



User activities:

Review activities:
Army - AV
Navy - AS, SH
USAF - 11, SE
DA - IS

TABLE I

SIZE DASH NO.	THREAD	A		B		C REF	D ±.020	F MIN	(a) BEARING SURFACE SQUARENESS	AXIAL TENSILE STRENGTH POUNDS MIN.	MINIMUM ULTIMATE WRENCH TORQUE IN-LB.	WEIGHT LB/100 REF
		MAX	MIN	MAX	MIN							
4C	1/4-20UNC-3B	.296	.266	.502	.492	.552	.273	.135	.007	4,200	75	1.14
5C	5/16-18UNC-3B	.328	.298	.564	.553	.622	.336	.150	.007	5,500	130	1.53
6C	3/8-16UNC-3B	.421	.391	.690	.679	.766	.398	.175	.008	8,450	230	2.87
7C	7/16-14UNC-3B	.453	.423	.752	.741	.837	.467	.225	.008	11,650	400	3.80
8C	1/2-13UNC-3B	.546	.516	.877	.865	.978	.531	.255	.009	17,550	835	6.19
10C	5/8-11UNC-3B	.624	.594	1.064	1.052	1.191	.656	.315	.010	25,900	1315	10.50
12C	3/4-10UNC-3B	.718	.688	1.252	1.239	1.403	.782	.355	.010	33,500	1925	16.80
16C	1-8UNC-3B	.922	.860	1.627	1.614	1.836	1.044	.410	.012	62,900	6055	32.70

(a) BEARING SURFACE SQUARENESS MEASURED IN ACCORDANCE WITH MIL-N-25027.
(b) MARK IN ACCORDANCE WITH NAS 1347, USING THE SYMBOL "B8F".

NOTES:

- MATERIAL:
1. 300 SERIES CORROSION RESISTANT STEEL IN ACCORDANCE WITH FED-STD-66.
2. THE INSERT SHALL BE IN ACCORDANCE WITH MIL-M-20693, COMPOSITION A, TYPE I.
- LOCKING DEVICE: THE LOCKING DEVICE SHALL BE A RING OR COLLAR INSERT CAPABLE OF COMPLETELY CIRCUMFERENTIAL THREAD ENGAGEMENT FOR AT LEAST ONE FULL THREAD.
- THREADS: THREADS SHALL BE "RIGHT-HAND", UNIFIED COARSE IN ACCORDANCE WITH H-28, CLASS 3B FIT EXCEPT THAT MINOR DIAMETER REQUIREMENTS OF MIL-S-8379 MAY APPLY.
- STRENGTH: AXIAL TENSILE STRENGTH OF NUTS SHALL BE DETERMINED WITH ALLOY STEEL BOLTS HEAT TREATED TO A MINIMUM ULTIMATE STRENGTH OF 160,000 P.S.I.
- PASSIVATION: NUTS SHALL BE PASSIVATED IN ACCORDANCE WITH QQ-P-35.
- MAGNETIC PERMEABILITY: THE MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR IN ACCORDANCE WITH MIL-I-17214.
- BOLTS OR STUDS FOR MAXIMUM LOCKING TORQUE AND MINIMUM BREAKAWAY TORQUE TEST: BOLTS OR STUDS FOR MAXIMUM LOCKING TORQUE AND MINIMUM BREAKAWAY TORQUE TEST SHALL BE CORROSION-RESISTANT STEEL OF 300 SERIES CLASS.
- BREAK ALL SHARP EDGES AND REMOVE BURRS AND SLIVERS.
- SURFACE ROUGHNESS IN ACCORDANCE WITH USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED THE SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICROINCHES.
- DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED.
- INTERNATIONAL INTEREST: CERTAIN PROVISIONS (TO APPLY TO THE ACROSS FLATS DIMENSIONS) OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ABC AIR-STD 17/2. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED, THE DEPARTMENTAL CUSTODIAN WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICE SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED.

THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENT REFERENCED HEREIN.
REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

(A) ENTIRE STANDARD REVISED.		(A) FOR CHANGES SEE SHEET 1 AND 2.	
P.A. Navy - AS Other Cast	INTERNATIONAL INTEREST:	TITLE	MILITARY STANDARD
Army - AV USAF - 11	SEE NOTE	NUT, SELF-LOCKING, HEXAGON-THIN, UNC 3B (NON METALLIC INSERT) AUSTENITIC CORROSION RESISTANT STEEL, NONMAGNETIC, 250° F	MS16228
PROCUREMENT SPECIFICATION MIL-N-25027	SUPERSEDES:	MIL-N-24129/4 (SHIPS), MS16228(SHIPS)	SHEET 1 OF 2

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 8 May 1957 REVISED (A) 4 Oct 68

