

INCH-POUND

MIL-DTL-24653/2A(SH)

28 July 2020

SUPERSEDING

MIL-H-24653/2(SH)

30 May 1985

DETAIL SPECIFICATION SHEET

HASP, HIGH SECURITY, SHROUDED, FOR SHIPBOARD DOORS AND HATCHES USING HIGH SECURITY PADLOCK, STYLE 2

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 2 hasp shall conform to [figure 1](#).

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

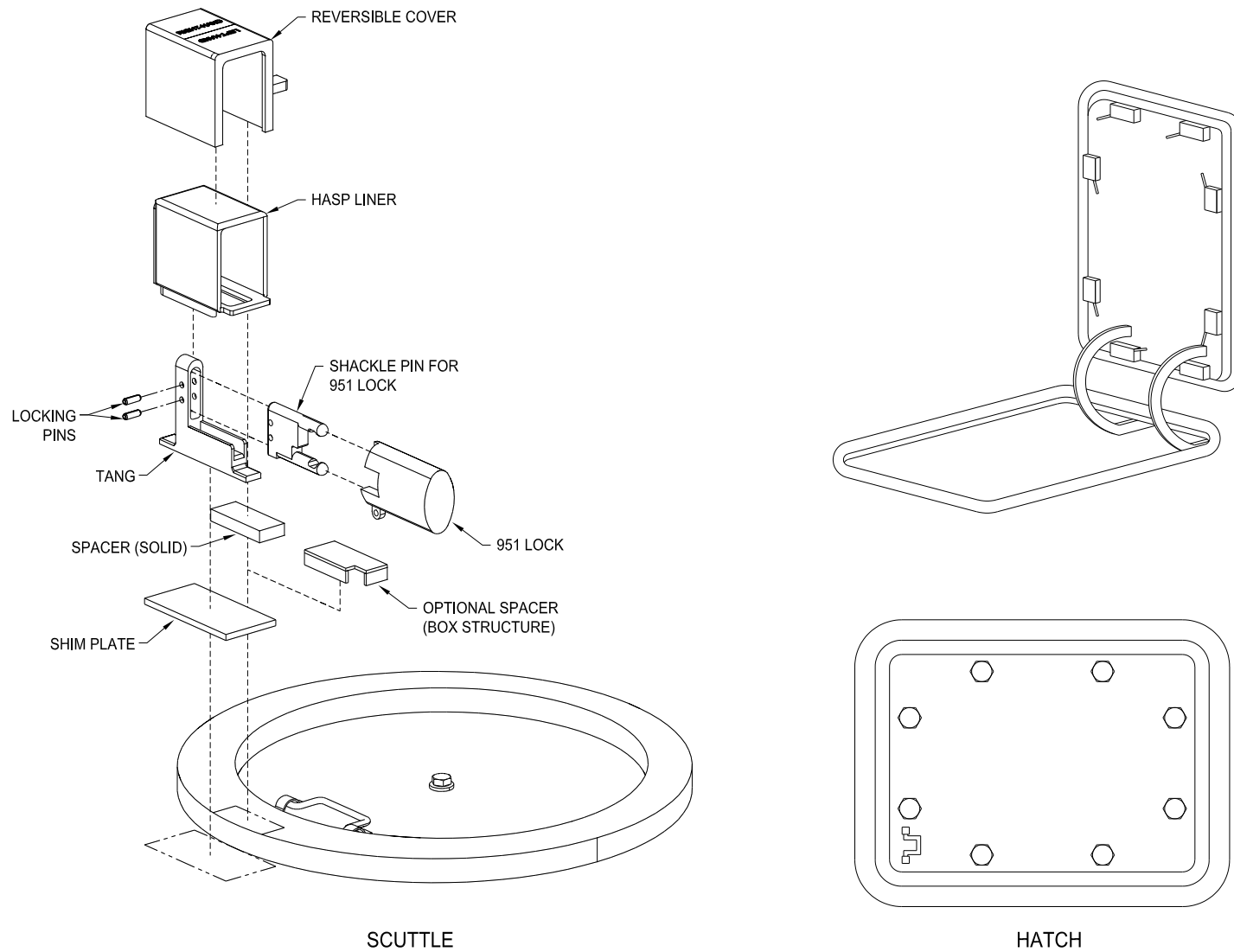
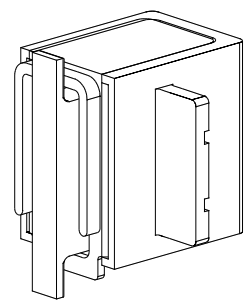
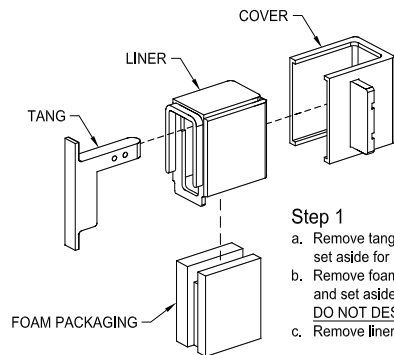


FIGURE 1. Configuration for left-hand or right-hand hinged armored doors swinging out to open, style 2.

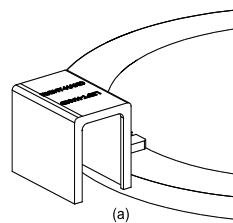


Hasp shown with liner, tang, cover, and packaging (as shipped from manufacturer).



Step 1

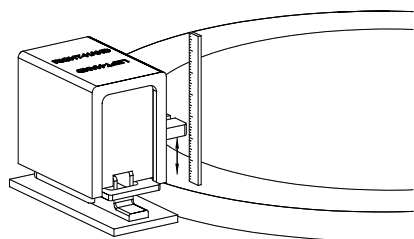
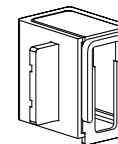
- a. Remove tang from packaging and set aside for later step.
- b. Remove foam packaging from liner and set aside for later step. **DO NOT DESTROY!**
- c. Remove liner from hasp cover.



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. In the case of a watertight scuttle, the two configurations allow the user to select the direction from which the lock is to be accessible.

- 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.)



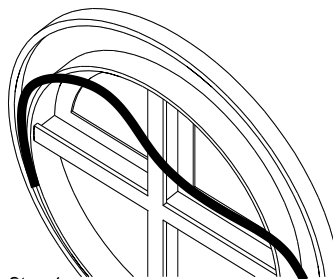
Step 3

Most armored closures do not have a $1/8$ dimension between the closure face and the frame or deck. Therefore, a shim or box structure must be fabricated to fill the space between the flange on the hasp cover and the closure face.

This spacer must be made from one of the following:

- (1) Structural steel if a solid shim is used.
- (2) 300 series stainless steel, $1/4$ inch min. thick, if a welded box structure is used to fill the space. Weld filler metal should be stainless steel.

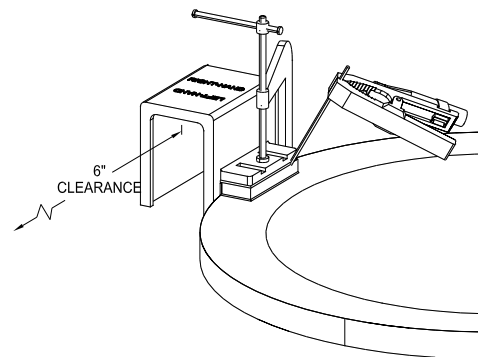
Spacer thickness should be determined by inserting the tang into the hasp with the foam jig in place, and placing the hasp as shown on the closure. Before this is done, both surfaces should be free of any tile or other coverings. After the hasp has been located and is perpendicular to the frame or deck, the gap between the cover flange and the closure face should be measured. This dimension is the thickness of the spacer. Spacer thickness can be increased by up to $1/8$ inch above the minimum thickness to allow use of standard size stock.



Step 4

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

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



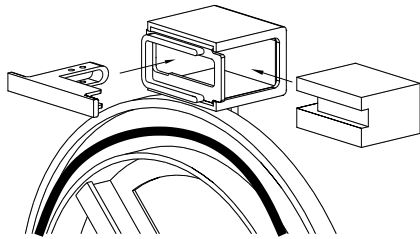
Step 5

- a. Position the shim 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 shim to the door face as shown.
- d. Weld the hasp cover/liner assembly to the shim.
- e. Remove clamp and allow welds to air cool.

Step 6

Reinstall gasket.

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

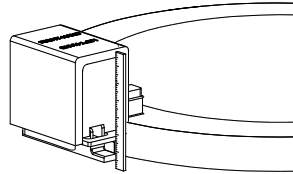


Step 7

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.

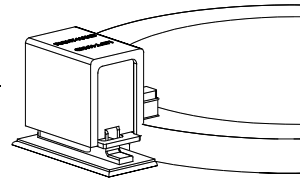
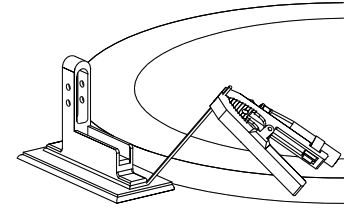
- a. Reinsert the foam packaging into the liner as shown.
- b. Reinsert the tang into the packaging.



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

Step 7 (cont.)

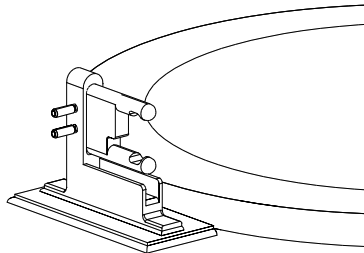
- c. Close and dog scuttle.
- d. Measure space between tang and coaming, hatch, or deck.
- e. Fill any space greater than $\frac{1}{8}$ " with shim plates provided. The tang may be adjusted up to $\frac{1}{8}$ " but any more must be shimmed!



Step 6 (cont.)

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

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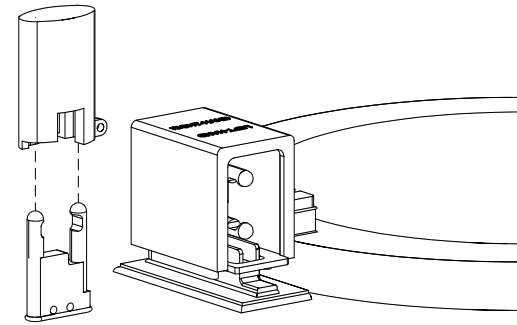
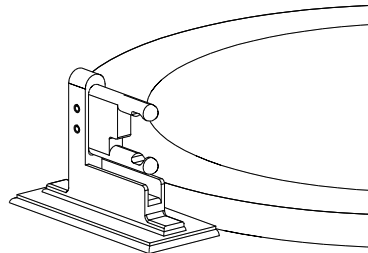


Step 8

General:

The hasp is designed to be used with The Sargent and Greenleaf Inc. 951 lock.

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



Step 9

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 scuttle, hatch, or deck 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 armored doors swinging out to open, style 2 – 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 5340-2020-016)

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>.