

User: Army-EL, M.F., M., MU
Navy-MC, OS
Air Force-

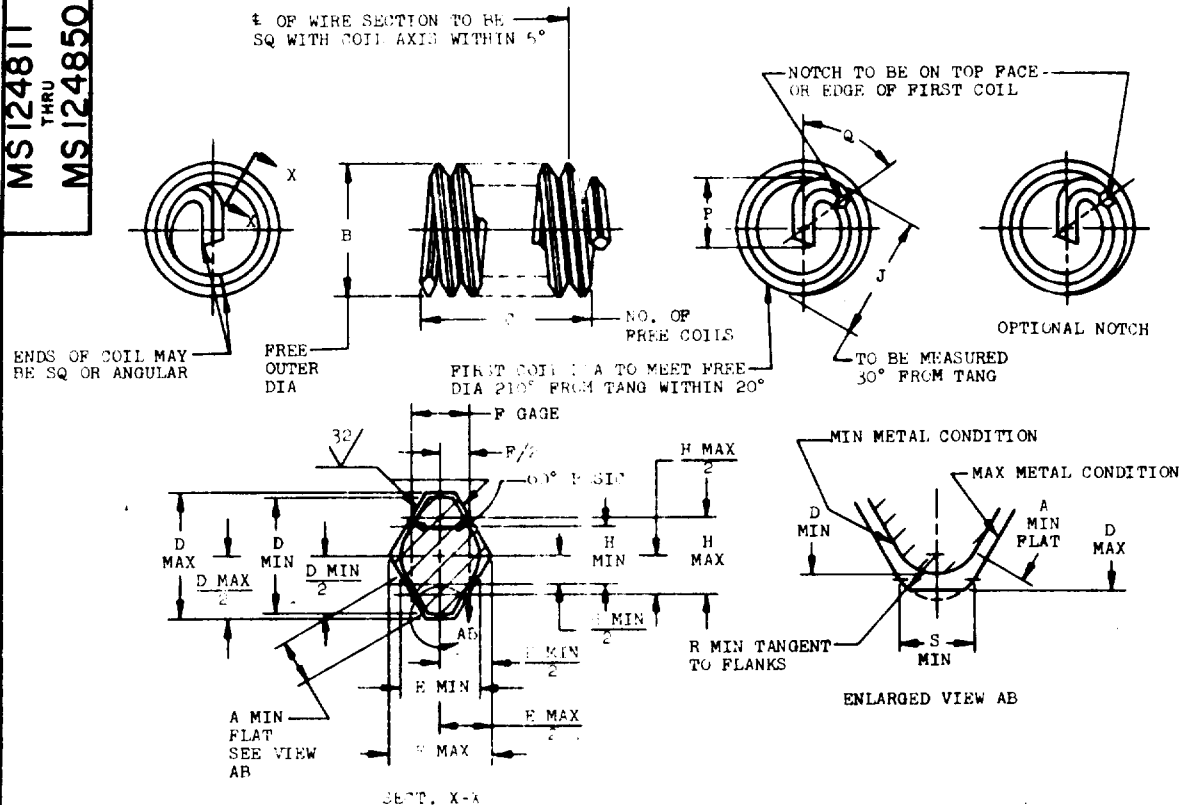
my-WC
Navy-
Air Force-82

Review activities

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.

MS124811
THRU
MS124850

FED. SUP CLASS
5340



THREAD SIZE	NOMI- NAL LENGTH	A MIN	B		O [*] 1.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.099 -56	.297	.0027	.13	.146	12.625	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.112 -48	.336	.0043	.147	.162	12.500	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.138 -40	.414	.0068	.173	.193	13.250	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.164 -36	.492	.0059	.204	.224	14.250	.0261	.0301	.0203	.0243	.01389	.01764	.01804
.190 -32	.570	.0076	.236	.255	14.875	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.250 -28	.750	.0085	.306	.326	17.625	.0347	.0387	.0253	.0313	.01786	.02270	.02320
.3125 -24	.938	.0120	.380	.400	19.000	.0410	.0446	.0305	.0365	.02083	.02656	.02706
.375 -24	1.125	.0120	.448	.468	23.125	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.4375 -20	1.312	.0164	.524	.549	22.500	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.500 -20	1.500	.0164	.592	.617	25.875	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.5625 -18	1.688	.0176	.666	.691	26.250	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.625 -18	1.875	.0176	.733	.758	29.375	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.750 -16	2.250	.0215	.876	.901	31.500	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.875 -14	2.625	.0267	1.021	1.051	32.250	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.000 -12	3.000	.0334	1.169	1.199	31.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.000 -14(b)	3.000	.0267	1.156	1.186	37.000	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.125 -12	3.375	.0334	1.304	1.334	35.750	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.250 -12	3.750	.0334	1.439	1.469	39.875	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.375 -12	4.125	.0334	1.575	1.610	44.000	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.500 -12	4.500	.0334	1.710	1.745	48.125	.0861	.0900	.0649	.0729	.04167	.05363	.05413

(D) FOR CHANGE SEE SHEET 1 AND 2.

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.

P.A.	USAF - 11	TITLE	MILITARY STANDARD
Other Com	Army - AV Navy - AS	INSERT, CRES HELICAL COIL FINE THREAD, 3 DIA NOMINAL LENGTH	MS 124811 THRU 124850
PROCUREMENT SPECIFICATION	SUPERSEDES:	MS12108 IN PART	SHEET 1 OF 2
MIL-I-8846			

Project No. 5340-2008

APPROVED 25 May 53 REVISED A 26 May 59 B 24 Oct 66 C 15 Oct 69 D 24 Feb 76

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

Review activities: Army - WC
 Navy -
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MS 124811
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FED. SUP CLASS
 5340

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	.0234	MS124830	
	.112-48	.134	.150	.060	.095	75°-150°	.0038	.0065	.0346	MS124831	
	.138-40			.100	.130	25°-100°	.0045	.0078	.0616	MS124813	MS124833
	.164-36			.117	.147	20°-100°	.0050	.0087	.1034	MS124814	MS124834
	.190-32			.130	.176	15°-90°	.0056	.0098	.170	MS124815	MS124835
	.250-28			.173	.239	15°-70°	.0064	.0112	.338	MS124816	MS124836
	.3125-24	.359	.377	.203	.291	15°-55°	.0075	.0130	.602	MS124817	MS124837
	.375-24	.422	.439	.235	.353	15°-75°	.0075	.0130	.862	MS124818	MS124838
	.4375-20	.494	.514	.281	.416	15°-75°	.0090	.0156	1.493	MS124819	MS124839
	.500-20	.556	.576	.313	.478	15°-75°	.0090	.0156	1.887	MS124820	MS124840
	.5625-18	.625	.645	.344	.541	15°-75°	.0100	.0174	2.564	MS124821	MS124841
	.625-18	.688	.708	.375	.588	15°-75°	.0100	.0174	3.030	MS124822	MS124842
	.750-16	.820	.840	.453	.562	15°-75°	.0113	.0195	5.263	MS124823	MS124843
	.875-14	.955	.980	.500	.640	15°-75°	.0129	.0223	7.692	MS124824	MS124844
	1.000-12	1.094	1.119	.526	.728	15°-75°	.0150	.0260	12.815	MS124811	
	1.000-14(b)	1.080	1.105	.526	.750	15°-75°	.0129	.0223	10.000	MS124825	MS124845
	1.125-12	1.219	1.244	.557	.819	10°-70°	.0150	.0260	15.536	MS124826	MS124846
	1.250-12	1.344	1.369	.679	.941	10°-70°	.0150	.0260	19.246	MS124827	MS124847
	1.375-12	1.469	1.499	.689	1.001	10°-70°	.0150	.0260	23.028	MS124828	MS124848
	1.500-12	1.594	1.624	.811	1.123	10°-70°	.0150	.0260	28.274	MS124829	MS124849

- ** 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 MPQ).
 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) MS124825 INACTIVE FOR DESIGN AFTER 15 OCT 1969. NO SUPERSEDING STANDARD.

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 THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.

P.A. Other Cost	USAP - 11	TITLE INSERT, CRES HELICAL COIL FINE THREAD, 3 DIA NOMINAL LENGTH	MILITARY STANDARD	
	Army - AV Navy - AS		MS 124811 THRU MS 124850	
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 C FOR CHANGES SEE SHEETS 1 AND 2.