

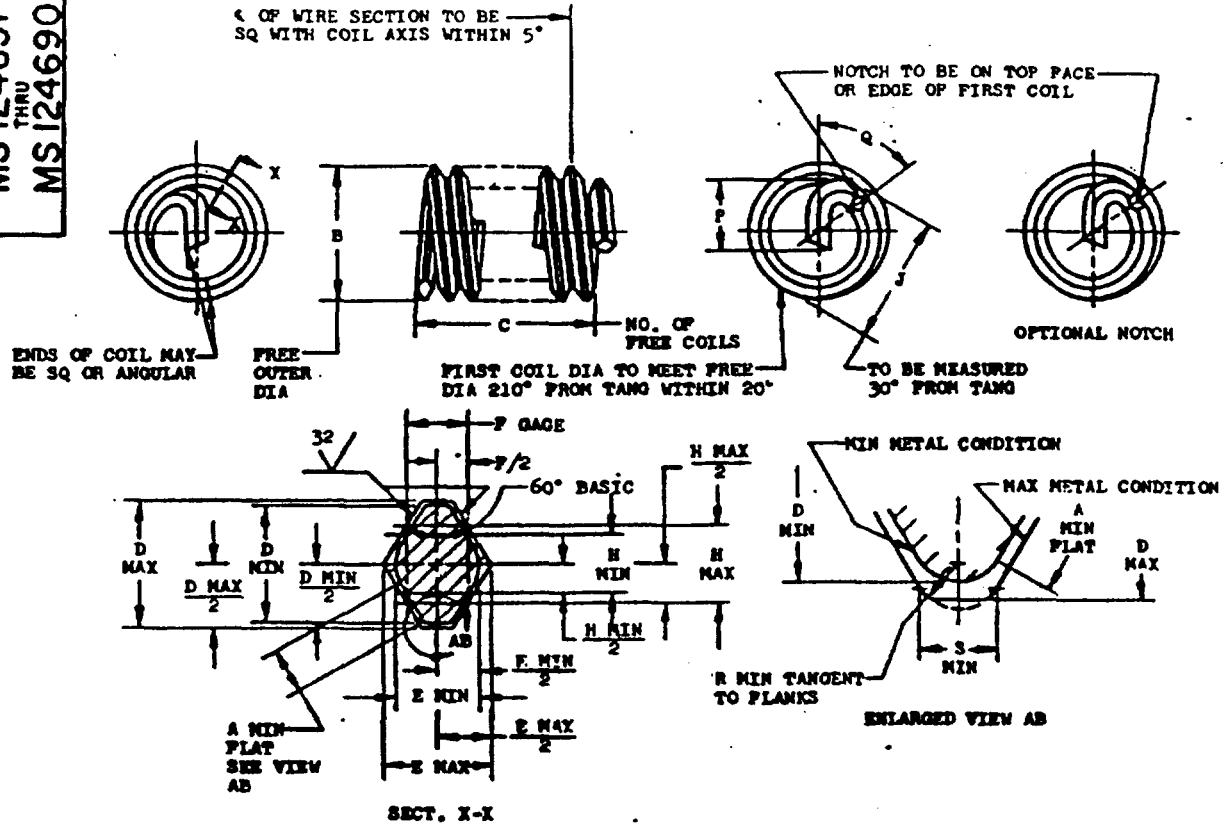
MS 124651
THRU
MS 124690

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

my - WC
--newy -
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.



(D)

THREAD SIZE	NOMI-NAL LENGTH	A MIN	B		C 2.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.099 -56	.099	.0027	.131	.146	3.375	.0163	.0193	.0120	.0156	.00893	.0112	.0130
.112 -48	.112	.0043	.147	.162	3.375	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.138 -40	.138	.0068	.173	.193	3.500	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.164 -36	.164	.0059	.204	.224	3.875	.0261	.0301	.0203	.0243	.01369	.01764	.01804
.190 -32	.190	.0076	.236	.256	4.125	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.250 -28	.250	.0085	.306	.326	5.000	.0347	.0397	.0253	.0313	.01786	.02270	.02320
.3125 -24	.312	.0120	.380	.420	5.500	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.375 -24	.375	.0120	.448	.468	6.875	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.4375 -20	.438	.0164	.524	.549	6.625	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.500 -20	.500	.0164	.592	.617	7.875	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.5625 -18	.562	.0176	.666	.691	8.000	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.625 -18	.625	.0176	.733	.758	9.000	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.750 -16	.750	.0215	.876	.901	9.750	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.875 -14	.875	.0267	1.021	1.051	9.875	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.000 -12	1.000	.0334	1.169	1.199	9.625	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.000 -14(b)	1.000	.0267	1.156	1.186	11.500	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.125 -12	1.125	.0334	1.304	1.334	11.125	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.250 -12	1.250	.0334	1.439	1.469	12.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.375 -12	1.375	.0334	1.575	1.610	13.750	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.500 -12	1.500	.0334	1.710	1.745	15.250	.0861	.0900	.0649	.0729	.04167	.05363	.05413

(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 Cont Army - AY Navy - AS	INSERT, CRES HELICAL COIL FINE THREAD, 1 DIA NOMINAL LENGTH	MS 124651 THRU MS 124690
PROCUREMENT SPECIFICATION NIL-I-8846	SUPERSEDES: MS21208 IN PART	SHEET 1 OF 2

APPROVED 21 May 53 REVISED (A) 26 May 50 (B) 24 Oct 66 (C) 25 Oct 69 (D) 24 Feb 76

FED. SUP CLASS
5340

MS 124651
THRU
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Navy - MC, OS
Air Force -

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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)	
.099 -56	.124	.146	.072	.090	75° - 150°	.0032	.0056	.0051	MS124670	X	
.112 -56	.134	.150	.060	.095	75° - 150°	.0038	.0065	.0099	MS124671		
.138 -40			.100	.130	25° - 100°	.0045	.078	.0200	MS124653		MS124673
.164 -36			.117	.147	20° - 100°	.0050	.0087	.0325	MS124654		MS124674
.190 -32			.130	.176	15° - 90°	.0056	.0098	.0474	MS124655		MS124675
.250 -28			.173	.239	15° - 70°	.0064	.0112	.109	MS124656		MS124676
.3125 -24	.359	.377	.203	.291	15° - 55°	.0075	.0130	.180	MS124657		MS124677
.375 -24	.422	.439	.235	.353	15° - 75°	.0075	.0130	.259	MS124658		MS124678
.4375 -20	.494	.514	.281	.416	15° - 75°	.0090	.0195	.459	MS124659		MS124679
.500 -20	.556	.576	.313	.478	15° - 75°	.0090	.0156	.995	MS124660		MS124680
.5625 -18	.625	.645	.344	.541	15° - 75°	.0100	.0174	.826	MS124661		MS124681
.625 -18	.688	.708	.375	.588	15° - 75°	.0100	.0174	1.010	MS124662		MS124682
.750 -16	.820	.840	.453	.662	15° - 75°	.0113	.0195	1.695	MS124663	MS124683	
.875 -14	.955	.980	.500	.640	15° - 75°	.0129	.0223	2.564	MS124664	MS124684	
1.000 -12	1.094	1.119	.526	.728	15° - 75°	.0150	.0260	3.875	MS124665	MS124685	
1.000 -14(b)	1.060	1.105	.526	.750	15° - 75°	.0129	.0223	3.448	MS124665	MS124685	
1.125 -12	1.219	1.244	.557	.819	10° - 70°	.0150	.0260	4.917	MS124666	MS124686	
1.250 -12	1.344	1.369	.679	.941	10° - 70°	.0150	.0260	6.254	MS124667	MS124687	
1.375 -12	1.469	1.499	.689	1.001	10° - 70°	.0150	.0260	7.359	MS124668	MS124688	
1.500 -12	1.594	1.624	.811	1.123	10° - 70°	.0150	.0260	8.799	MS124669	MS124689	

- 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 MFG).
- 5. SURFACE TEXTURE: AMSI 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 INACTIVATED INSERTS, BUT THE INACTIVATED INSERTS CANNOT REPLACE THE SUPERSEDING NOTCHED INSERTS.
- (b) MS124665 INACTIVE FOR DESIGN AFTER 15 OCTOBER 1969. NO SUPERSEDING STANDARD.

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P.A.	USAF - 11	TITLE	MILITARY STANDARD
Other Com	Army - AV Navy - AS	INSERT, CPES HELICAL COIL FINE THREAD, 1 DIA NOMINAL LENGTH	MS 124651 THRU MS 124690
PROCUREMENT SPECIFICATION	SUPERSEDED	MS21208 IN PART	SHEET 2 OF 2

APPROVED 29 May 53 REVISED 26 May 59 24 Oct 66 FOR CHARGES SEE SHEETS 1 AND 2