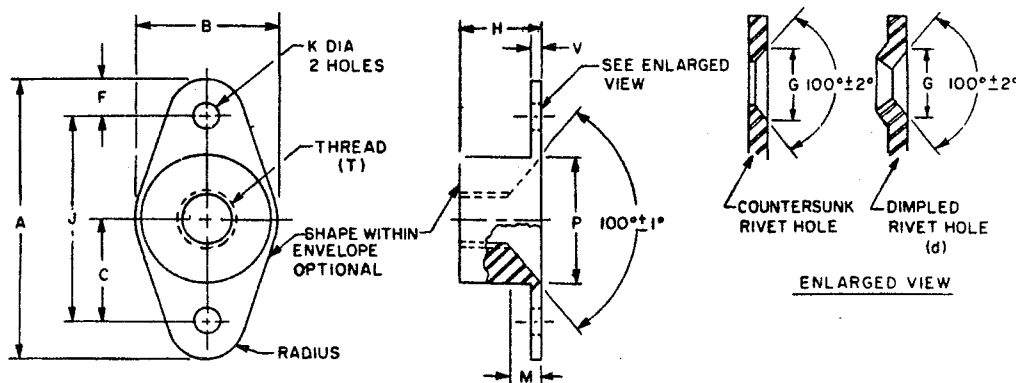


USER SYMBOLS:
ARMY ER, MI, AT, ME
REVIEWER SYMBOLS:
NAVY AS
USAF 11, 82
ARMY AV
DLA ISCONFIGURATION OF NUT OPTIONAL WITHIN
THE LIMITATIONS IMPOSED BY DIM'S, AND
REQUIREMENTS AS SPECIFIED HEREIN.

(T) THREAD SIZE (a)	A	B		C	F	G DIA. ±.010	(b) H MAX.	(c) J ±.002	K DIA. +.005 -.000	M REF.	P DIA. ±.005	V MAT'L MAX.	AXIAL	WEIGHT
		MAX.	MIN.										STRENGTH	LBS/100
				±.005	MIN.								LBS.	LBS/100
													MIN.	MAX.
.1640-32 UNJC-3B	.948	.422	.360	.344	.100	.200	.272	.688	.098	.084	.365	.047	1,720	.39
.1900-32 UNJF-3B	.948	.453	.406	.344	.100	.200	.281	.688	.098	.093	.411	.047	2,460	.41
.2500-28 UNJF-3B	1.260	.619	.535	.500	.100	.200	.340	1.000	.098	.121	.540	.055	4,580	.88
.3125-24 UNJF-3B	1.292	.766	.681	.500	.125	.230	.422	1.000	.130	.156	.686	.065	7,390	1.17

- (a) THREADS BEFORE LUBRICATION PER MIL-S-8879.
(b) MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS.
(c) CENTER OF THE TAPPED HOLE SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES BY MORE THAN .005.
(d) DIMPLED HOLE TOLERANCE FOR "K" IS +.015, - .000 AFTER FORMING.

- (E) MATERIAL: Carbon Steel UNS G10350 (AISI 1035)
UNS G10400 (AISI 1040)
UNS G10420 (AISI 1042)
UNS G10500 (AISI 1050)
Alloy Steel UNS G41300 (AISI 4130)
UNS G43400 (AISI 4340)
UNS G87400 (AISI 8740)

PLATING: CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 2. FOR DRY FILM LUBRICATED NUTS, THE TYPE AND CLASS ARE OPTIONAL IF THE NUTS MEET THE SALT SPRAY REQUIREMENTS OF QQ-P-416.

- (E) HARDNESS: 49 HRC MAX
(E) LUBRICANT: DRY FILM LUBRICANT APPROVED IN ACCORDANCE WITH MIL-N-25027. OTHER LUBRICANTS SOLUBLE IN THE CLEANER SPECIFIED IN MIL-S-7502.

DIMENSIONS IN INCHES

SURFACE ROUGHNESS IN ACCORDANCE WITH ANSI B46.1. UNLESS OTHERWISE SPECIFIED, THE SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICRONS.

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 A CROSS SECTIONAL AREA AT THE BASIC ROOT DIAMETER OF THE THREAD. 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.

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.

- (E) 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.

(E) DENOTES CHANGES

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engineering and design applications and for repetitive use shall be
made from this document.

AMSC N/A

P.A. NAVY — AS Other Cust USAF — 11 ARMY — AV	TITLE NUT, SELF-LOCKING, PLATE, TWO LUG, 100° GSK, LOW HEIGHT, STEEL, 125 KSI F _{tu} , 450°F	MILITARY STANDARD MS21049
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES: NAS681, AN361, AND AN373 IN PART	SHEET 1 OF 2

DD FORM 672-1 (Coordinated)
1 MAR 72

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PROJECT NO. 5310-1362

REVISED (A) 12 FEB 65 (B) 4 NOV 66 (C) 21 DEC 71 (D) 15 MAR 78 (E) 24 SEP 86
APPROVED 12 JUN 64

USER SYMBOLS:
ARMY ER, MI, AT, ME
NAVY AS
USAF 11, 02
ARMY AV
DLA IS

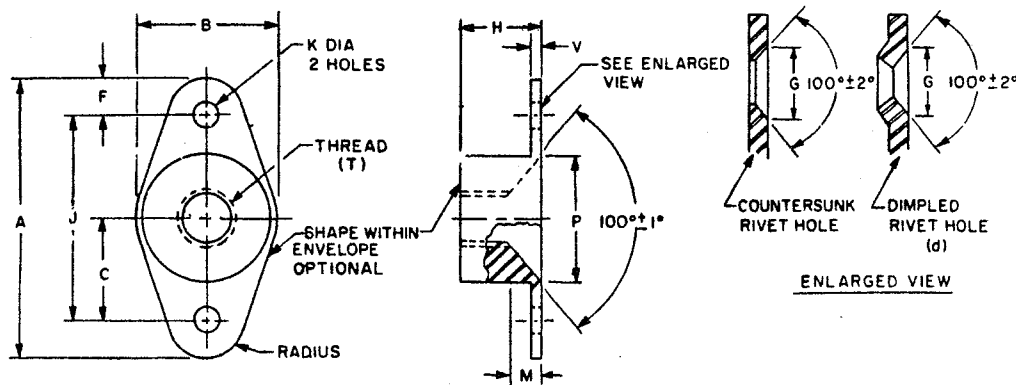
REVIEWER SYMBOLS:
NAVY AS
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ARMY AV
DLA IS

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AMSC N/A

CONFIGURATION OF NUT OPTIONAL WITHIN THE LIMITATIONS IMPOSED BY DIM'S, AND REQUIREMENTS AS SPECIFIED HEREIN.



(a)	(T) THREAD SIZE	A	B		C	F	G DIA.	(b) H	(c) J	K DIA.	M	P	V	AXIAL STRENGTH	WEIGHT
	MAX.	MAX.	MIN.	±.005	MIN.	±.010	MAX.	±.002	REF.	±.005	MAX.	MIN.	MAX.	LBS. MIN.	LBS/100 MAX.
	.1640-32 UNJC-3B	.948	.422	.360	.344	.100	.200	.272	.688	.098	.084	.365	.047	1,720	.39
	.1900-32 UNJF-3B	.948	.453	.406	.344	.100	.200	.281	.688	.098	.093	.411	.047	2,460	.41
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	.3125-24 UNJF-3B	1.292	.766	.681	.500	.125	.230	.422	1.000	.130	.156	.686	.065	7,390	1.17

- (a) THREADS BEFORE LUBRICATION PER MIL-S-8870.
(b) MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS.
(c) CENTER OF THE TAPPED HOLE SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES BY MORE THAN .005.
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- (E) HARDNESS: 49 HRC MAX
(E) LUBRICANT: DRY FILM LUBRICANT APPROVED IN ACCORDANCE WITH MIL-N-25027. OTHER LUBRICANTS SOLUBLE IN THE CLEANER SPECIFIED IN MIL-S-7502.

DIMENSIONS IN INCHES

SURFACE ROUGHNESS IN ACCORDANCE WITH ANSI B46.1: UNLESS OTHERWISE SPECIFIED, THE SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICROINCHES.

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(E) DENOTES CHANGES

P.A. NAVY — AS Other Cust	TITLE	MILITARY STANDARD
USAF - 11 ARMY - AV	NUT, SELF-LOCKING, PLATE, TWO WLG, 100° CSK, LOW HEIGHT, STEEL, 125 KSI Flu, 450°F	MS21049
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES: NAS681, AN361, AND AN373 IN PART	SHEET 1 OF 2