

MIL-B-81934/2D ■ 9999906 1995862 802 ■

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODDS SPECIFIED IN THE SOLICITATION: MIL-B-81934.

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

FORM APPROVED  
DODS NO. 0704-0108

NOTE: CONCENTRICITY TOLERANCE BETWEEN #B AND #D DIA SHALL NOT EXCEED .003 TR

DETAIL A

DETAIL B

TABLE I. DIMENSIONS AND WEIGHTS

DASH NO.	NOMINAL SIZE (REF)	#B (BORE DIA) +.0000 -.0010	#D 1/	F +.000 -.005	#H +.000 -.020	SLEEVE WEIGHT LB/IN (REF) L = 1.000		FLANGE WEIGHT LB/IN (REF)	
						AL	CRES	AL	CRES
-04	.2500	.2515	.3760	.0625	.750	.006	.016	.002	.006
-05	.3125	.3140	.4386	.0625	.812	.007	.019	.003	.007
-06	.3750	.3765	.5012	.0625	.875	.008	.022	.003	.007
-07	.4375	.4390	.5638	.0625	.937	.009	.025	.003	.008
2/ -07A					.745				
-08	.5000	.5015	.6265	.0625	1.000	.011	.028	.003	.009
-09	.5625	.5640	.6892	.0625	1.125	.012	.031	.004	.011
-10	.6250	.6265	.8142	.0625	1.250	.021	.056	.006	.014
-11	.6875	.6890	.8767	.0625	1.375	.022	.060	.006	.016
-12	.7500	.7515	.9393	.0625	1.500	.024	.065	.007	.020
-14	.8750	.8765	1.0645	.0625	1.625	.026	.075	.006	.022
-16	1.0000	1.0015	1.1898	.0625	1.750	.031	.084	.009	.024
-18	1.1250	1.1265	1.3148	.0937	1.875	.035	.094	.015	.041
-20	1.2500	1.2515	1.4368	.0937	2.000	.036	.103	.016	.045
-22	1.3750	1.3765	1.5648	.0937	2.125	.041	.113	.017	.048
-24	1.5000	1.5015	1.7523	.0937	2.250	.062	.171	.018	.051
-26	1.6250	1.6265	1.8773	.0937	2.375	.067	.183	.020	.055
-28	1.7500	1.7515	2.0023	.0937	2.500	.071	.196	.021	.058
-32	2.0000	2.0015	2.2523	.0937	2.750	.081	.222	.023	.065

1/ #D TOLERANCE: ALUMINUM ±.0005; CORROSION RESISTANT STEEL +.0000, -.0005

EXAMPLE OF WEIGHT CALCULATION: M81934/2-16A008:  
 SLEEVE WEIGHT: (0.031 LB/IN) x .250 INCH = 0.008 LB  
 FLANGE WEIGHT: = 0.009 LB  
 TOTAL WEIGHT: = 0.017 LB

2/ INACTIVE FOR NEW DESIGN AFTER 1 AUGUST 1981. USE M81934/2-07.

Ⓢ DENOTES CHANGE

PREPARING ACTIVITY: NAVY - AS CUSTODIANS: ARMY-AV NAVY- AIR FORCE-99 REVIEW: DLA-IS, NAVY-SH, AIR FORCE-84 ARMY-AR, AT, MI PROJECT NUMBER: 3120-0743-02	<b>MILITARY SPECIFICATION SHEET</b> TITLE BEARING, SLEEVE, FLANGED, SELF-LUBRICATING, 328° F	SPECIFICATION SHEET NUMBER <b>MIL-B-81934/2</b> REV D 5 DEC 94 SUPERSEDING MIL-B-81934/2 REV C 4 JAN 88 ANSC - N/A FSC 3120
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DD FORM 1 MAY 68

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PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

MIL-B-81934/2D

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THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE DRAWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODSS SPECIFIED IN THE SOLUTION: MIL-B-81934.

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FORM APPROVED  
 OMS NO. 0704-018

TABLE II. SLEEVE BEARING LENGTH

DASH NO.	NOMINAL SIZE	LENGTH L $\begin{matrix} +.000 \\ -.010 \end{matrix}$														
		.156	.187	.218	.250	.281	.312	.343	.375	.437	.500	.562	.625	.687	.750	.875
-04	.2500	005	006	007	008	009	010	011	012	014						
-05	.3125	005	006	007	008	009	010	011	012	014	016	018				
-06	.3750	005	006	007	008	009	010	011	012	014	016	018	020	022		
-07	.4375	005	006	007	008	009	010	011	012	014	016	018	020	022	024	
-08	.5000	005	006	007	008	009	010	011	012	014	016	018	020	022	024	
-09	.5625	005	006	007	008	009	010	011	012	014	016	018	020	022	024	
-10	.6250	005	006	007	008	009	010	011	012	014	016	018	020	022	024	
-11	.6875				008	009	010	011	012	014	016	018	020	022	024	
-12	.7500				008	009	010	011	012	014	016	018	020	022	024	
-14	.8750				008	009	010	011	012	014	016	018	020	022	024	
-16	1.0000				008	009	010	011	012	014	016	018	020	022	024	
-18	1.1250						010	011	012	014	016	018	020	022	024	
-20	1.2500								012	014	016	018	020	022	024	
-22	1.3750								012	014	016	018	020	022	024	
-24	1.5000								012	014	016	018	020	022	024	
-26	1.6250										016	018	020	022	024	
-28	1.7500										016	018	020	022	024	
-32	2.0000										016	018	020	022	024	

TABLE II. SLEEVE BEARING LENGTH (CONTINUED)

DASH NO.	NOMINAL SIZE	LENGTH L $\begin{matrix} +.000 \\ -.010 \end{matrix}$															
		1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000	2.125	2.250	2.375	2.500	2.750	3.000	
-04	.2500																
-05	.3125																
-06	.3750																
-07	.4375																
-08	.5000																
-09	.5625	032	036														
-10	.6250	032	036	040	044												
-11	.6875	032	036	040	044	048	052										
-12	.7500	032	036	040	044	048	052										
-14	.8750	032	036	040	044	048	052										
-16	1.0000	032	036	040	044	048	052	056	060								
-18	1.1250	032	036	040	044	048	052	056	060								
-20	1.2500	032	036	040	044	048	052	056	060	064	068						
-22	1.3750	032	036	040	044	048	052	056	060	064	068						
-24	1.5000	032	036	040	044	048	052	056	060	064	068	072	076	080	088		
-26	1.6250	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096	
-28	1.7500	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096	
-32	2.0000	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096	

PREPARING ACTIVITY: NAVY - AS  
 CUSTODIANS: ARMY-AV NAVY- AIR FORCE-99  
 REVIEW: DLA-IS, NAVY-SH, AIR FORCE-84 ARMY-AR, AT, MI  
 PROJECT NUMBER: 3120-0743-02

**MILITARY SPECIFICATION SHEET**

TITLE  
 BEARING, SLEEVE, FLANGED,  
 SELF-LUBRICATING, 325° F

SPECIFICATION SHEET NUMBER  
**MIL-B-81934/2** REV D 5 DEC 84  
 SUPERSEDING  
 MIL-B-81934/2 REV C 4 JAN 88  
 AMSC - N/A FSC 3120

DD FORM 1 MAY 68

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MIL-B-81934/2 9999906 1995864 685

FORM APPROVED  
 OMB NO. 0704-0100

Ⓓ TABLE II. OVERSIZE BEARING DIMENSIONS 2/

RESTRICTED USAGE FOR REPAIR WORK ONLY

.010 AND .020 OVERSIZE OUTSIDE DIAMETER FOR  
 REPLACEMENT OF BEARINGS SHOWN ON SHEET 1

DASH NO.	NOMINAL SIZE	1st OVERSIZE (.010) #D 1/
-04	.2500	.3880
-05	.3125	.4486
-06	.3750	.5112
-07	.4375	.5738
-08	.5000	.6366
-09	.5625	.6992
-10	.6250	.8242
-11	.6875	.8867
-12	.7500	.9493
-14	.8750	1.0743
-16	1.0000	1.1996
-18	1.1250	1.3248
-20	1.2500	1.4498
-22	1.3750	1.5748
-24	1.5000	1.7623
-26	1.6250	1.8873
-28	1.7500	2.0123
-32	2.0000	2.2623

DASH NO.	NOMINAL SIZE	2nd OVERSIZE (.020) #D 1/
-04	.2500	.3960
-05	.3125	.4566
-06	.3750	.5212
-07	.4375	.5838
-08	.5000	.6465
-09	.5625	.7092
-10	.6250	.8342
-11	.6875	.8967
-12	.7500	.9593
-14	.8750	1.0845
-16	1.0000	1.2098
-18	1.1250	1.3348
-20	1.2500	1.4598
-22	1.3750	1.5848
-24	1.5000	1.7723
-26	1.6250	1.8973
-28	1.7500	2.0223
-32	2.0000	2.2723

1/ #D TOLERANCE ALUMINUM ±.0005; CORROSION RESISTANT STEEL +.0000, -.0005.

2/ BEFORE INITIATING A REPAIR PROCEDURE TO USE AN OVERSIZE BEARING, APPROVAL FOR MODIFYING AND REIDENTIFYING THE BEARING HOUSING MUST BE OBTAINED FROM THE COGNIZANT ENGINEERING AUTHORITY.

REQUIREMENTS:

- MATERIAL: BEARING: "A" INDICATES ALUMINUM ALLOY QQ-A-200/3 OR QQ-A-225/8 (2024T851 OR 2024T8511).  
 NOTE: THE MANUFACTURER MAY SUBSTITUTE ALLOY 2024T381 OR 2024T3811 FOR 2024T851 OR 2024T8511, RESPECTIVELY, PROVIDED THE PROCESSING PROCEDURES EMPLOYED IN MANUFACTURING THE BEARING RESULT IN A CONVERSION OF ALLOY TO 2024T851 OR 2024T8511.  
 "C" INDICATES CORROSION RESISTANT STEEL, AMS-5643 (17-4PH) CONDITION H1150 PER MIL-H-6875.

LINER: SEE PROCUREMENT SPECIFICATION.

- SURFACE TEXTURE: SMOOTH MACHINE FINISH 63 MICRO-INCH R<sub>a</sub> ON O.D.; 125 MICRO-INCH R<sub>a</sub> ON ALL OTHER METALLIC SURFACES PER ASME-B46.1, UNLESS OTHERWISE SPECIFIED.
- BREAK SHARP EDGES AND CORNERS AND REMOVE ALL BURRS AND SLIVERS.
- DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE, DECIMALS ±.010 AND ANGLES ±0.5°.
- MARKING: FOR DASH NO. 08 AND LARGER THE MILITARY PART NUMBER SHALL BE MARKED ON THE PART
- INTERCHANGEABILITY RELATIONSHIP: USE ONLY ASSIGNED PART NUMBERS FOR LENGTH AS LISTED IN LENGTH COLUMN OF TABLE II.
- LOAD RATINGS: QUALIFICATION TEST DYNAMIC LOADS ARE BASED UPON THE FORMULA:  
 TEST LOAD (LBS) = 37,500 PSI x BORE DIAMETER x (L + F - .13).
- USE OF THESE BEARINGS WILL USUALLY REQUIRE OPERATION AT A LOWER STRESS LEVEL IN ORDER TO OBTAIN THE DESIRED WEAR/LIFE CHARACTERISTICS FOR A SPECIFIC APPLICATION.
- STATIC LIMIT LOAD: ALUMINUM = 50,000 B x (L + F - .13) LBS.  
 CORROSION RESISTANT STEEL = 78,500 x BORE DIAMETER x (L + F - .13) LBS.

PREPARING ACTIVITY: NAVY - AS  
 CUSTODIANS: ARMY-AV NAVY-  
 AIR FORCE-99  
 REVIEW: DLA-IS, NAVY-SH, AIR FORCE-84  
 ARMY-AR, AT, MI  
 PROJECT NUMBER: 3120-0743-02

**MILITARY SPECIFICATION SHEET**

TITLE  
 BEARING, SLEEVE, FLANGED,  
 SELF-LUBRICATING, 325° F

SPECIFICATION SHEET NUMBER  
**MIL-B-81934/2** REV D 5 DEC 94  
 SUPERSEDING  
 MIL-B-81934/2 REV C 4 JAN 89  
 AMSC - N/A FSC 3120

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PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DOCSIS SPECIFIED IN THE SOLICITATION: MIL-B-81934.

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

MIL-B-81934/2D

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FORM APPROVED  
 OMS NO. 6704-0180

**REQUIREMENTS: (CONTINUED)**

- ⑩ 10. OUTER DIAMETER CODE: ABSENCE OF THE LETTER T AND U INDICATE STD OUTER DIA (O.D.), DIMENSION #D (SEE TABLE I).  
 T INDICATES .010 OVERSIZE O.D., DIMENSION #D (FOR REPAIR ONLY, SEE TABLE II).  
 U INDICATES .020 OVERSIZE O.D., DIMENSION #D (FOR REPAIR ONLY, SEE TABLE II).
- ⑪ 11. FINISH CODE: "P" INDICATES CORROSION RESISTANT STEEL SHALL BE ZINC-NICKEL PLATED PER AMS-2417, TYPE 2 OR CADMIUM PLATED PER QQ-P-418, TYPE II, CLASS 2 WITH A THICKNESS RANGE OF 0.0003 TO 0.0006 INCH. ABSENCE OF LETTER "P" INDICATES:  
 ALUMINUM SLEEVE BEARINGS SHALL BE ANODIZED PER MIL-A-8625, TYPE I OR II;  
 OR CHEMICAL FILM TREATMENT PER MIL-C-8841.  
 CORROSION RESISTANT STEEL BEARINGS, O.D., SHALL BE PASSIVATED PER QQ-P-36 AND THE PROCUREMENT SPECIFICATION.
- 12. TEMPERATURE RANGE: -68° F TO 325° F.

**NOTES:**

- ① 1. EXAMPLE OF PART NO.  
 MIL81934/2 - 04 C 008 P I - .250 INCH NOMINAL SIZE, ZINC-NICKEL PLATED ONE BY .280 INCH LONG .810 INCH OVERSIZE O.D.  
  - OUTER DIAMETER CODE, SEE REQUIREMENT 10
  - FINISH CODE, SEE REQUIREMENT 11
  - LENGTH CODE, SEE TABLE II
  - MATERIAL CODE, SEE REQUIREMENT 1
  - NOMINAL BORE SIZE CODE, SEE TABLE I
  - BASIC PART NUMBER
- 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 DOCS SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.

THE REQUIREMENTS FOR ACQUIRING PRODUCTS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FLAWING SPECIFICATION LISTED IN THAT ISSUE OF THE DOCS SPECIFIED IN THE SOLICITATION: MIL-B-81934.

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENT AGENCIES OF THE DEPARTMENT OF DEFENSE.

PREPARING ACTIVITY: NAVY - AS CUSTODIANS: ARMY-AV NAVY- AIR FORCE-99 REVIEW: DLA-IS, NAVY-SH, AIR FORCE-84 ARMY-AR, AT, MI PROJECT NUMBER: 3120-0743-02	<b>MILITARY SPECIFICATION SHEET</b>  TITLE BEARING, SLEEVE, FLANGED, SELF-LUBRICATING, 325° F	SPECIFICATION SHEET NUMBER <b>MIL-B-81934/2</b> REV D 5 DEC 94
		SUPERSEDING MIL-B-81934/2 REV C 4 JAN 88  AMSC - N/A FSC 3120
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PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE