

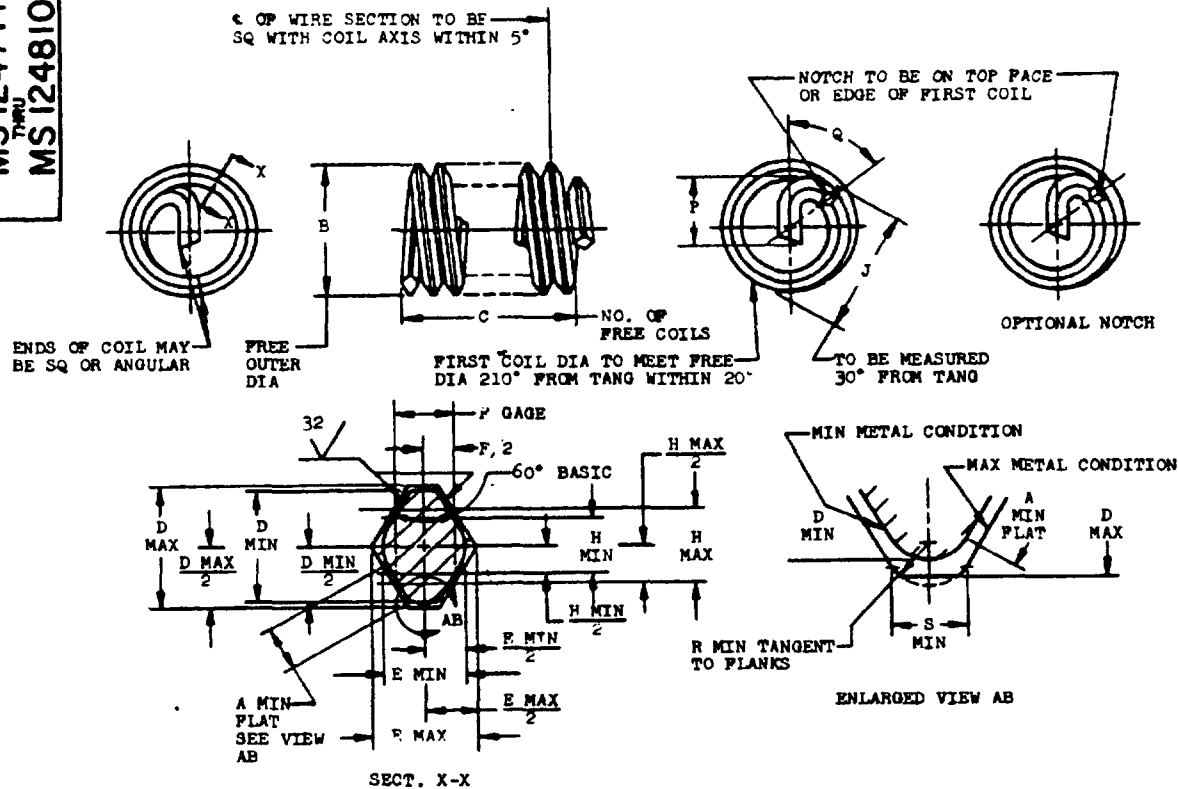
FED. SUP CLASS

5340

MS124771
THRU
MS124810User: Army - EL, ME, MG, MU
Navy - MG, OS
Air Force -Army - WC
Navy -

Review attn:

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	.248	.0027	.131	.146	10.375	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.112 -48	.280	.0043	.147	.162	10.250	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.136 -40	.345	.0068	.173	.193	10.750	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.164 -36	.410	.0059	.204	.224	11.625	.0261	.0301	.0203	.0243	.01389	.01764	.01804
.190 -32	.475	.0076	.236	.256	12.250	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.250 -28	.625	.0085	.303	.326	14.500	.0347	.0387	.0253	.0313	.01786	.02270	.02320
.3125 -24	.781	.0120	.380	.400	15.625	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.375 -24	.938	.0120	.448	.468	19.125	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.4375 -20	1.094	.0164	.524	.549	18.500	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.500 -20	1.250	.0164	.592	.617	21.375	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.5625 -18	1.406	.0176	.666	.691	21.750	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.625 -18	1.562	.0176	.733	.758	24.250	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.750 -16	1.875	.0215	.876	.901	26.000	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.875 -14	2.188	.0267	1.021	1.051	26.625	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.000 -12	2.500	.0334	1.169	1.199	26.000	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.000 -14(b)	2.500	.0267	1.156	1.186	30.625	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.125 -12	2.812	.0334	1.304	1.344	29.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.250 -12	3.125	.0334	1.439	1.469	33.000	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.375 -12	3.438	.0334	1.575	1.610	36.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.500 -12	3.750	.0334	1.710	1.745	39.875	.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 Cost	Army - AV Navy - AS	INSERT, CRES HELICAL COIL FINE THREAD, 2-1/2 DIA NOMINAL LENGTH	MS 124771 THRU MS 124810
PROCUREMENT SPECIFICATION	MIL-I-5846	SUPERSEDES:	SHEET 1 OF 2

MS21208 IN PART

Project No. 5340-2007

APPROVED 29 May 53 REVISED (A) 26 May 59 (B) 24 Oct 66 (C) 15 Oct 69 (D) 24 Feb 76

FED. SUP CLASS
534CMS124771
THRU
MS124810User: Army - EL, ME, MT, 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)
.099 -56	.124	.146	.072	.090	75° -150°	.0032	.0056	.0192	MS124790	
.112 -48	.134	.150	.060	.095	75° -150°	.0038	.0065	.0285	MS124791	
.138 -40			.100	.130	25° -100°	.0045	.0078	.0512	MS124773	MS124793
.164 -36			.117	.147	20° -100°	.0050	.0087	.0857	MS124774	MS124794
.190 -32			.130	.176	15° - 90°	.0056	.0098	.140	MS124775	MS124795
.250 -28			.173	.239	15° - 70°	.0064	.0112	.276	MS124776	MS124796
.3125 -24	.359	.377	.203	.291	15° - 55°	.0075	.0130	.490	MS124777	MS124797
.375 -24	.422	.439	.235	.353	15° - 75°	.0075	.0130	.709	MS124778	MS124798
.4375 -20	.494	.514	.281	.416	15° - 75°	.0090	.0156	1.250	MS124779	MS124799
.500 -20	.556	.576	.313	.478	15° - 75°	.0090	.0156	1.563	MS124780	MS124800
.5625 -18	.625	.645	.344	.541	15° - 75°	.0100	.0174	2.128	MS124781	MS124801
.625 -18	.688	.708	.375	.588	15° - 75°	.0100	.0174	2.632	MS124782	MS124802
.750 -16	.820	.840	.453	.562	15° - 75°	.0113	.0195	4.348	MS124783	MS124803
.875 -14	.955	.980	.500	.640	15° - 75°	.0129	.0223	6.667	MS124784	MS124804
1.000 -12	1.094	1.119	.526	.728	15° - 75°	.0150	.0260	10.406	MS124771	MS124805
1.000 -14 (b)	1.080	1.105	.526	.750	15° - 75°	.0129	.0223	8.333	MS124785	MS124805
1.125 -12	1.219	1.244	.557	.819	10° - 70°	.0150	.0260	12.882	MS124786	MS124806
1.250 -12	1.344	1.369	.679	.941	10° - 70°	.0150	.0260	15.998	MS124787	MS124807
1.375 -12	1.469	1.499	.689	1.001	10° - 70°	.0150	.0260	19.111	MS124788	MS124808
1.500 -12	1.594	1.624	.811	1.123	10° - 70°	.0150	.0260	23.352	MS124789	MS124809

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 MP0).
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) MS124785 INACTIVE FOR DESIGN AFTER 15 OCTOBER 1969.. NO SUPERSEDING STANDARD.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.

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P.A.	USAP - 11	TITLE	MILITARY STANDARD
Other Code	Army - AV Navy - AS	INSERT, CRES HELICAL COIL FINE THREAD, 2-1/2 DIA NOMINAL LENGTH	MS 124771 THRU 124810
PROCUREMENT SPECIFICATION	MIL-I-8846	SUPERSEDES:	SHEET 2 OF 2
		MS12478 IN PART	

FOR CHANGES SEE SHEETS 1 AND 2

APPROVED 29 May 53 REVISED A 26 May 59 B 24 Oct