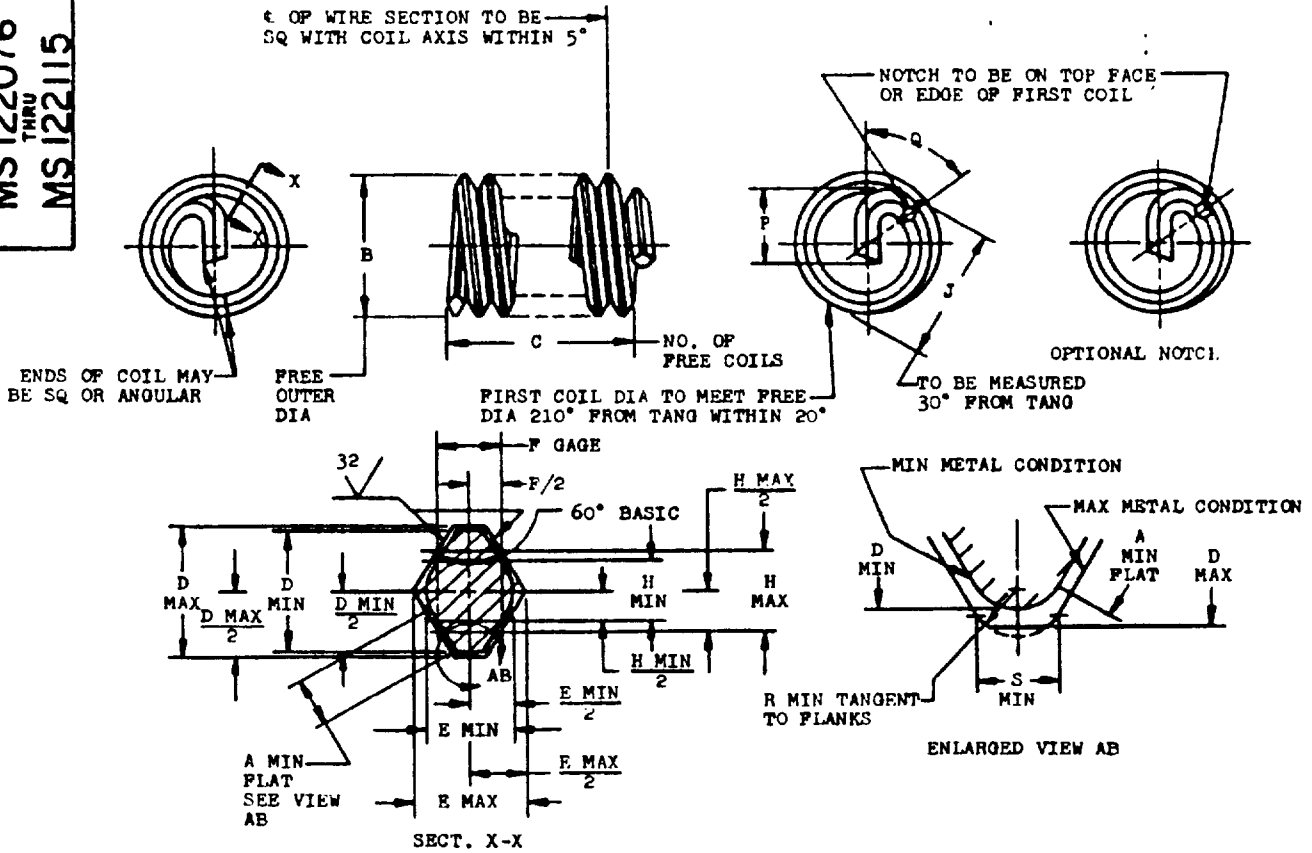


FED. SUP CLASS
5340

MS 122076
THRU
MS 122115



THREAD SIZE	NOMINAL LENGTH	A MIN	B		C* ±.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.086 -56	.086	.0027	.110	.119	3.000	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.099 -48	.099	.0043	.128	.139	2.875	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.112 -40	.112	.0068	.144	.159	2.750	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.125 -40	.125	.0068	.158	.173	3.250	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.138 -32	.138	.0076	.178	.193	2.750	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.164 -32	.164	.0076	.205	.220	3.500	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.190 -24	.190	.0120	.244	.259	2.875	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.250 -20	.250	.0164	.310	.330	3.375	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.3125 -18	.312	.0176	.380	.400	4.000	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.375 -16	.375	.0215	.452	.472	4.375	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.4375 -14	.438	.0267	.526	.551	4.500	.0730	.0770	.0545	.0625	.03571	.04589	.04639
.500 -13	.500	.0273	.597	.622	4.875	.0758	.0829	.0593	.0673	.03846	.04946	.04996
.5625 -12	.562	.0334	.669	.694	5.125	.0861	.0900	.0649	.0729	.04167	.05363	.05413
.625 -11	.625	.0351	.742	.767	5.250	.0909	.0980	.0715	.0795	.04545	.05855	.05905
.750 -10	.750	.0402	.881	.906	5.875	.1007	.1079	.0795	.0875	.05000	.06445	.06495
.875 -9	.875	.0466	1.022	1.052	6.250	.1124	.1199	.0892	.0972	.05556	.07167	.07217
1.000 -8	1.000	.0544	1.166	1.196	6.375	.1264	.1350	.1004	.1094	.06250	.08069	.08119
1.125 -7	1.125	.0645	1.315	1.355	6.125	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.250 -7	1.250	.0645	1.443	1.483	7.000	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.375 -6	1.375	.0775	1.598	1.643	6.500	.1695	.1799	.1368	.1458	.08333	.10775	.10825
1.500 -6	1.500	.0775	1.727	1.772	7.250	.1695	.1799	.1368	.1458	.08333	.10775	.10825

(D) FOR CHANGES SEE SHEETS 1 AND 2.

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.

P.A.	USAF - 11	TITLE	MILITARY STANDARD MS 122076 THRU 122115
Other Cont	Army - AV Navy - AS	INSERT, CRES HELICAL COIL COARSE THREAD, 1 DIA NOMINAL LENGTH	
PROCUREMENT SPECIFICATION	MIL-I-8846	SUPERSEDES:	SHEET 1 OF 2
		MS21208 IN PART	

Review activities: n, /C
User: Army-EL, ME, MT, MU
Navy-MC, OS,
Air Force-82

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 29 May 53 REVISED A 26 May 59 B 24 Oct 66 C 15 Oct 69 D 24 Feb 76

FED. SUP CLASS
5340

MS 122076
THRU
MS 122115

User: Army - EL, ME, MI, MU
Navy - MC, OS
Air Force -

Review activities: Army - WC
Navy -
Air Force - 82

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

(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
.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	

- (D)
- NOMINAL LENGTH EQUALS BASIC THICKNESS OF PLATE FOR INSERT ASSEMBLY.
 - ASSEMBLED LENGTH OF INSERT TO BE AS SPECIFIED ON MS33537.
 - NUMBER OF FREE COILS TO BE COUNTED AND ASSEMBLED LENGTH OF INSERT TO BE MEASURED 90° FROM TANG.
 - MATERIAL: STEEL, CORROSION RESISTANT, AMS 7245 (MATERIAL AND MPO).
 - SURFACE TEXTURE: ANSI B46.1-1962.
 - 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.
 - DIMENSIONS IN INCHES.
 - IDENTIFICATION: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION ON CONTAINER.
 - 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.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC., PUBLICATIONS. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.

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

APPROVED 24 OCT 66 (D) FOR CHANGES SEE SHEETS 1 AND 2. REVISED 26 MAY 64 (P)