

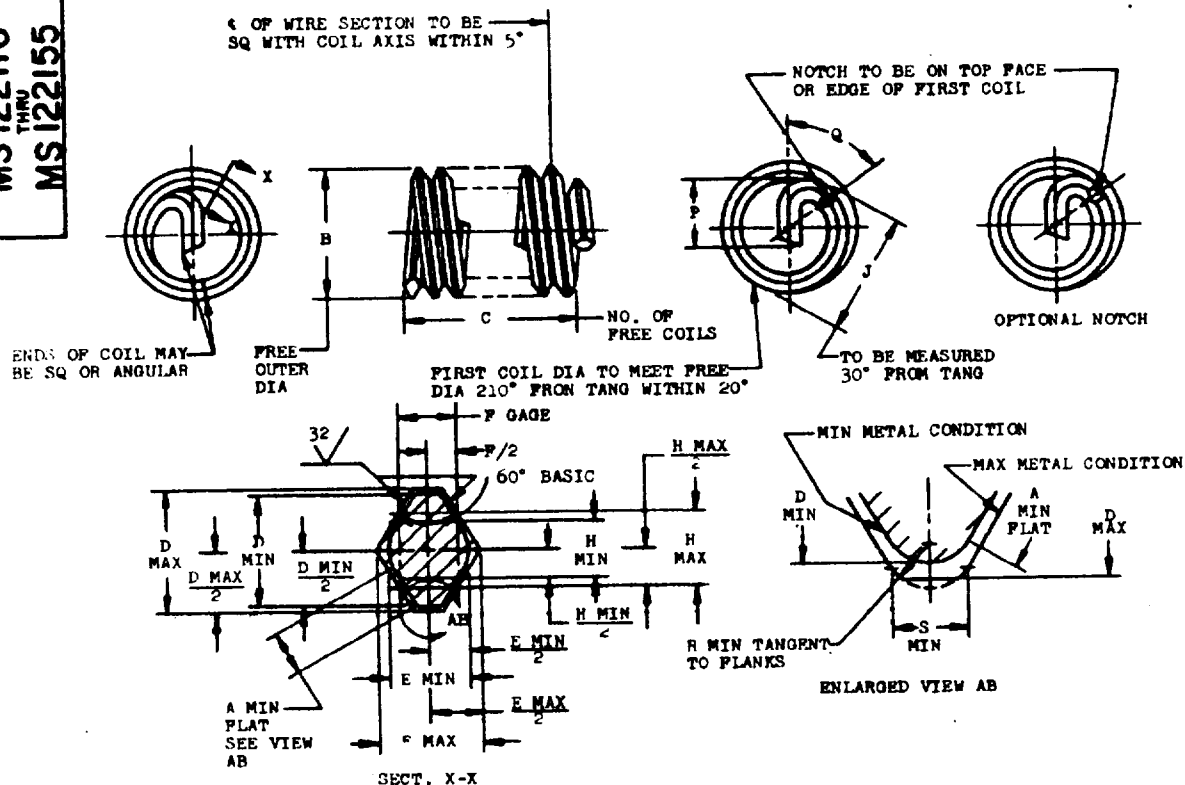
my - WC User: Army - EL, MI, ME, MU
 Navy - MC, OS
 Air Force - 82

Review activity

This 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.

MS 122116
 THRU
 MS 122155

FED. SUP CLASS
 5340



THREAD SIZE	** NOMI- NAL LENGTH	A MIN	B		C* ±.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.086 -56	.129	.0027	.110	.119	5.250	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.099 -48	.148	.0043	.128	.139	5.000	.0196	.0226	.0186	.01042	.01313	.01353	.01353
.112 -40	.168	.0068	.144	.159	4.750	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.125 -40	.188	.0068	.158	.173	5.500	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.138 -32	.207	.0076	.178	.193	4.750	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.164 -32	.246	.0076	.205	.220	6.000	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.190 -24	.285	.0120	.244	.259	5.000	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.250 -20	.375	.0164	.310	.330	5.750	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.3125 -18	.469	.0176	.380	.400	6.625	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.375 -16	.562	.0215	.452	.472	7.250	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.4375 -14	.656	.0267	.526	.551	7.375	.0730	.0770	.0545	.0625	.03571	.04639	.04639
.500 -13	.750	.0273	.597	.622	7.875	.0758	.0829	.0593	.0673	.03846	.04946	.04996
.5625 -12	.844	.0334	.669	.694	8.250	.0861	.0900	.0649	.0729	.04167	.05363	.05413
.625 -11	.938	.0351	.742	.767	8.500	.0909	.0980	.0715	.0795	.04545	.05855	.05905
.750 -10	1.125	.0402	.881	.906	9.375	.1007	.1079	.0795	.0875	.05000	.06445	.06495
.875 -9	1.312	.0466	1.022	1.052	10.000	.1124	.1199	.0892	.0972	.05556	.07167	.07217
1.000 -8	1.500	.0544	1.166	1.196	10.125	.1264	.1350	.1004	.1094	.06250	.08060	.08119
1.125 -7	1.688	.0645	1.315	1.355	9.875	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.250 -7	1.875	.0645	1.443	1.483	11.250	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.375 -6	2.062	.0775	1.598	1.643	10.500	.1695	.1799	.1368	.1458	.08333	.10775	.10825
1.500 -6	2.250	.0775	1.727	1.772	11.500	.1695	.1799	.1368	.1458	.08333	.10775	.10825

(D) FOR CHANGE 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
Other Com Army - AV	INSERT, CRES HELICAL COIL COARSE THREAD,	MS 122116
Navy - AS	1-1/2 DIA NOMINAL LENGTH	THRU MS 122155
PROCUREMENT SPECIFICATION MIL-I-8846	SUPERSEDES MS21208 IN PART	SHEET 1 OF 2

Project No. 5340-2000

APPROVED 20 May 53 REVISED A 26 May 59 B 24 Oct 66 C 15 Oct 69 D 24 Feb 76

FED. SUP CLASS
5340MS 122116
THRU
MS 122155

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

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

(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	.0084	MS122135	
.099 -48	.120	.131	.070	.090	75° -150°	.0038	.0065	.0125	MS122155	
.112 -40			.070	.095	25° -100°	.0045	.0078	.0196	MS122116	MS122136
.125 -40			.078	.108	25° -100°	.0045	.0078	.0250	MS122117	MS122137
.138 -32			.091	.121	25° -100°	.0056	.0098	.0384	MS122118	MS122138
.164 -32			.118	.153	20° -100°	.0056	.0098	.0556	MS122119	MS122139
.190 -24			.141	.176	15° -90°	.0075	.0130	.0899	MS122120	MS122140
.250 -20			.182	.233	20° -80°	.0090	.0156	.196	MS122121	MS122141
.3125 -18	.375	.390	.214	.286	20° -80°	.0100	.0174	.369	MS122122	MS122142
.375 -16	.445	.462	.269	.348	20° -80°	.0113	.0195	.625	MS122123	MS122143
.4375 -14	.518	.536	.313	.411	20° -80°	.0129	.0223	.943	MS122124	MS122144
.500 -13	.586	.606	.348	.458	20° -80°	.0139	.0240	1.316	MS122125	MS122145
.5625 -12	.656	.676	.390	.520	20° -80°	.0150	.0260	1.961	MS122126	MS122146
.625 -11	.727	.747	.421	.567	20° -80°	.0164	.0284	2.439	MS122127	MS122147
.750 -10	.840	.885	.453	.610	60° -120°	.0180	.0312	4.000	MS122128	MS122148
.875 -9	.991	1.026	.500	.734	60° -120°	.0200	.0347	6.250	MS122129	MS122149
1.000 -8	1.135	1.170	.526	.781	60° -120°	.0226	.0391	9.091	MS122130	MS122150
1.125 -7	1.260	1.315	.557	.843	60° -120°	.0258	.0446	12.928	MS122131	MS122151
1.250 -7	1.366	1.416	.679	.937	60° -120°	.0258	.0446	16.070	MS122132	MS122152
1.375 -6	1.545	1.598	.689	1.093	60° -120°	.0301	.0521	22.264	MS122133	MS122153
1.500 -6	1.676	1.727	.811	1.187	60° -120°	.0301	.0521	26.915	MS122134	MS122154

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 MPG).
 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 Code	Army - AV Navy - AS	INSERT, CRES HELICAL COIL COARSE THREAD, 1-1/2 DIA NOMINAL LENGTH	MS 122116 THRU MS 122155
REQUIREMENT SPECIFICATION	MIL-I-8846	SUPERSEDES	SHEET 2 OF 4
		MS21208 IN PART	

APPROVED 23 May 53 REVISED A 26 May 50 B 24 Oct 66 C FOR CHANGES SEE SHEETS 1 AND 2.