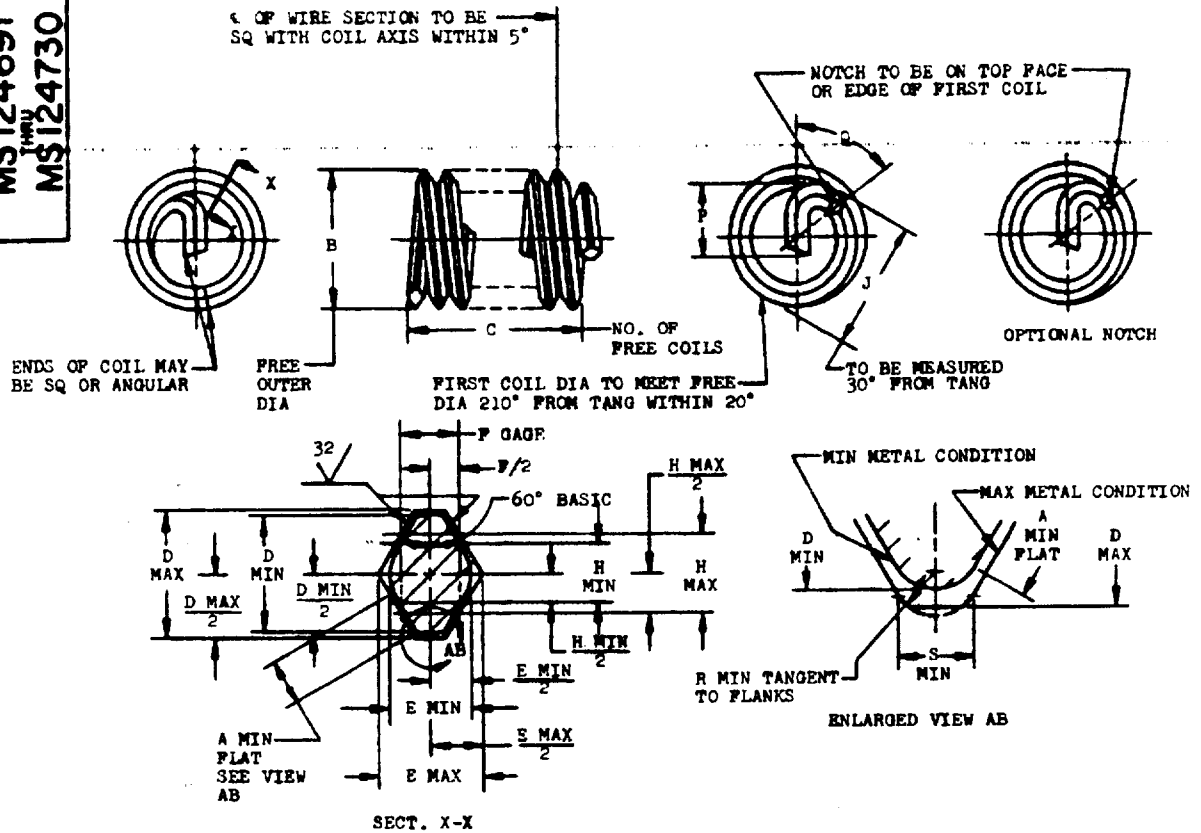


FED. SUP CLASS  
5340MS124691  
MS124730User: Army - EL, MI, ME, MU  
Navy - MC, OS  
Air Force -Army - WC  
Navy -  
Air Force - 82

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.



THREAD SIZE	NOMI- NAL LENGTH	A MIN	B		C* ±.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.099 -56	.148	.0027	.131	.146	5.625	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.112 -48	.168	.0043	.147	.162	5.625	.0190	.0226	.0152	.0182	.01042	.01313	.01353
.138 -40	.207	.0068	.173	.193	6.000	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.164 -36	.246	.0059	.204	.224	6.500	.0261	.0301	.0203	.0243	.01389	.01764	.01804
.190 -32	.285	.0076	.236	.256	6.875	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.250 -28	.375	.0085	.306	.326	8.250	.0347	.0387	.0253	.0313	.01786	.02270	.02320
.3125 -24	.469	.0120	.380	.400	8.875	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.375 -24	.562	.0120	.448	.468	11.000	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.4375 -20	.656	.0164	.524	.549	10.625	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.500 -20	.750	.0164	.592	.617	12.375	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.5625 -18	.844	.0176	.666	.691	12.500	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.625 -18	.938	.0176	.733	.758	14.125	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.750 -16	1.125	.0215	.876	.901	15.125	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.875 -14	1.312	.0267	1.021	1.051	15.500	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.000 -12	1.500	.0334	1.169	1.199	15.750	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.000 -14(b)	1.500	.0267	1.156	1.186	17.875	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.125 -12	1.688	.0334	1.304	1.334	17.250	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.250 -12	1.875	.0334	1.439	1.469	19.375	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.375 -12	2.062	.0334	1.575	1.610	21.375	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.500 -12	2.250	.0334	1.710	1.745	23.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413

(E) 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 Code	Army - AV Navy - AS	INSERT, CRES HELICAL COIL FINE THREAD, 1-1/2 DIA NOMINAL LENGTH	MS 124691 MS 124730
PROCUREMENT SPECIFICATION	MIL-I-8846	SUPERSEDES	SHEET 1 OF 2
		MS12108 IN PART	

Project No. 5340-2005

APPROVED 29 Mar 53 REVISED A 28 Nov 55 B 26 May 59 C 24 Oct 66 D 15 Oct 69 E 24 Feb 76

FED. SUP CLASS,  
5340MS124691  
THRU  
MS124730User 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)
.0094 -56	.134	.146	.072	.090	75° -150°	.0032	.0056	.0084	MS124710	<del>MS124713 MS124714</del>
.112 -48	.134	.150	.060	.095	75° -150°	.0038	.0065	.0160	MS124711	
.138 -40			.100	.130	25° -100°	.0045	.0078	.0304	MS124693	
.164 -36			.117	.147	20° -100°	.0050	.0087	.0502	MS124694	
.190 -32			.130	.176	15° - 90°	.0056	.0098	.0784	MS124695	MS124715
.250 -28			.173	.239	15° - 70°	.0064	.0112	.155	MS124696	MS124716
.3125 -24	.359	.377	.203	.291	15° - 55°	.0075	.0130	.284	MS124697	MS124717
.375 -24	.422	.439	.235	.353	15° - 75°	.0075	.0130	.420	MS124698	MS124718
.4375 -20	.494	.514	.281	.416	15° - 75°	.0090	.0156	.699	MS124699	MS124719
.500 -20	.556	.576	.313	.476	15° - 75°	.0090	.0156	.909	MS124700	MS124720
.5625 -18	.625	.645	.344	.541	15° - 75°	.0100	.0174	1.266	MS124701	MS124721
.625 -18	.688	.708	.375	.588	15° - 75°	.0100	.0174	1.562	MS124702	MS124722
.750 -16	.820	.840	.453	.682	15° - 75°	.0113	.0195	2.564	MS124703	MS124723
.875 -14	.955	.980	.500	.740	15° - 75°	.0129	.0223	4.000	MS124704	MS124724
1.000 -12	1.094	1.119	.526	.778	15° - 75°	.0150	.0260	6.063	MS124691	<del>MS124705</del> MS124725
1.000 -14(b)	1.080	1.105	.526	.750	15° - 75°	.0129	.0223	5.263	<del>MS124705</del>	
1.125 -12	1.219	1.244	.557	.819	10° - 70°	.0150	.0260	7.572	MS124706	MS124726
1.250 -12	1.344	1.369	.679	.941	10° - 70°	.0150	.0260	9.502	MS124707	MS124727
1.375 -12	1.469	1.493	.684	1.001	10° - 70°	.0150	.0260	11.276	MS124708	MS124728
1.500 -12	1.594	1.624	.811	1.123	10° - 70°	.0150	.0260	13.650	MS124709	MS124729

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 NPG)
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 INACTIVATED INSERTS, BUT THE INACTIVATED INSERTS CANNOT REPLACE THE SUPERSEDING NOTCHED INSERTS.
- (b) MS124705 INACTIVE FOR DESIGN AFTER 15 OCTOBER 1969. NO SUPERSEDING STANDARD.

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. USAP - 11	TITLE	MILITARY STANDARD
Other Com Army - AV Navy - AS	INSERT, CRES HELICAL COIL FINE THREAD, 1-1/2 DIA NOMINAL LENGTH	MS 124691 THRU MS 124730
PROCUREMENT SPECIFICATION MIL-I-8846	SUPERSEDES MS21208 IN PART	REPT 2 OF 2

APPROVED 27 May 53 REVISED A 28 Nov 55 B 26 May 57 C 24 Oct 66 E FOR CHANGES SEE SHEETS 1 AND 2