



FED. SUP CLASS  
5340MS122156  
THRU  
MS122195User: Army - EL, ME, MI, MU  
Navy - MC, OS  
Air Force -Review activities: Army - WC  
Navy -  
Air Force - 82

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THREAD SIZE	J		P		Q	R MIN	S MIN	APPROX WEIGHT LB/100	PART NUMBERS	
	MIN	MAX	MIN	MAX					NOTCHED	UNNOTCHED (a)
.046 -56	.103	.111	.062	.080	75° -150°	.0032	.0056	.0117	MS122175	MS122176 MS122177
.099 -48	.120	.131	.070	.090	75° -150°	.0038	.0065	.0174	MS122195	
.112 -40			.070	.095	25° -100°	.0045	.0078	.0272	MS122156	
.125 -40			.078	.108	25° -100°	.0045	.0078	.0345	MS122157	
.138 -32			.091	.121	25° -100°	.0056	.0098	.0525	MS122158	MS122178
.164 -32			.118	.153	20° -100°	.0056	.0098	.0776	MS122159	MS122179
.190 -24			.141	.176	15° -90°	.0075	.0130	.1330	MS122160	MS122180
.250 -20			.182	.233	20° -80°	.0090	.0156	.308	MS122161	MS122181
.3125 -18	.375	.390	.214	.286	20° -80°	.0100	.0174	.510	MS122162	MS122182
.375 -16	.445	.462	.269	.348	20° -80°	.0113	.0195	.862	MS122163	MS122183
.4375 -14	.518	.536	.313	.411	20° -80°	.0129	.0223	1.250	MS122164	MS122184
.500 -13	.586	.606	.348	.458	20° -80°	.0139	.0240	1.852	MS122165	MS122185
.5625 -12	.656	.676	.390	.520	20° -80°	.0150	.0260	2.632	MS122166	MS122186
.625 -11	.727	.747	.421	.567	20° -80°	.0164	.0284	3.448	MS122167	MS122187
.750 -10	.840	.885	.453	.640	60° -120°	.0180	.0312	5.263	MS122168	MS122188
.875 -9	.991	1.026	.500	.734	60° -120°	.0200	.0347	8.333	MS122169	MS122189
1.000 -8	1.135	1.170	.526	.761	60° -120°	.0226	.0391	12.500	MS122170	MS122190
1.125 -7	1.260	1.315	.557	.843	60° -120°	.0258	.0446	17.464	MS122171	MS122191
1.250 -7	1.366	1.416	.679	.937	60° -120°	.0258	.0446	21.653	MS122172	MS122192
1.375 -6	1.545	1.598	.689	1.093	60° -120°	.0301	.0521	30.122	MS122173	MS122193
1.500 -6	1.676	1.727	.811	1.187	50° -120°	.0301	.0521	36.268	MS122174	MS122194

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

P.A. Other Cont	USAP - 11	TITLE  INSERT, JRES HELICAL COIL COARSE THREAD, 2 DIA NOMINAL LENGTH	MILITARY STANDARD	
	Army - AV Navy - AS		MS 122156 THRU MS 122195	
PROCUREMENT SPECIFICATION MIL-I-PR46		SUPERSEDES MS21208 IN PART	SHEET 2 OF 2	

APPROVED 29 May 53 REVISED A 26 May 59 R 24 Oct 66 D FOR CHANGES SEE SHEETS 1 AND 2.