMPLE: MS87968R102

DASH NUMBER

WHEEL STYLE CODE

- 1 - PLASTIC, HARD TREAD
- 2 - METAL, MOLDED RUBBER TREAD
- 3 - METAL, DEMOUNTABLE RUBBER TREAD
- 4 - RUBBER, HARD TREAD
- 5 - RUBBER, SOFT TREAD
- 6 - METAL, ALL
- 7 - METAL, DEMOUNTABLE POLYURETHANE TREAD
- 8 - METAL, MOLDED-ON POLYURETHANE TREAD

CASTER TYPE CODE

- R - RIGID  
S - SWIVEL

BASIC MS SHEET NUMBER

MS87968R102 INDICATES SWIVEL TYPE CASTER; RUBBER, HARD TREAD; LIGHT DUTY; WHEEL DIA 4.0; TREAD WIDTH .938;  
OVERALL HEIGHT 4.750; MOUNTING PLATE SIZE 2.750 x 3.750; HOLE SPACINGS FOR MOUNTING PLATES 1.750 x 3.000;  
MOUNTING BOLT DIA .250; SWIVEL RADIUS 3.75.

APPROVED 5 JULY 1984 REVISED

P. A. 82 Other Cast 99, AR, YD	INTERNATIONAL INTEREST	TITLE CASTERS, RIGID AND SWIVEL INDUSTRIAL DUTY	MILITARY STANDARD MS87968
PROCUREMENT SPECIFICATION FF-C-88	SUPERSEDES:	PAGE 1 OF 3	

FED. SUP CLASS  
5340

## NOTES:

1. DIMENSIONS. ALL DIMENSIONS ARE IN INCHES
2. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
3. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

TABLE I. DIMENSIONS AND DASH NUMBERS.

DASH NO	1/ CLASS	WHEEL DIA (NOM)	TREAD WIDTH (NOM)	OVERALL HEIGHT	MOUNTING PLATE OVERALL SIZE	HOLE SPACINGS FOR THE MOUNTING PLATE	MOUNTING BOLT DIA	SWIVEL RADIUS (MAX)
		A	B	C	D X E	F X G	H	J
01	1 LIGHT DUTY 75 TO 145 LBS	2.0	.812	2.625	1.250 x 2.125	.8120 x 1.562	.188	2.00
02		3.0	.812	3.188	2.750 x 3.750	1.750 x 3.000	.250	2.75
03		4.0	.938	4.750				3.75
04		5.0	.938	5.750				4.00
05	2 LIGHT MEDIUM DUTY 125 TO 280 LBS	3.0	1.25	3.750 or 4.188	2.750 x 3.750 or 3.125 x 4.125	1.750 x 2.875 or 2.375 x 3.438	.312	3.00
06		3.5		4.500 or 4.750				3.25
07		4.0		5.062				3.75
08		5.0		6.125				4.25
09	3 MEDIUM DUTY 200 TO 575 LBS	4.0	1.50	5.312 or 5.625	4.000 x 4.750	SLOTTED HOLES 2.625 x 3.625 TO 3.000 x 3.000	.375	4.00
11		5.0		6.188 or 6.438				4.75
12		6.0		7.375				5.50
13	4 HEAVY MEDIUM DUTY 300 TO 1050 LBS	4.0		5.562	5.000 x 5.500	SLOTTED HOLES 2.625 x 3.625 TO 3.000 x 3.000	.375	4.00
14		5.0		6.312 or 6.500				4.50
15		6.0		7.375 or 8.000				5.75
16		8.0		9.375 or 10.00				7.25
17	5 HEAVY DUTY 540 TO 2200 LBS	6.0	2.50	7.625 or 8.125	5.000 x 7.000	SLOTTED HOLES 2.438 x 4.938 TO 3.375 x 5.250	.500	6.25
18								
19		8.0	3.00	10.25 or 10.62				7.25
20		10.0		12.25				8.50
21		12.0		14.50				10.25

1/ SEE TABLE II FOR LOAD CARRYING CAPACITY

P. A. Other Cost 99, AR, YD	82 INTERNATIONAL INTEREST	TITLE CASTERS, RIGID AND SWIVEL INDUSTRIAL DUTY	MILITARY STANDARD MS 87968
PROCUREMENT SPECIFICATION FF-C-88	SUPERSEDES:	PAGE 2 OF 3	

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5340-1424

USER ACTIVITIES:  
ARMY - CE, GL, MEREVIEWER ACTIVITIES:  
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TABLE II. LOAD CAPACITY FOR WHEEL DIAMETERS.

CLASS	WHEEL DIAMETER INCHES (NOM)	WHEEL STYLE 1	WHEEL STYLE 2	WHEEL STYLE 3	WHEEL STYLE 4	WHEEL STYLE 5	WHEEL STYLE 6	WHEEL STYLE 7	WHEEL STYLE 8
		LBS MIN	LBS MIN	LBS MIN	LBS MIN	LBS MIN	LBS MIN	LBS MIN	LBS MIN
1 LIGHT 75 TO 145 LBS	2				100	75	100		
	3				125	100	125		
	4				135	110	135		
	5				145	125	145		
2 LIGHT MEDIUM 145 TO 280 LBS	3			-	210	125	210	-	
	3.5			165	225	140	225	225	
	4			165	255	165	255	250	
	5			165	280	190	280	280	
3 MEDIUM 200 TO 575 LBS	3	-	-	-	-	-	-	-	-
	4	375	200	-	300	200	425	-	400
	5	440	240	240	350	240	500	360	480
	6	430	280	280	400	280	575	420	560
4 MEDIUM HEAVY 300 TO 1050 LBS	4	500	300	-	400	300	550	-	500
	5	580	350	-	450	325	700	-	700
	6	640	410	410	560	400	850	610	820
	8	675	500	500	600	475	1050	750	1000
5 HEAVY 540 TO 2200 LBS	5	-	-	-			-	-	-
	6	800	540	-			1200	-	1100
	8	850	670	670			1400	1000	1340
	10	940	790	790			1650	1180	1580
	12	1240	1140	1140			2100	1710	2100

APPROVED 5 JULY 1984 REVISED

P. A. 82	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cost		CASTERS, RIGID AND SWIVEL INDUSTRIAL DUTY	MS 87968
99, AR, YD			
PROCUREMENT SPECIFICATION FF-C-88	SUPERSEDES:		PAGE 3 OF 3

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