



METRIC AEROSPACE STANDARD

MA1568™

REV. A

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Superseding MA1568

Nut, Self Locking - UNS S66286, 425°C & 650°C, 1100 MPa,
MJ Thread, Procurement Specification For, Metric

RATIONALE

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1. SCOPE:

1.1 Type:

This specification establishes the requirements for the following types of self locking nuts:

- a. Wrenching nuts: i.e., hex, double hex, spline drive.
- b. Anchor nuts: i.e., plate nuts, gang channel nuts, shank (clinch) nuts.

The wrenching nuts, shank nuts, and nut elements of plate and gang channel nuts are made of corrosion and heat resistant steel of the type identified under the Unified Numbering System as UNS S66286.

1.2 Application:

Primarily for use in aerospace propulsion systems to temperatures up to 425°C for anchor nuts and shear height wrenching nuts formed from sheet, and to 650°C for nuts made from bar or forging and tension height wrenching nuts formed from sheet. Nuts are used with bolts capable of developing 1100 MPa tensile strength at room temperature and having MJ threads to MA1370.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specification (AMS) and Aerospace Standards (AS & MA) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications:

Available from SAE, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

AMS 2350	Standards and Test Methods
AMS 2411	Plating, Silver, High Temperature Applications
AMS 2645	Fluorescent Penetrant Inspection
AMS 5525	Sheet, Strip, and Plate, 15Cr - 25.5Ni - 1.2Mo - 2.1Ti - 0.006B - 0.30V, 1800°F (980°C) Solution Heat Treated
AMS 5731	Bars, Forgings, Tubing, and Rings, 15Cr - 25.5Ni - 1.3Mo - 2.1Ti - 0.006B - 0.30V Cons. Elect. Melt, 1800°F (980°C) Sol. Heat Treated
AMS 5732	Bars, Forgings, Tubing, and Rings, 15Cr - 25.5Ni - 1.2Mo - 2.1Ti - 0.006B - 0.30V, Cons. Elect. Melt, 1800°F (980°C) Sol. and Precip. Heat Treated
AMS 5734	Bars, Forgings, and Tubing, 15Cr - 25.5Ni - 1.3Mo - 2.1Ti - 0.006B - 0.30V, Cons. Elect. Melt, 1650°F (900°C) Sol. Heat Treated
AMS 5737	Bars, Forgings, and Tubing, 15Cr - 25.5Ni - 1.3Mo - 2.1Ti - 0.006B - 0.30V, Cons. Elect. Melt, 1650°F (900°C) Sol. & Precip. Heat Treated
AS1310	Fastener Torque for Threaded Applications, Definitions of
MA1370	Screw Threads - MJ Profile, Metric
MA1520	Areas for Calculating Stress or Load Values for Metric MJ Externally Threaded Fasteners
MA1586	Wrench Configuration, 12 Spline Drive, Metric
MA3374	Bolts and Screws, UNS S66286, 650°C, 900 MPa, MJ Thread, Procurement Specification For, Metric

2.2 U.S.A. Government Publications:

Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

MIL-L-7808	Lubricating Oil, Aircraft Turbine Engine, Synthetic Base
MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-794	Parts and Equipment, Procedures for Packaging and Packing of
MIL-STD-1312	Fastener Test Methods

2.3 ANSI Publications:

Available from American National Standards Institute, Inc., 1430 Broadway, New York, NY 10018.

ANSI B1.13M	Metric Screw Threads - M Profile
ANSI/ASME B46.1	Surface Texture (Surface Roughness, Waviness, and Lay)

2.4 ASTM Publications:

Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM E 112 Determining Average Grain Size

2.5 NAS Publications:

Available from National Standards Association, Inc., 1321 Fourteenth Street, NW, Washington, DC 20005.

NA 0012 Fixture - Bearing Surface Squareness Test Self Locking Nuts, Metric

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Shall be corrosion and heat resistant steel, AMS 5731, AMS 5732, AMS 5734, or AMS 5737 bars or forgings, as specified on the part drawing, for wrenching nuts, shank nuts, and nut elements of plate and gang channel nuts. When specified on the part drawing, wrenching nuts and nut elements of plate or gang channel nuts may be formed from AMS 5525 sheet. Material for the retaining plate for plate nuts and channel for gang channel nuts shall be capable of withstanding the requirements of this specification, and shall be as specified on the part drawing.

3.2 Design:

Finished (completely manufactured) parts shall conform to the following requirements:

3.2.1 Dimensions: The dimensions of finished parts, after all processing including plating, shall conform to the part drawing.

3.2.1.1 Bearing Surface Perpendicularity: Shall be as specified on the part drawing when tested in accordance with Appendix A.

3.2.1.2 Geometric Tolerances: Part features shall be within the geometric tolerance specified on the part drawing when tested by conventional measuring methods, except for bearing surface perpendicularity as in 3.2.1.1.

3.2.2 Surface Texture: Surface texture of finished parts, prior to plating, shall conform to the requirements on the part drawing, determined in accordance with ANSI/ASME B46.1.

3.2.3 Threads: Metric screw thread MJ profile and dimensions in accordance with MA1370.

3.2.3.1 Countersink: The entering end of the thread at the bearing surface and the end of the thread at the top of nut shall be countersunk as specified on the part drawing.

- 3.2.3.2 Plated Threads: Thread in plated nuts shall meet the coating requirements of MA1370 before forming the self locking feature.
- 3.2.3.3 After Forming Self Locking Feature: The upper threaded portion shall be formed out of round in any manner which provides self locking nuts meeting the locking torque requirements of this specification. The plated nut shall allow the GO thread plug gage to enter a minimum of three turns before engagement of the locking element for nuts having overall length of threaded portion not less than 1.2 times the nominal thread diameter; nuts having shorter threaded portion shall allow GO thread plug gage to enter a minimum of three quarters of a turn.
- 3.2.4 Construction: The nut shall be of the prevailing torque-type, self contained, all metal unit, including the self locking feature. The locking feature shall not operate by means of separate movement and shall not depend upon pressure on the bearing surface for locking action. Tool marks resulting from producing the self locking feature shall blend smoothly without abrupt change.

3.3 Heat Treatment:

The nuts shall be solution and precipitation heat treated in accordance with the heat treating procedure specified in the material specification, except nuts formed from sheet stock may be precipitation heat treated after forming.

3.4 Product Marking:

Each part shall be identification marked as specified on the part drawing. Depressed characters shall have a rounded root form, depressed 0.15 mm max.

3.5 Plating:

Unless otherwise specified on the part drawing, parts shall be silver plated in accordance with AMS 2411. On nuts with nominal thread sizes 6 mm and larger, the plating on the thread shall be not less than 5 µm when measured on the pitch diameter. Microscopic measurement of a sectioned nut shall be used as the referee method. Nuts with nominal thread sizes below 6 mm shall show complete coverage on the thread surfaces. Plating on the other surfaces shall be 8 – 15 µm thick, unless otherwise specified on the part drawing. No plating shall be applied to the retaining plate for floating plate nuts and channel for gang channel nuts, unless otherwise specified on the part drawing.

3.6 Mechanical Properties:

- 3.6.1 Hardness: Unless otherwise specified on the part drawing, the hardness after heat treatment as in 3.3 shall be uniform and within the range of 29 – 39 HRC or equivalent, except nuts formed from sheet stock shall be within the range of 29 – 44 HRC, when tested in accordance with MIL-STD-1312-6. Sizes up to and including 10 mm nominal thread size shall be sectioned and mounted. Mounting optional for other sizes.

3.7 Metallurgical Properties:

- 3.7.1 Microstructure: Wrenching nuts, shank nuts, and nut elements of plate and gang channel nuts shall have microstructure of completely recrystallized material.
- 3.7.2 Grain Size: Shall be predominantly 5 or finer with occasional grains as large as 2 in the base of the nut as determined by comparison of a polished and etched specimen with ASTM E 112 plate 2. In case of disagreement on grain size by the comparison method, the intercept (Heyn) procedure shall be used.

3.8 Quality:

Parts shall be uniform in quality and condition, clean, sound, smooth, and free from burrs and foreign materials and from imperfections detrimental to their performance.

- 3.8.1 Fluorescent Penetrant Inspection: Parts shall be subject to fluorescent penetrant inspection in accordance with AMS 2645. Acceptance criteria of surface discontinuities shall be in accordance with Appendix J.

3.9 Product Performance Test:

Refer to Tables VII and VIII for details of sample sizes for Acceptance Test Plan and Qualification Approval Test Plan.

- 3.9.1 Axial Tensile Strength: Nuts shall withstand the minimum tensile load as specified in Table I without rupture, stripping or appearance of cracks when tested as follows:
- 3.9.1.1 As Received Condition at Room Temperature: Nuts in as received condition tested in accordance with DOD-STD-1312-108, using alloy steel test bolts hardened and tempered to 40 HRC min or equivalent, shall withstand the axial tensile load specified in Table I, applied at the rate specified at room temperature.
- 3.9.1.2 After Bake, at Room Temperature: Prior to testing, the nut shall be assembled on a bolt as specified in 3.10 with at least two thread pitches protruding and baked for 6 hrs $\pm$ 0.25 at 650°C $\pm$ 8 for nuts made from bar or forging and tension height wrenching nuts formed from sheet, and at 425°C $\pm$ 8 for anchor nuts and shear height wrenching nuts formed from sheet, and then cooled to room temperature. A new test bolt shall be used for each axial tensile test. Nuts shall be tested, after baking, at room temperature in accordance with DOD-STD-1312-108 and shall withstand the axial tensile load in Table I, applied at the rate specified.

TABLE I. Axial Tensile Load

Nut Thread Size	Axial Tensile Load at Room Temp. T, kN min 1/
MJ4 x 0.7-4H6H	10.47
MJ5 x 0.8-4H6H	16.83
MJ6 x 1-4H5H	23.93
MJ7 x 1-4H5H	34.02
MJ8 x 1-4H5H	45.85
MJ10 x 1.25-4H5H	71.65
MJ12 x 1.25-4H5H	106.80

- 1/ Requirements above apply to companion bolts with metric MJ threads to class 4h6h tolerance. Area upon which stress for axial tensile strength load requirements is based on the tensile stress area as defined in MA1520, Formula (2), for companion bolt thread rolled after heat treatment, and calculated from equation:

$$A = 0.7854(d_3)^2 \left[2 - \left(\frac{d_3}{d_2} \right)^2 \right]$$

where d_2 = max pitch diameter

d_3 = max root diameter

Load requirements for axial strength load is based on 1100 MPa stress.

Axial tensile strength load, $T = 1100 \text{ MPa} \times A$ divided by 1000 to obtain load in kN.

For sizes not shown, axial tensile strength loads for nuts shall be based upon the respective companion bolt stress area and 1100 MPa stress.

- 3.9.1.3 Shank Nuts: Nuts with shanks designed to be flared at assembly (See Fig. 1) shall be tested as in 3.9.1 except that the bearing plate hole shall be 0.1 – 0.2 mm greater than the max shank diameter. It is not necessary to flare the shank for this test. The bearing plate hole shall be chamfered sufficiently to clear the shank nut bearing surface-to-shank max fillet.
- 3.9.2 Wrench Torque: Wrenching nuts with spline drive wrenching feature shall be tested as specified in Appendix B and shall withstand the wrench torques specified in Table II applied through 15 engagement cycles without any permanent deformation which can interfere with the use of socket wrenches conforming to MA1586. Wrenching nuts with hexagon or double hexagon wrenching features shall be tested in the same manner and shall withstand Table II wrench torques in the same manner as spline drive nuts except double hexagon socket-type wrench shall be used.

TABLE II. Wrench Torque

Thread Size	Wrench Torque, Nm
MJ5 x 0.8	13.8
MJ6 x 1	24
MJ7 x 1	40
MJ8 x 1	60
MJ10 x 1.25	115
MJ12 x 1.25	200

- 3.9.3 Push Out Load: Anchor nuts of the types in 3.9.3.1 (normal series and miniature series rivet hole spacing) shall be tested as specified in Appendix C and shall withstand the push out loads for the applicable series specified in Table III without separating from the plate for the normal and miniature series or from the channel for the normal series. Nuts shall be serviceable after this test.
- 3.9.3.1 The push out test in 3.9.3 is applicable to gang channel nuts, plate nuts (floating and non-floating except side by side, corner and side mounted types). See Appendix A for definition of types.

TABLE III. Push Out Load

Thread Size	Push Out Load Normal Series N	Push Out Load Miniature Series N
MJ4 x 0.7	---	360
MJ5 x 0.8	900	460
MJ6 x 1	950	570
MJ7 x 1	1050	---
MJ8 x 1	1100	---

- 3.9.4 Torque Out: Anchor nuts of the types in 3.9.3.1 (normal series and miniature series rivet hole spacing) shall be tested as specified in Appendix D and shall withstand the torque out loads for the applicable series specified in Table IV without cracking, rupture, or being deformed to a degree which will prevent normal use. This test shall be performed with no axial load on the bearing surface of the nut.

TABLE IV. Torque Out Load

Thread Size	Torque Out Normal Series Nm	Torque Out Miniature Series Nm
MJ4 x 0.7	--	6
MJ5 x 0.8	10	9
MJ6 x 1	16	13
MJ7 x 1	22	--
MJ8 x 1	33	--

- 3.9.5 Permanent Set: Nuts shall be tested as specified in Appendix E and shall not exceed the max permissible locking torque or be less than the min breakaway torque values specified in Table V. The bolt or mandrel shall project thru the nut a min of three full thread pitches.

- 3.9.6 Reusability Test at Room Temp. After Bake: Nuts 5 mm nominal thread size and larger shall be tested for five consecutive cycles as specified in Appendix F, loading initially to 517 MPa in accordance with 3.9.6.3. The assembly shall be heated in a furnace to $650^{\circ}\text{C} \pm 8$ for nuts made from bar or forging and tension height wrenching nuts formed from sheet, and to $425^{\circ}\text{C} \pm 8$ for anchor nuts and shear height wrenching nuts formed from sheet, and held at heat for 6 hrs ± 0.25 , removed from the furnace and cooled to room temp.
- 3.9.6.1 Wrenching and Reference Recording: Wrenchable nuts shall be turned relative to the fixture. The wrenchability of the tested nuts shall permit assembly of standard wrench. For non-wrenchable nuts, the bolt head shall be turned. For reference information, the assembly and breakloose torques shall be recorded for each heat cycle.
- 3.9.6.2 Locking Feature Torque Requirements: Nuts tested as in 3.9.6 shall conform to the min breakaway torque in Table V, Column 1, for each cycle. The self locking torque shall be measured on installation and removal, and shall not exceed the torque in Table V, Column 4, nor shall be less than the breakaway torque in Table V, Column 1.
- 3.9.6.3 Loading by Elongation: Loading shall be determined by measurement of elongation of the bolt at room temperature using bolts having a shank diameter equal to the thread pitch diameter. The correct loading shall be determined by using a modulus of elasticity of 203.4 GPa. Stress area for the bolt shall be based on Formula (2) area given in MA1520. The elongation shall be equal to $0.002542L$ (where L = length of bushing) elongation of bolts using standard bushing as specified in Appendix F.
- 3.9.7 Reusability Test at Room Temperature, As Received Condition: Nuts shall be tested for 15 cycles as specified in Appendix G, loading to assembly torque specified in Table V, Column 5. Wrenchable nuts shall be turned relative to the fixture. For non-wrenchable nuts, the bolt head shall be turned. Locking feature torque shall conform to the min breakaway torque and max self locking torque in Table V, Column 1 and 3, respectively, for each cycle. The self locking torque shall be measured on installation and removal, and shall not exceed the torque in Table V, Column 3, nor shall be less than the breakaway torque in Table V, Column 1. After testing, the nut shall assemble freely with the fingers up to the self locking feature. Bolt threads shall remain serviceable and permit assembly of a new nut freely with the fingers up the self locking feature.
- 3.9.8 Three Cycles Test at Room Temperature: Nuts shall be tested as specified in Appendix H, loading to assembly torque specified in Table V, Column 5. Wrenchable nuts shall be turned relative to the fixture. For non-wrenchable nuts, the bolt head shall be turned. Nuts shall conform to the min breakaway torque in Table V, Column 2 for the first cycle, and Column 1 for the subsequent two cycles. The self locking torque shall be measured on installation and removal, and shall not exceed the torque in Table V, Column 3, nor shall be less than the breakaway torque in Table V, Column 1.

TABLE V. Locking Feature Torques and Assembly Torque

Thread Size	Breakaway Torque Min, Nm		Self Locking Torque, Max, Nm		Assembly Torque, Nm
	1	2	3	4	5
MJ4 x 0.7	0.15	0.30	1.6	3.2	2.8
MJ5 x 0.8	0.25	0.50	2.0	4.0	5.5
MJ6 x 1	0.35	0.70	3.2	6.4	9.6
MJ7 x 1	0.50	1.00	4.6	9.2	16.0
MJ8 x 1	0.65	1.30	6.0	12.0	24.0
MJ10 x 1.25	1.20	2.40	9.5	19.0	46.0
MJ12 x 1.25	1.80	3.60	15.0	30.0	80.0

1. Min breakaway torque for 15 cycle test, 5 cycle test, 2nd & 3rd cycle of 3 cycle test, and permanent set test.
2. Min breakaway torque for 1st cycle of 3 cycle test.
3. Max self locking torque for 15 cycle test, 3 cycle test, and permanent set test.
4. Max self locking torque for 5 cycle test.
5. Assembly torque for 15 cycle and 3 cycle tests.

3.9.9 Accelerated Vibration Test: Nuts shall be tested in accordance with DOD-STD-1312-107 and shall be loaded to assembly torques specified in Table VI. The loaded nut assembly shall withstand 30,000 cycles continuous vibration at 30 Hz and amplitude (total travel) 11.25 mm without relative rotation exceeding 360°, without cracking of nut, and without being capable of turning by hand.

TABLE VI. Assembly Torque for Accelerated Vibration Test

Thread Size	Assembly Torque, Nm
MJ5 x 0.8	3.6
MJ6 x 1	6.0
MJ7 x 1	9.2
MJ8 x 1	12.0
MJ10 x 1.25	19.0
MJ12 x 1.25	30.0

3.9.9.1 At Room Temperature, As Received Condition: Nut shall be loaded as specified in 3.9.9 on spacer then removed and reinstalled four additional times on the same bolt to the assembly torques in Table VI. The final assembly shall be with the block ready for the vibration test. The loaded nut assembly shall then be vibrated at room temperature in accordance with 3.9.9 requirements, and nuts shall conform to the requirements of 3.9.9 after the vibration test.

3.9.9.2 At Room Temperature After Baking: Nuts shall be loaded as specified in 3.9.9 on spacer as specified in Appendix F, and the loaded nut assembly shall be heated in a furnace to $650^{\circ}\text{C} \pm 8$ for nuts made of bar or forging and tension height wrenching nuts formed from sheet, and to $425^{\circ}\text{C} \pm 8$ for anchor nuts and shear height wrenching nuts formed from sheet, and held at heat for 6 hrs ± 0.25 , and cooled to room temperature. Nut shall then be removed from the assembly and reinstalled four additional times on the same bolt to the assembly torques in Table VI. The final assembly shall be on the test fixture in the block ready for the vibration test. The loaded nut assembly shall then be vibrated at room temperature in accordance with 3.9.9 requirements, and nuts shall conform to the requirements of 3.9.9 after the vibration test.

3.9.10 Flareability: Unless otherwise specified on the part drawing, the shank of shank (clinch) nuts shall be capable of being flared with a 60° included angle conical tool to a diameter equal to 120% of max shank diameter without cracking.

3.10 Test Bolts:

Except as specified in 3.9.1.1, test bolts shall be unplated and conform to MA3374 with threads to MA1370 class 4h6h.

3.11 Test Lubrication:

Stud-mandrel or bolt threads and nut bearing surface, and for non-wrenchable nut tests the bolt bearing surface, shall be lubricated with engine oil MIL-L-7808 or equivalent before each installation of the nut.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of parts shall supply all parts for vendor tests and shall be responsible for performing all required tests. Subsequent to qualification, there shall be no changes in the manufacturing method and operations sequence without requalification of the parts. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the parts conform to the requirements of this specification.

4.2 Classification of Tests:

The inspection and testing of parts shall be classified as follows:

- (a) Acceptance Tests
- (b) Qualification Tests

4.2.1 Acceptance Tests: Tests classified as acceptance or routine control tests are listed in Table VII.

4.2.2 Qualification Tests: Tests to determine conformance to all technical requirements of this specification and part drawing are listed in Table VIII.

4.3 Sampling:

4.3.1 Acceptance Tests: Acceptance tests shall be performed on each inspection lot. See 8.2.3.

4.3.1.1 Non-Destructive Tests - Visual and Dimensional: A random sample shall be selected from each inspection lot, the size of the sample to be as specified in Table X. The classification of defects for nuts will be as specified in Table IX. Defects not classified in Table IX shall be classified as Minor B defects. All dimensional characteristics are considered defective when out of tolerance.

4.3.1.2 Destructive Tests: A random sample shall be selected from each inspection lot, the size of the sample shall be as specified in Table XI, Column B. The sample nuts may be selected from those that have been subjected to and passed the non-destructive tests.

4.3.2 Qualification Tests: The qualification approval test samples shall consist of the applicable number of nuts for each thread size to be tested as specified in Table VIII.

4.4 Reports:

4.4.1 The vendor shall furnish with, or prior to, the first shipment of parts of each part number a report of test data showing that the parts conform to all technical requirements of this specification and the part drawing.

4.4.2 The vendor of parts shall furnish with each production lot shipment a report stating that the chemical composition of the parts conform to the applicable material specification, and showing the results of tests to determine conformance to the acceptance tests, and where applicable, the flareability requirements of this specification. This report shall include the purchase order number, production lot number, this specification number, contractor or direct supplier of material, material specification number, part number, nominal size, and quantity.

4.5 Resampling and Retesting:

If any part used in the above tests fails to meet the specified requirements, disposition of the parts may be based on the results of testing three additional parts for each original nonconforming part. Failure of any retest part to meet the specified requirements shall be cause for rejection of the parts represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION OF DELIVERY:

5.1 Identification:

Nuts of each different part number shall be packed in separate containers. Each container of parts shall be marked to show not less than the following information:

NUTS, SELF LOCKING, STEEL, CORROSION AND HEAT RESISTANT

MA1568

PART NUMBER _____

PURCHASE ORDER NUMBER _____

QUANTITY _____

MANUFACTURER'S IDENTIFICATION _____

PRODUCTION LOT NUMBER _____

INSPECTION _____

5.2 Packaging:

Containers of parts shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the product to ensure carrier acceptance and safe delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

- 5.2.1 For direct U.S. Military procurement, packaging shall be in accordance with MIL-STD-794, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.2 will be acceptable if it meets the requirements of Level C.

6. ACKNOWLEDGMENT:

A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.

7. REJECTIONS:

Parts not conforming to this specification or to modifications authorized by purchaser will be subject to rejection.

8. NOTES:

- 8.1 For direct U.S. Military procurement, purchase documents should specify not less than the following:

Title, number, and date of this specification.

Part number or size of parts desired.

Quantity of parts desired.

Applicable level of packaging.