

INCH-POUND

MIL-DTL-24653/1A(SH)

28 July 2020

SUPERSEDING

MIL-H-24653/1(SH)

30 May 1985

DETAIL SPECIFICATION SHEET

HASP, HIGH SECURITY, SHROUDED, FOR SHIPBOARD DOORS AND HATCHES USING HIGH SECURITY PADLOCK, STYLE 1

This specification sheet is approved for use by the Naval Sea Systems Command and is available for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and MIL-DTL-24653.

REQUIREMENTS:

The configuration requirements applicable to a style 1 hasp shall conform to [figure 1](#).

Installation instructions: Each hasp assembly shall be furnished with installation instructions as shown on [figure 2](#).

AMSC N/A

FSC 5340

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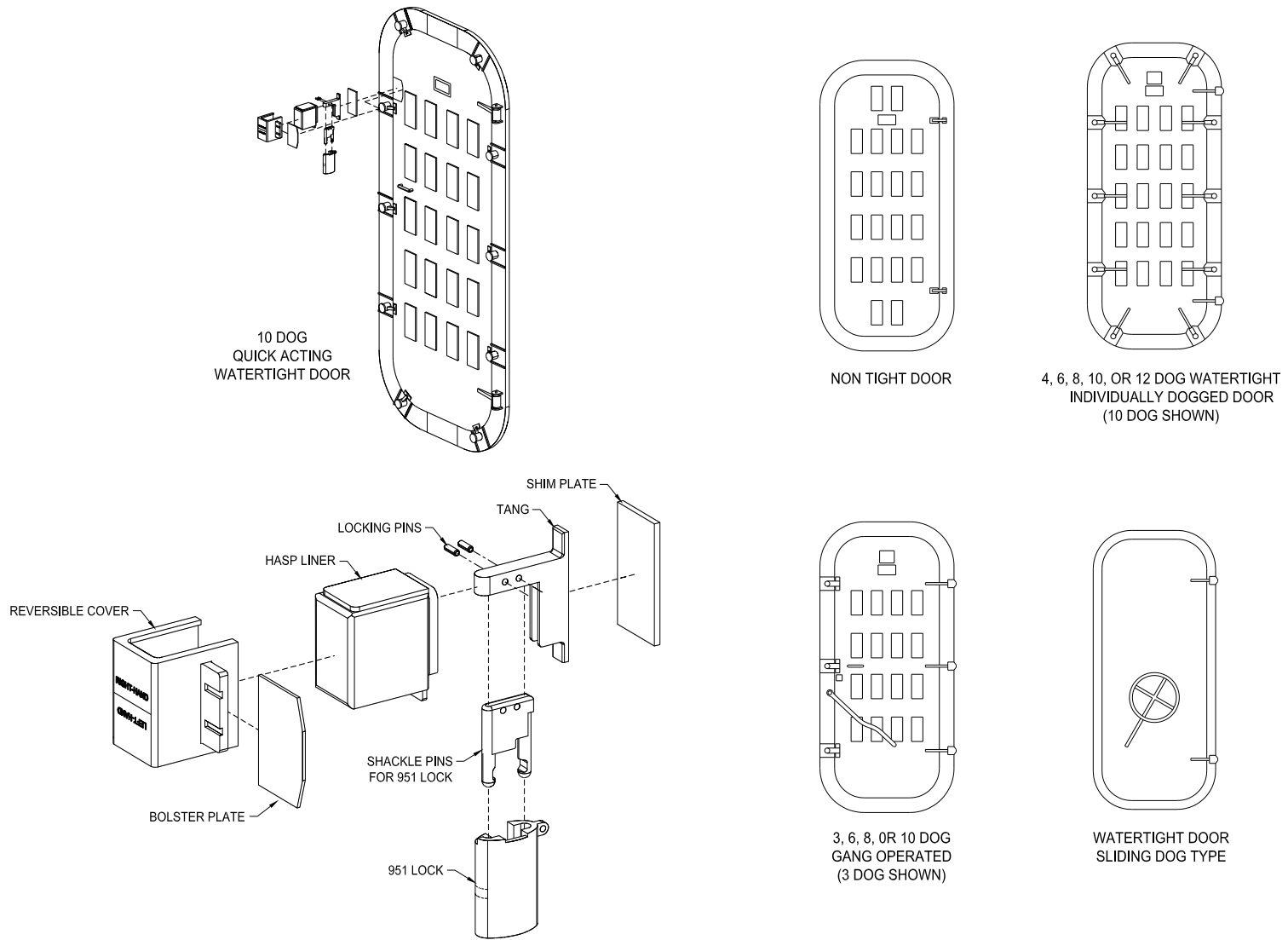
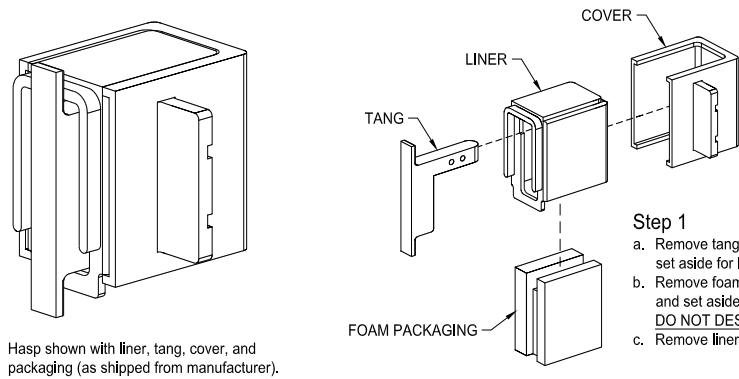


FIGURE 1. Configuration for left-hand or right-hand hinged doors swinging out to open, style 1.



Hasp shown with liner, tang, cover, and packaging (as shipped from manufacturer).

Step 1

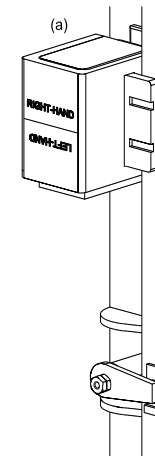
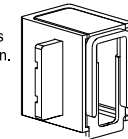
- a. Remove tang from packaging and set aside for later step.
- b. Remove foam packaging from liner and set aside for later step. **DO NOT DESTROY!**
- c. Remove liner from hasp cover.

Step 2

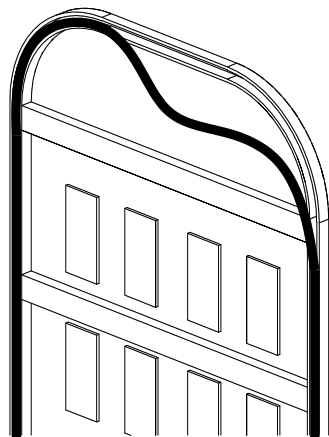
General:

The hasp cover is reversible. Its final configuration must be determined during installation. The attitude of the liner within the hasp cover produces the left-hand or right-hand configuration. Figure (a) shows the hasp and liner in the right-hand mode. For use with doors swinging out to open, the hasp in its right-hand mode will be welded to right-hand hinged doors. The hasp in its left-hand mode will be welded to left-hand hinged doors.

- a. Determine the attitude of the hasp liner and cover assembly by holding units against the door as shown.
- b. After trial assembly, weld the liner to the cover as shown.



(Only use the welding rod provided or specified in this document. Strength and security capabilities will be seriously impaired if a non-certified rod is used.)



Step 3

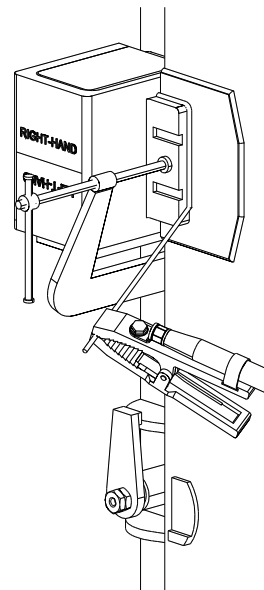
Remove watertight gasket to prevent damage from welding heat or replace gasket after welding.

Step 4

General:

To strengthen the door, a bolster plate has been provided. This plate will be fully welded to the door face. The hasp cover/liner assembly will then be welded to it.

- a. Position the bolster plate and hasp cover/liner assembly as shown. A minimum of 6 inches of clearance must be provided between the open locking end of the hasp and any obstruction to allow removal of the lock.
- b. Clamp the hasp cover/liner assembly in place.
- c. Weld the bolster plate to the door face as shown.
- d. Weld the hasp cover/liner assembly to the bolster plate.
- e. Remove clamp and allow welds to air cool.



WELDING ROD SPEC.
 STAINLESS STEEL, TYPE E, CLASS I,
 310-16 3/32 DIA.
 AWS A5.4/A5.4M PER MIL-E-22200/2

Step 5

Reinstall gasket.

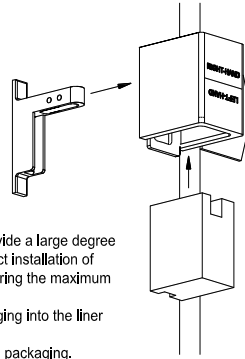
FIGURE 2. Installation procedures for left-hand or right-hand hinged doors swinging out to open, style 1.

Step 6

General:

The hasp is designed to provide a large degree of hasp/lock flexibility. Correct installation of the tang is important to ensuring the maximum of flexibility.

- a. Reinsert the foam packaging into the liner as shown.
- b. Reinsert the tang into the packaging.

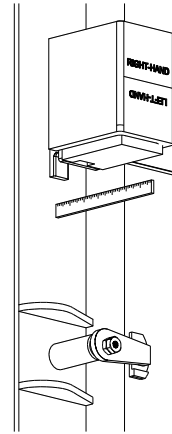
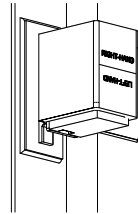


Step 6 (cont.)

- c. Close and dog door.
- d. Measure space between tang and coaming.
- e. Fill any space greater than 1/8" with shim plates provided.

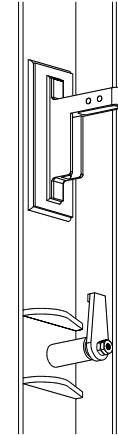
The tang may be adjusted up to 1/8" but any more must be shimmed.

- f. Weld shim plate to coaming.
- g. Tack weld top and bottom of tang flanges.



Step 6 (cont.)

- h. Open door leaving tang attached to coaming.
- i. Finish welding tang to coaming as shown.
- Allow welds to air cool.
- j. Remove foam packaging from cover/liner and discard.

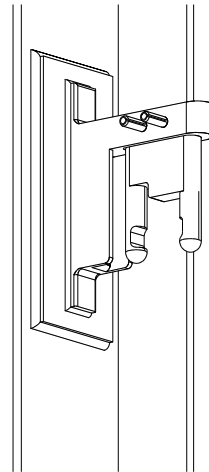
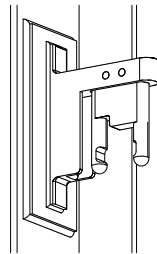


Step 7

General:

The hasp is designed to be used with the Sargent and Greenleaf, Inc., 951 lock. The 951 lock meets the high security requirements when used with the hasp. The lock requires its shackles to be removed (by a locksmith).

- a. Insert the set of pins selected into the tang as shown and drive in locking pins.



Step 8

General:

A second set of shackle pins are provided to allow the lock to be stored outside the hasp. This set of pins may be installed anywhere on the door or coaming at the discretion of the operating personnel.

- a. Hold or clamp shackle pins to selected surface.
- b. Weld pins in place.

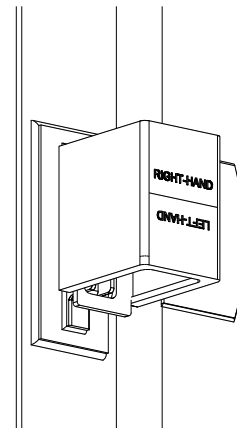
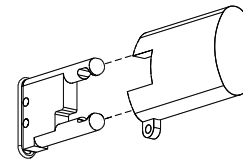


FIGURE 2. Installation procedures for left-hand or right-hand hinged doors swinging out to open, style 1 – Continued.

CHANGES FROM PREVIOUS ISSUE: Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

CONCLUDING MATERIAL

Custodian:
Navy – SH

Preparing activity:
Navy – SH
(Project 5340-2020-015)

Review activity:
DLA – IS

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.dla.mil>.