

FED. SUP CLASS
5340MS 122076
THRU
MS 122115User: Army - EL, ME, ML, MU
Navy - MC, OS
Air Force -Review activities: Army - WC
Navy -
Air Force - 82

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D	THREAD SIZE	J		P		Q	R MIN	S MIN	APPROX WEIGHT LB/100	PART NUMBERS	
		MIN	MAX	MIN	MAX					NOTCHED	UNNOTCHED (a)
	.086 -56	.103	.111	.062	.080	75° -150°	.0032	.0056	.0051	MS122095	MS122096 MS122097 MS122098 MS122099 MS122100 MS122101 MS122102 MS122103 MS122104 MS122105 MS122106 MS122107 MS122108 MS122109 MS122110 MS122111 MS122112 MS122113 MS122094 MS122114
	.099 -48	.120	.131	.070	.090	75° -150°	.0038	.0065	.0077	MS122115	
	.112 -40			.070	.095	25° -100°	.0045	.0078	.0121	MS122076	
	.125 -40			.078	.108	25° -100°	.0045	.0078	.0154	MS122077	
	.138 -32			.091	.121	25° -100°	.0056	.0098	.0243	MS122078	
	.164 -32			.118	.153	20° -100°	.0056	.0098	.0355	MS122079	
	.190 -24			.141	.176	15° -90°	.0075	.0130	.0573	MS122080	
	.250 -20			.182	.233	20° -80°	.0090	.0156	.145	MS122081	
	.3125 -18	.375	.390	.214	.286	20° -80°	.0100	.0174	.232	MS122082	
	.375 -16	.445	.462	.269	.348	20° -80°	.0113	.0195	.391	MS122083	
	.4375 -14	.518	.536	.313	.411	20° -80°	.0129	.0223	.667	MS122084	
	.500 -13	.586	.606	.348	.458	20° -80°	.0139	.0240	.794	MS122085	
	.5625 -12	.656	.676	.390	.520	20° -80°	.0150	.0260	1.235	MS122086	
	.625 -11	.727	.747	.421	.567	20° -80°	.0164	.0284	1.515	MS122087	
	.750 -10	.840	.885	.453	.640	60° -120°	.0180	.0312	2.778	MS122088	
	.875 -9	.991	1.026	.500	.734	60° -120°	.0200	.0347	4.545	MS122089	
	1.000 -8	1.135	1.170	.526	.781	60° -120°	.0226	.0391	5.882	MS122090	
	1.125 -7	1.260	1.315	.557	.843	60° -120°	.0258	.0446	8.392	MS122091	
	1.250 -7	1.366	1.416	.679	.937	60° -120°	.0258	.0446	10.487	MS122092	
	1.375 -6	1.545	1.598	.689	1.093	60° -120°	.0301	.0521	14.505	MS122093	
	1.500 -6	1.676	1.727	.811	1.187	60° -120°	.0301	.0521	17.563	MS122094	

1. NOMINAL LENGTH EQUALS BASIC THICKNESS OF PLATE FOR INSERT ASSEMBLY.
2. ASSEMBLED LENGTH OF INSERT TO BE AS SPECIFIED ON MS33537.
3. NUMBER OF FREE COILS TO BE COUNTED AND ASSEMBLED LENGTH OF INSERT TO BE MEASURED 90° FROM TANG.
4. MATERIAL: STEEL, CORROSION RESISTANT, AMS 7245 (MATERIAL AND MPO).
5. SURFACE TEXTURE: ANSI B46.1-1962.
6. INSERT, WHEN ASSEMBLED IN TAPPED HOLE AS SPECIFIED IN MS33537, SHALL PRODUCE A FINISHED THD MEETING ALL REQUIREMENTS OF MIL-S-7742 AND SHALL ACCEPT EXTERNAL MIL-S-8879 THREADS.
7. DIMENSIONS IN INCHES.
8. IDENTIFICATION: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION ON CONTAINER.
9. DO NOT USE UNASSIGNED PART NUMBERS.
- (a) UNNOTCHED INSERTS INACTIVE FOR DESIGN AFTER 15 OCT 1969. USE NOTCHED INSERTS. NOTCHED INSERTS CAN UNIVERSALLY REPLACE THE INACTIVATED INSERTS, BUT THE INACTIVATED INSERTS CANNOT REPLACE THE SUPERSEDING NOTCHED INSERTS.

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P.A.	USAF - 11	TITLE	MILITARY STANDARD
Other Com	Army - AV Navy - AS	INSERT, CRES HELICAL COIL COARSE THREAD, 1 DIA NOMINAL LENGTH.	MS 122076 THRU 122115
PROCUREMENT SPECIFICATION	MIL-I-8846	SUPERSEDES:	SHEET OF
		MS21208 IN PART	

APPROVED 24 MAY 69 REVISED 24 OCT 66 FOR CHANGES SEE SHEETS 1 AND 2.