

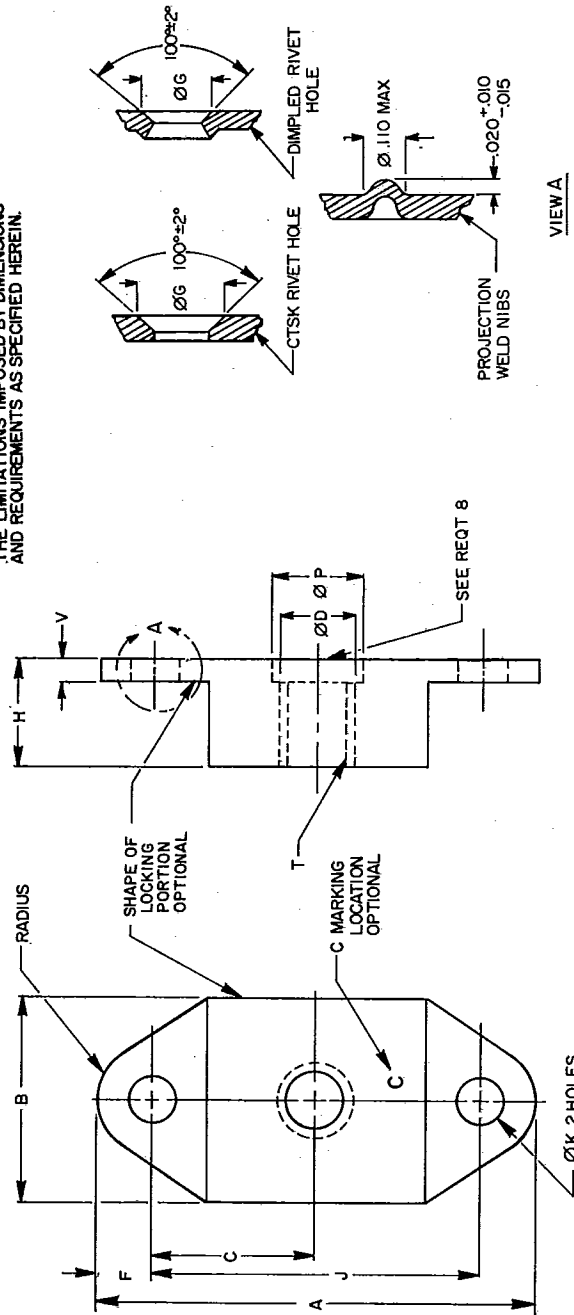
FED. SUP CLASS
5 310

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REVIEWER ACTIVITIES:
ARMY-AR
NAVY-SH
AIR FORCE-99
DLA-IS

USER ACTIVITIES:
ARMY-CR,MI
NAVY-OS

CONFIGURATION OF NUT OPTIONAL WITHIN THE LIMITATIONS IMPOSED BY DIMENSIONS AND REQUIREMENTS AS SPECIFIED HEREIN.



VIEW A

TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	450°P		800°P		T THREAD SIZES	A MAX	B		C MIN	Ø D MIN	F MIN	Ø G MIN	H ^{1/2} MAX	J ±.002	Ø P MAX	V MAX	ACTUAL STRENGTH LBS/MIN	WEIGHT LBS/100	
	PLAIN HOLES	WELDING PROJECTIONS	PLAIN HOLES	WELDING PROJECTIONS			MAX	MIN											
L04	L04K	L04N	-04	-04W	.112-40 UNJF-3B	.948	.416	.290	.344	—	.100	.200	.175	.688	.270	.1172	.032	750	.38
L06	L06K	L06N	-06	-06W	.138-32 UNJF-3B	.948	.416	.290	.344	—	.100	.200	.203	.688	.270	.1198	.032	1,130	.39
L08	L08K	L08N	-08	-08W	.164-24 UNJF-3B	.948	.416	.290	.344	.168	.100	.200	.250	.688	.270	.1224	.032	1,720	.40
L3	L3K	L3N	-3	-3W	.190-32 UNJF-3B	.948	.416	.290	.344	.194	.100	.200	.250	.688	.270	.1250	.032	2,460	.41
L4	L4K	L4N	-4	-4W	.250-28 UNJF-3B	1.292	.516	.350	.500	.254	.100	.200	.281	1.000	.330	.310	.032	4,580	.90
L5	L5K	L5N	-5	-5W	.3125-24 UNJF-3B	1.292	.609	.412	.500	.317	.125	.230	.328	1.000	.392	.372	.045	7,390	1.26
L6	—	L6N	-6	-6W	.375-24 UNJF-3B	1.292	.680	.475	.500	.379	.125	.230	.344	1.000	.455	.435	.055	11,450	1.55
L7	—	L7N	-7	-7W	.4375-20 UNJF-3B	1.477	.719	.672	.562	.442	.146	.230	.504	1.125	.517	.497	.115	15,450	3.30
L8	—	L8N	-8	-8W	.500-20 UNJF-3B	1.602	.859	.796	.625	.504	.146	.230	.630	1.250	.580	.560	.115	21,110	4.00

1/ MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS OF SPECIFICATION.
2/ DIMPLED RIVET HOLE TOLERANCE FOR Ø "K" IS +.015 -.000.

ENTIRE STANDARD REVISED

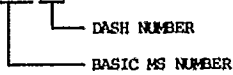
P.A. NAVY-AS Other Cust ARMY-AV AIR FORCE-II	INTERNATIONAL INTEREST	TITLE NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING, LOW HEIGHT, CRES, 125 KSI FTU, 450° F & 800° F	MILITARY STANDARD
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES: NAS 686, NAS 1031 (IN PART)	PAGE 1 OF 3	MS 21060

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REQUIREMENTS:

1. MATERIAL: CORROSION RESISTANT STEEL, TYPE A286, (UNS S66286) IN ACCORDANCE WITH AMS5525, AMS5732 OR AMS5737.
2. FINISH: ONLY 800°F NUTS: SILVER PLATE ALL THREADED SURFACES OF NUT ELEMENT IN ACCORDANCE WITH AMS 2410. THREADS SHALL SHOW COMPLETE COVERAGE. SILVER PLATING ON ALL OTHER SURFACES OPTIONAL. TARNISHING OR DISCOLORATION OF SILVER NOT CAUSE FOR REJECTION.
3. LUBRICANT: ONLY 450°F NUTS: DRY FILM LUBRICANT IN ACCORDANCE WITH MIL-N-25027.
4. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
5. HARDNESS: 49HRC, MAX.
6. THREADS: THREADS BEFORE LUBRICATION IN ACCORDANCE WITH MIL-S-8879.
7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL NOT EXCEED 125 MICROINCHES, IN ACCORDANCE WITH ANSI B46.1.
8. COUNTERBORE/COUNTERSINK: ON SIZE .164 AND LARGER, THREAD RELIEF SHALL BE .062 MINIMUM; ON SIZE .138 AND SMALLER, COUNTERSINK OR RADIUS WITHIN "P" DIAMETER.
9. PERFORMANCE: SEE PROCUREMENT SPECIFICATION, EXCEPT 450°F DRY FILM LUBRICATED NUTS LIMITED TO FIVE REUSE CYCLES.
10. FLOAT OF NUT PORTION: FLOAT OF NUT PORTION OF ASSEMBLY SHALL NOT BE LESS THAN .030 RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
11. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS21060L4K



MS21060L4K INDICATES: NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING, LOW HEIGHT, CRES; 125 KSI Ft_u, 450°F; DRY FILM LUBRICATION; .250-28 UNF-3B; COUNTERSUNK OR DIMPLED HOLES.

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. 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.
3. 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.
4. DESIGN AND USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO DEVELOP THE TENSILE STRENGTH OF BOLTS AND SCREWS WITH AN ULTIMATE TENSILE STRENGTH OF 125 KSI BASED ON THE CROSS SECTION AREA AT THE BASIC ROOT DIAMETER OF THE THREADS. THESE NUTS ARE DESIGNED TO BE USED ON 3A EXTERNAL THREADS. THESE NUTS SHALL BE USED IN ACCORDANCE WITH THE LIMITATIONS OF MS33588. ONLY NUTS FOR WHICH THERE ARE QUALIFIED PRODUCTS LISTED ON QPL 25027 SHALL BE USED.

USER ACTIVITIES:
ARMY-CR, M1
NAVY-OS

REVIEWER ACTIVITIES:
ARMY-AR
NAVY-SH
AIR FORCE-99
DLA-IS

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APPROVED 23 JUL 64 REVISED (F) FOR CHANGES SEE PAGES 1, 2 AND 3

P.A. NAVY-AS Other Cust ARMY-AV AIR FORCE-11	INTERNATIONAL INTEREST	TITLE NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING, LOW HEIGHT, CRES, 125 KSI FTU, 450° F & 800° F	MILITARY STANDARD
	PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES NAS 686, NAS 1031 (IN PART)	MS21060 PAGE 2 OF 3

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5310-1570

FED. SUP CLASS
5310

INTERCHANGEABILITY RELATIONSHIP

MS21060 NUTS CAN UNIVERSALLY REPLACE NAS686 AND NAS1031 NUTS OF LIKE MATERIAL, THREAD SIZE, LUBRICANT (DRY FILM OR SILVER PLATE) RIVET SPACING AND FASTENING METHOD (PLAIN RIVET HOLES; DIMPLED OR COUNTERSUNK RIVET HOLES OR PROJECTION WELDING), BUT THESE NAS686 AND NAS1031 NUTS CANNOT UNIVERSALLY REPLACE MS21060 NUTS.

INTERCHANGEABILITY TABLE

CANCELLED PART NUMBER	SUBSTITUTIVE PART NUMBER	CANCELLED PART NUMBER	SUBSTITUTIVE PART NUMBER	CANCELLED PART NUMBER	SUBSTITUTIVE PART NUMBER	CANCELLED PART NUMBER	SUBSTITUTIVE PART NUMBER
NAS686C04	MS21060-04	---	MS21060-3W	NAS1031C04	MS21060-04	NAS1031C4W	MS21060-4W
NAS686C04K	MS21060-04K	NAS686C3M	MS21060L3	NAS1031C04K	MS21060-04K	NAS1031C5	MS21060-5
---	MS21060-04W	NAS686C3MK	MS21060L3K	NAS1031C04W	MS21060-04W	NAS1031C5K	MS21060-5K
NAS686C04M	MS21060L04	---	MS21060L3W	NAS1031C06	MS21060-06	NAS1031C5W	MS21060-5W
NAS686C04MK	MS21060L04K	NAS686C4	MS21060-4	NAS1031C06K	MS21060-06K	NAS1031C6	MS21060-6
---	MS21060L04W	NAS686C4K	MS21060-4K	NAS1031C06W	MS21060-06W	NAS1031C6W	MS21060-6W
NAS686C06	MS21060-06	---	MS21060-4W	NAS1031C08	MS21060-08	NAS1031C7	MS21060-7
NAS686C06K	MS21060-06K	NAS686C4M	MS21060L4	NAS1031C08K	MS21060-08K	NAS1031C7W	MS21060-7W
---	MS21060-06W	NAS686C4MK	MS21060L4K	NAS1031C08W	MS21060-08W	NAS1031C8	MS21060-8
NAS686C06M	MS21060L06	---	MS21060L4W	NAS1031C3	MS21060-3	NAS1031C8W	MS21060-8W
NAS686C06MK	MS21060L06K	NAS686C5	MS21060-5	NAS1031C3K	MS21060-3K	---	---
---	MS21060L06W	NAS686C5K	MS21060-5K	NAS1031C3W	MS21060-3W	---	---
NAS686C08	MS21060-08	---	MS21060-5W	NAS1031C4	MS21060-4	---	---
NAS686C08K	MS21060-08K	NAS686C5M	MS21060L5	NAS1031C4K	MS21060-4K	---	---
---	MS21060-08W	NAS686C5MK	MS21060L5K	---	---	---	---
NAS686C08M	MS21060L08	---	MS21060L5W	---	---	---	---
NAS686C08MK	MS21060L08K	NAS686C6	MS21060-6	---	---	---	---
---	MS21060L08W	---	MS21060-6W	---	---	---	---
NAS686C3	MS21060-3	NAS686C6M	MS21060L6	---	---	---	---
NAS686C3K	MS21060-3K	---	MS21060L6W	---	---	---	---

USER ACTIVITIES:
ARMY - CR, MI
NAVY - OS

REVIEWER ACTIVITIES:
ARMY - AR
NAVY - SH
AIR FORCE - 99
DLA - IS

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