

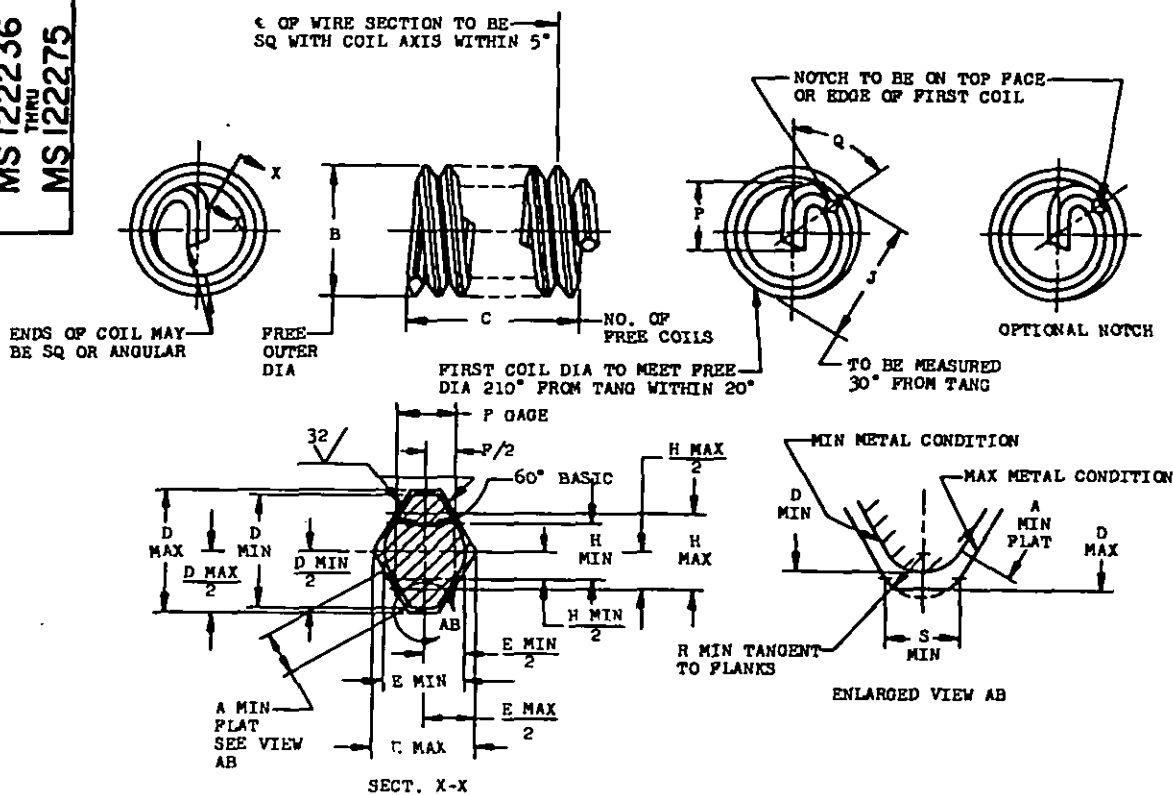
User: Army - EL, ME, ML, MU
Navy - MC, OS
Air Force -

Army - WC
Navy -
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 122236
THRU
MS 122275

FED. SUP CLASS
5340



| THREAD SIZE | NOMI- NAL LENGTH | A MIN | B | | C* ±.250 COIL | D | | E | | P GAGE | H | |
|-------------|---------------------|-------|-------|-------|------------------|-------|-------|-------|-------|-----------|--------|--------|
| | | | MIN | MAX | | MIN | MAX | MIN | MAX | | MIN | MAX |
| .086 -56 | .258 | .0027 | .110 | .119 | 11.875 | .0163 | .0193 | .0126 | .0156 | .00893 | .0112 | .0116 |
| .099 -48 | .297 | .0043 | .128 | .139 | 11.500 | .0196 | .0226 | .0152 | .0182 | .01042 | .01313 | .01353 |
| .112 -40 | .336 | .0068 | .144 | .159 | 10.875 | .0241 | .0271 | .0189 | .0219 | .01250 | .01584 | .01624 |
| .125 -40 | .375 | .0068 | .158 | .173 | 12.250 | .0241 | .0271 | .0189 | .0219 | .01250 | .01584 | .01624 |
| .138 -32 | .414 | .0076 | .178 | .193 | 10.875 | .0295 | .0338 | .0233 | .0273 | .01563 | .01985 | .02030 |
| .164 -32 | .492 | .0076 | .205 | .220 | 13.250 | .0295 | .0338 | .0233 | .0273 | .01563 | .01985 | .02030 |
| .190 -24 | .570 | .0120 | .244 | .259 | 11.375 | .0413 | .0449 | .0305 | .0365 | .02083 | .02656 | .02706 |
| .250 -20 | .750 | .0164 | .310 | .330 | 12.750 | .0500 | .0540 | .0378 | .0438 | .02500 | .03198 | .03248 |
| .3125 -18 | .938 | .0176 | .380 | .430 | 14.625 | .0560 | .0600 | .0416 | .0486 | .02778 | .03558 | .03608 |
| .375 -16 | 1.125 | .0215 | .452 | .472 | 15.750 | .0636 | .0677 | .0477 | .0547 | .03125 | .04009 | .04059 |
| .4375 -14 | 1.312 | .0267 | .526 | .551 | 16.125 | .0730 | .0770 | .0545 | .0625 | .03571 | .04589 | .04639 |
| .500 -13 | 1.500 | .0273 | .597 | .622 | 17.125 | .0758 | .0829 | .0593 | .0673 | .03846 | .04946 | .04996 |
| .5625 -12 | 1.688 | .0334 | .669 | .694 | 17.875 | .0861 | .0900 | .0649 | .0729 | .04167 | .05363 | .05413 |
| .625 -11 | 1.875 | .0351 | .742 | .767 | 18.375 | .0909 | .0980 | .0715 | .0795 | .04545 | .05855 | .05905 |
| .750 -10 | 2.250 | .0402 | .881 | .906 | 20.125 | .1007 | .1079 | .0795 | .0875 | .05000 | .06445 | .06495 |
| .875 -9 | 2.625 | .0466 | 1.022 | 1.052 | 21.250 | .1124 | .1199 | .0892 | .0972 | .05556 | .07167 | .07217 |
| 1.000 -8 | 3.000 | .0544 | 1.166 | 1.196 | 21.625 | .1264 | .1350 | .1004 | .1094 | .06250 | .08069 | .08119 |
| 1.125 -7 | 3.375 | .0645 | 1.315 | 1.355 | 21.250 | .1451 | .1546 | .1160 | .1250 | .07143 | .09229 | .09279 |
| 1.250 -7 | 3.750 | .0645 | 1.443 | 1.483 | 23.750 | .1451 | .1546 | .1160 | .1250 | .07143 | .09229 | .09279 |
| 1.375 -6 | 4.125 | .0775 | 1.598 | 1.643 | 22.250 | .1695 | .1799 | .1368 | .1458 | .08333 | .10775 | .10825 |
| 1.500 -6 | 4.500 | .0775 | 1.727 | 1.772 | 24.500 | .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. | USAP - 11 | TITLE | MILITARY STANDARD |
|---------------------------|------------------------|--|-----------------------------|
| Other Cost | Army - AV Navy - AS | INSERT, JRES HELICAL COIL COARSE THREAD, 3 DIA NOMINAL LENGTH | MS 122236 THRU 122275 |
| PROCUREMENT SPECIFICATION | MIL-I-8846 | SUPERSEDES: | SHEET 1 OF 2 |
| | | MS21208 IN PART | |

Project No. 5340-2003

APPROVED 29 May 53 REVISED 26 May 59 24 Oct 66 15 Oct 69 24 Feb 76

FED. SUP CLASS
5340MS 122236
THRU
MS 122275User: Army - EL, ME, MI, MU
Navy - WC, 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) |
| .086 -56 | .103 | .111 | .062 | .080 | 75° -150° | .0032 | .0056 | .0183 | MS122255 | |
| .099 -48 | .120 | .131 | .070 | .090 | 75° -150° | .0038 | .0065 | .0271 | MS122275 | |
| .112 -40 | | | .070 | .095 | 25° -100° | .0045 | .0078 | .0423 | MS122236 | MS122256 |
| .125 -40 | | | .078 | .108 | 25° -100° | .0045 | .0078 | .0536 | MS122237 | MS122257 |
| .138 -32 | | | .091 | .121 | 25° -100° | .0056 | .0098 | .0807 | MS122238 | MS122258 |
| .164 -32 | | | .118 | .153 | 20° -100° | .0056 | .0098 | .125 | MS122239 | MS122259 |
| .190 -24 | | | .141 | .176 | 15° -90° | .0075 | .0130 | .219 | MS122240 | MS122260 |
| .250 -20 | | | .182 | .233 | 20° -80° | .0090 | .0156 | .490 | MS122241 | MS122261 |
| .3125 -18 | .375 | .390 | .214 | .286 | 20° -80° | .0100 | .0174 | .806 | MS122242 | MS122262 |
| .375 -16 | .445 | .462 | .269 | .348 | 20° -80° | .0113 | .0195 | 1.316 | MS122243 | MS122263 |
| .4375 -14 | .518 | .536 | .313 | .411 | 20° -80° | .0129 | .0223 | 2.000 | MS122244 | MS122264 |
| .500 -13 | .586 | .606 | .348 | .458 | 20° -80° | .0139 | .0240 | 2.857 | MS122245 | MS122265 |
| .5625 -12 | .656 | .676 | .390 | .520 | 20° -80° | .0150 | .0260 | 4.000 | MS122246 | MS122266 |
| .625 -11 | .727 | .747 | .421 | .567 | 20° -80° | .0164 | .0284 | 5.263 | MS122247 | MS122267 |
| .750 -10 | .840 | .885 | .453 | .640 | 60° -120° | .0180 | .0312 | 8.333 | MS122248 | MS122268 |
| .875 -9 | .991 | 1.026 | .500 | .734 | 60° -120° | .0200 | .0347 | 12.500 | MS122249 | MS122269 |
| 1.000 -8 | 1.135 | 1.170 | .526 | .781 | 60° -120° | .0226 | .0391 | 16.670 | MS122250 | MS122270 |
| 1.125 -7 | 1.260 | 1.315 | .557 | .843 | 60° -120° | .0258 | .0446 | 26.536 | MS122251 | MS122271 |
| 1.250 -7 | 1.366 | 1.416 | .679 | .937 | 60° -120° | .0258 | .0446 | 32.819 | MS122252 | MS122272 |
| 1.375 -6 | 1.545 | 1.598 | .689 | 1.093 | 60° -120° | .0301 | .0521 | 45.839 | MS122253 | MS122273 |
| 1.500 -6 | 1.676 | 1.727 | .811 | 1.187 | 60° -120° | .0301 | .0521 | 54.972 | MS122254 | MS122274 |

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 HOLES 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.

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 |
|---|------------------------|--|--------------------------------|
| Other Code | Army - AV Navy - AS | INSERT, FRES HELICAL COIL COARSE THREAD, 3 DIA NOMINAL LENGTH | MS 122236 THRU MS 122275 |
| PROCUREMENT SPECIFICATION MIL-I-8846 | SUPERSEDES: | MS21208 IN PART | SHEET 2 OF 2 |

FOR CHANGES SEE SHEETS 1 AND 2

24 Oct

B

26 May 59

REVISED

29 May 53

APPROVED