

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

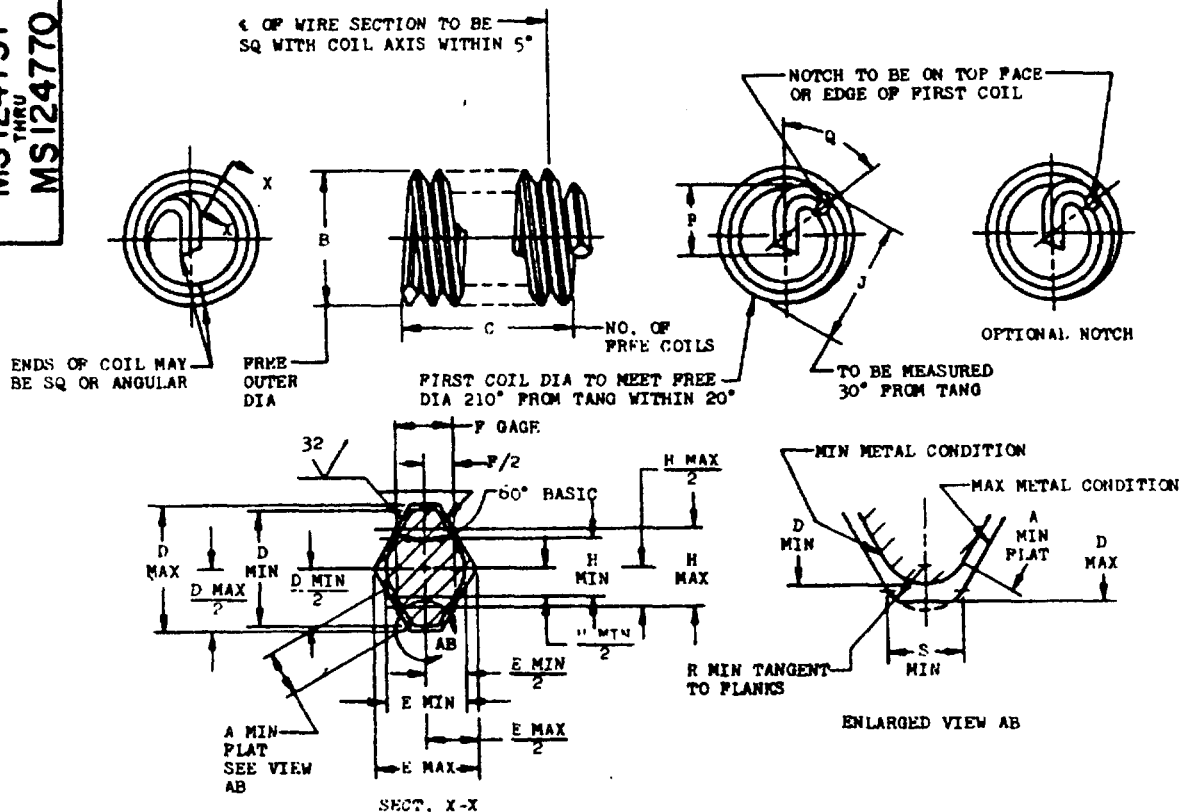
Army - WC
Navy -
Air Force - 82

Review activity:

This military 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.

MS124731
THRU
MS124770

FED. SUP CLASS
5340



THREAD SIZE	NOMINAL LENGTH	A MIN	B		C ±.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.099 -56	.198	.0027	.131	.146	8.000	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.112 -48	.224	.0043	.147	.162	7.875	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.138 -40	.276	.0068	.173	.193	8.375	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.164 -36	.328	.0059	.204	.224	9.125	.0261	.0301	.0203	.0243	.01389	.01764	.01874
.190 -32	.380	.0076	.236	.256	9.500	.0295	.0338	.0233	.0273	.01563	.01965	.02030
.250 -28	.500	.0085	.306	.326	11.375	.0347	.0387	.0253	.0313	.01786	.02270	.02320
.3125 -24	.625	.0120	.380	.400	12.250	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.375 -24	.750	.0120	.448	.468	15.000	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.4375 -20	.875	.0164	.524	.544	14.625	.0500	.0540	.0378	.0438	.02500	.03196	.03248
.500 -20	1.000	.0164	.592	.617	16.875	.0500	.0540	.0378	.0438	.02500	.03196	.03248
.5625 -18	1.125	.0176	.566	.601	17.125	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.625 -18	1.250	.0176	.733	.752	19.250	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.750 -16	1.500	.0215	.876	.901	20.625	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.875 -14	1.750	.0267	1.021	1.051	21.125	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.000 -12	2.000	.0334	1.167	1.199	20.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.000 -14(b)	2.000	.0267	1.156	1.186	24.250	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.125 -12	2.250	.0334	1.304	1.334	21.375	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.250 -12	2.500	.0334	1.439	1.469	26.250	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.375 -12	2.750	.0334	1.575	1.610	28.875	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.500 -12	3.000	.0334	1.710	1.745	31.625	.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 Case	Army - AV Navy - AS	INSERT, JRES HELICAL COIL FINE THREAD, 2 DIA NOMINAL LENGTH	MS 124731 THRU 124770
PROCUREMENT SPECIFICATION	SUPERSEDES:	MS21208 IN PART	SHEET 1 OF 2
MIL-I-8846			

Project No. 5340-2006

APPROVED 25 May 53 REVISED A 26 May 59 B 24 Oct 66 C 15 Oct 65 D 24 Feb 76

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

Review activities: Army - WC
Navy -
Air Force - B2

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MS124770

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(D)

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	.0117	MS124750	MS124753 MS124754
.112 -48	.134	.150	.060	.095	75° -150°	.0038	.0065	.0222	MS124751	
.138 -40			.100	.130	25° -100°	.0045	.0078	.0408	MS124733	
.164 -36			.117	.147	20° -100°	.0050	.0087	.0680	MS124734	
.200 -32			.130	.170	15° - 90°	.0050	.0098	.112	MS124735	MS124755
.250 -26			.173	.239	15° - 75°	.0064	.0112	.212	MS124736	MS124756
.3125 -24	.359	.377	.203	.291	15° - 55°	.0075	.0130	.397	MS124737	MS124757
.375 -24	.422	.439	.235	.353	15° - 75°	.0075	.0130	.553	MS124738	MS124758
.4375 -20	.494	.514	.281	.416	15° - 75°	.0090	.0156	.917	MS124739	MS124759
.500 -20	.556	.576	.313	.478	15° - 75°	.0090	.0156	1.234	MS124740	MS124760
.5625 -18	.625	.645	.344	.541	15° - 75°	.0100	.0174	1.695	MS124741	MS124761
.625 -18	.686	.708	.375	.588	15° - 75°	.0100	.0174	2.083	MS124742	MS124762
.750 -16	.820	.840	.453	.562	15° - 75°	.0113	.0195	3.448	MS124743	MS124763
.875 -14	.955	.980	.500	.640	15° - 75°	.0129	.0223	5.263	MS124744	MS124764
1.000 -12	1.094	1.110	.526	.728	15° - 75°	.0150	.0260	8.168	MS124731	MS124745 MS124765
1.000 -14(b)	1.080	1.105	.526	.750	15° - 75°	.0129	.0223	6.667	MS124745	
1.125 -12	1.214	1.244	.557	.819	10° - 75°	.0150	.0260	10.227	MS124746	MS124766
1.250 -12	1.344	1.364	.674	.941	10° - 75°	.0150	.0260	12.750	MS124747	MS124767
1.375 -12	1.469	1.494	.689	1.001	10° - 75°	.0150	.0260	15.194	MS124748	MS124768
1.500 -12	1.594	1.624	.811	1.123	10° - 75°	.0150	.0260	18.501	MS124749	MS124769

- ** 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: ANSI #46.1-1962
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) MS124745 INACTIVE FOR DESIGN AFTER 15 OCTOBER 1969. NO SUPERSEDING STANDARD.

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P.A.	USAF - 11	TITLE	MILITARY STANDARD
Other Cost	Army - AY Navy - AS	INSERT, DRES HELICAL COIL FINE THREAD, 2 DIA NOMINAL LENGTH	MS124731 THRU MS124770
PROCUREMENT SPECIFICATION MIL-I-8846	SUPERSEDES	MS21208 IN PART	SHEET 2 OF 2

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