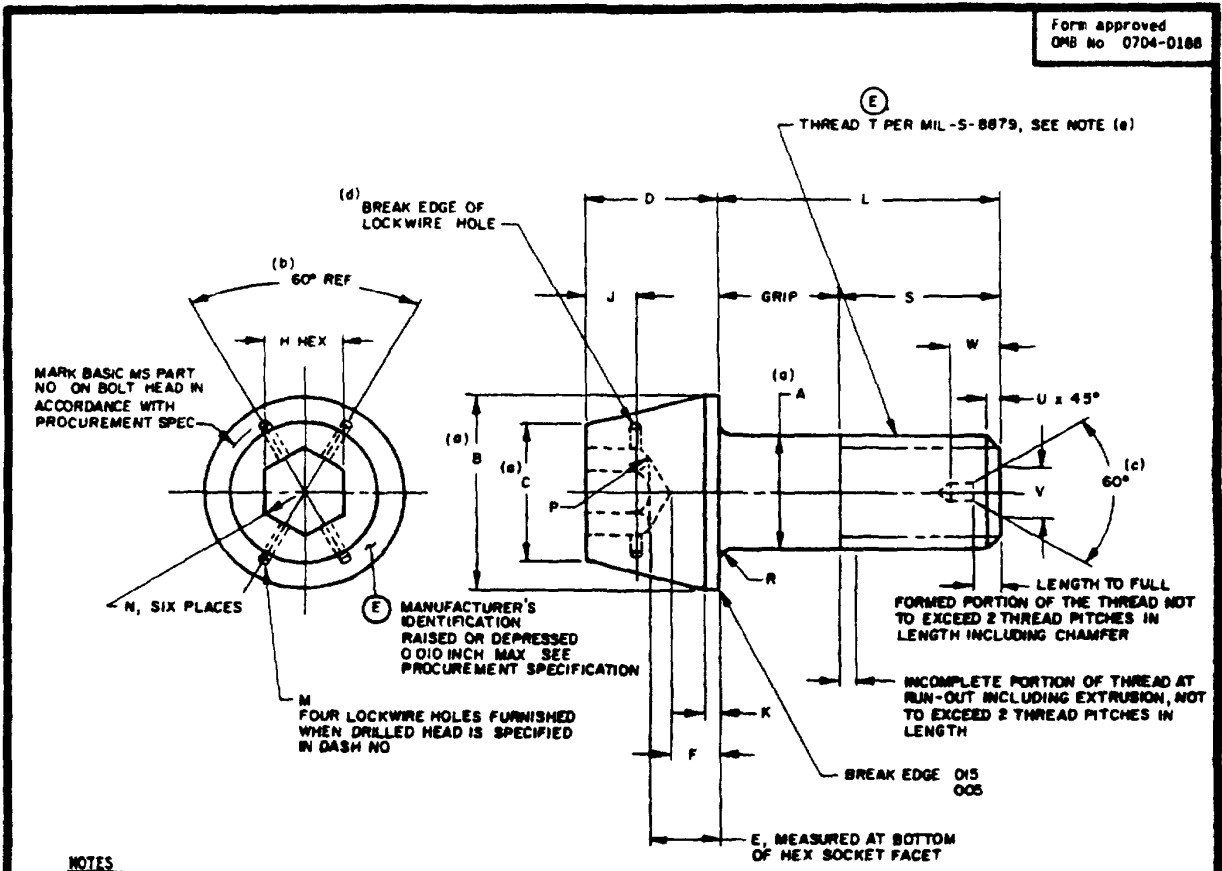


THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DOORS SPECIFIED IN THE SOLICITATION MIL-B-7836



**NOTES**

- (a) DIMENSIONS A, B AND C SHALL BE CONCENTRIC TO EACH OTHER WITHIN VALUES SPECIFIED FOR X TOTAL INDICATOR READING. DIMENSIONS SHALL BE H AND C SHALL BE CONCENTRIC TO EACH OTHER WITHIN VALUES SPECIFIED FOR Y TOTAL INDICATOR READING. DIMENSION A AND THREAD PITCH DIAMETER SHALL BE CONCENTRIC TO EACH OTHER WITHIN VALUES SPECIFIED FOR Z TOTAL INDICATOR READING.
- (b) REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES AND TO PROVIDE INFORMATION ONLY. THESE DIMENSIONS ARE NOT INSPECTION OR MANUFACTURING REQUIREMENTS. S MIN REF = (L MIN) - (GRIP MAX).
- (c) ON MS20012 THRU MS20024 CENTER DRILLING OF SHANK IS OPTIONAL FOR BOLT MANUFACTURER.
- (d) COUNTERSINKING OF DRILLED HOLES IS OPTIONAL.
- (e) MS20016 (SEE TABLE 1), 1-14NS-3A IS INACTIVE FOR NEW DESIGN MS20016 THREADS ARE NOTED AS AN EXCEPTION IN MIL-B-7836
- (f) MS20012A IS CANCELLED AFTER 13 JANUARY 1990

**REQUIREMENTS**

- 1 MATERIAL ALLOY STEEL - UNS G43400, UNS G43406, UNS G41400, UNS G87400, UNS G87350
  - 2 FINISH CADMIUM PLATING PER QQ-P-416, TYPE II, CLASS 2 PARTS WITH CLASS 3 PLATING MAY BE FURNISHED FROM SUPPLIER'S STOCK UNTIL 1 JANUARY 1975.
  - 3 HARDNESS 34-40 HRC
  - 4. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED, TOLERANCES DECIMALS - 010, ANGLES ±1°
  - 5 DIMENSIONS TO BE MET AFTER PLATING
- INTERCHANGEABILITY RELATIONSHIP
- BOLTS WITH TYPE II PLATING CAN BE USED TO REPLACE BOLTS WITH TYPE I PLATING IN ALL APPLICATIONS  
BOLTS WITH TYPE I PLATING CAN BE USED IN PLACE OF BOLTS WITH TYPE II PLATING UNTIL PRESENT STOCKS ARE DEPLETED, BUT BOLTS WITH TYPE I PLATING SHALL NOT BE USED AFTER 1 JANUARY 1964

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID

(E) DENOTES CHANGES

PREPARING ACTIVITY NAVY - AS CUSTODIANS ARMY-AR NAVY- AIR FORCE-99 DLA- REVIEW ARMY - ER, ME, MI DLA - 15 AF-87 USER ARMY - AV PROJECT NUMBER 5306-123E	MILITARY SPECIFICATION SHEET TITLE BOLTS, INTERNAL WRENCHING, 160 KSI FTU AND 90 KSI FSL	SPECIFICATION SHEET NUMBER 30 MAY 1989 <b>MS20004E THRU 20024E</b> SUPERSEDING MS20004D THRU 20024D 10 AUGUST 1981 AMSC- N/A FSC 5306
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(E) TABLE I BOLT DIMENSIONS AND TENSILE STRENGTH

BASIC MS PART NO	(a) THREAD T	(a) A DIA		(a) B DIA		(a) C DIA	D	E	F MIN	(a) H HEX		J	K	M +.005 -.000 DIA	N MAX RAD
		MAX	MIN	MAX	MIN					MAX	MIN				
MS20004	1/4-28 UNJF-3A	.2492	.2477	.438	.428	.342	.250	.112	.068	.1900	.1880	.078			.010
MS20005	5/16-24 UNJF-3A	.3117	.3102	.531	.521	.394	.312	.144	.094	2.210	2.190	.094			.011
MS20006	3/8-24 UNJF-3A	.3742	.3727	.649	.639	.520	.375	.183	.116	3.150	3.130	.125			.019
MS20007	7/16-20 UNJF-3A	.4367	.4347	.750	.740	.534	.438	.208	.147	3.785	3.755	.172			.022
MS20008	1/2-20 UNJF-3A	.4991	.4971	.828	.818	.625	.500	.247	.169	4.410	4.380	.203			.022
MS20009	9/16-18 UNJF-3A	.5616	.5596	.938	.928	.723	.562	.279	.190	5.035	5.005	.234			.022
MS20010	5/8-18 UNJF-3A	.6240	.6220	1.050	1.040	.826	.625	.317	.216	5.660	5.630	.281			.022
MS20012	3/4-16 UNJF-3A	.7488	.7468	1.230	1.220	.921	.750	.385	.273	6.295	6.257	.344			.022
MS20014	7/8-14 UNJF-3A	.8737	.8707	1.438	1.428	1.083	.875	.450	.327	7.547	7.507	.391			.022
MS20016 *	1-14 NS-3A		.9955	1.625	1.615	1.249	1.000	.527	.381			.453			.022
MS20017	1-12 UNJF-3A	9985								7.547	7.507	.391			.022
MS20018	1-1/8-12 UNJF-3A	1.124								1.125	.589	.443			.022
MS20020	1-1/4-12 UNJF-3A	2.249								1.005	1.001	.500	.125		.022
MS20022	1-3/8-12 UNJF-3A	3.374								1.375	.746	.531	.131		.022
MS20024	1-1/2-12 UNJF-3A	4.499								1.500	.823	.586	1.256		.022
MS20012A	3/4-16 UNJF-3A	.7488	.7468	1.230	1.220	.921	.750	.385	.273	6.295	6.257	.344			.022

(E) SEE NOTE (f)

TABLE I (CONTINUED)

BASIC MS PART NO	P RAD		P RAD		(b) S MIN REF	U ±.016	(c) V MAX	(c) W MAX	(b) (c) CENTER DRILL SIZE REF	TENSILE STRENGTH LB MIN	(a) CONCENTRICITY		
	MAX	MIN	MAX	MIN							X	Y	Z
MS20004			.041	.031	.475	.031				6,190	.005	.007	
MS20005					.537					9,820	.006	.008	0045
MS20006					.662	.047				15,200	.008	.010	
MS20007	020	010			.787					20,400	.009	.011	
MS20008			.057	.047						27,400	.010	.012	
MS20009					.850					34,800	.011	.014	.006
MS20010					.912	.062				43,600	.012	.016	
MS20012					1.037		187	200	2	63,200	.015	.018	
MS20014					1.162					86,100	.018	.022	
MS20016 *			073	063	1.287	.078				112,000	.020	.025	.009
MS20017	030	015			1.475		250	260	3	114,000	.022	.026	
MS20018					1.600					144,000	.025	.032	
MS20020			.089	.077	1.725	.094	.312	320	4	180,000	.028	.035	.012
MS20022					1.850					219,000	.030	.039	
MS20024					2.000					263,000	.035	.045	
MS20012A			.073	.063	1.162	.062	187	200	2	63,200	.015	.018	.006

(E) SEE NOTE (f)

\* SEE NOTE (a)

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PREPARING ACTIVITY NAVY - AS  
CUSTODIANS ARMY - AP NAVY -  
AIR FORCE - 99 DLA -  
REVIEW ARMY - EP, ME, MI DLA - IS AF - HC  
USER ARMY - AV  
PROJECT NUMBER 5306-1233

MILITARY SPECIFICATION SHEET  
TITLE BOLTS, INTERNAL WRENCHING, 160 KSI FTU  
AND 96 KSI FSL

SPECIFICATION SHEET NUMBER 30 MAY 1989  
MS20004E THRU 20024E  
SUPERSEDING  
MS20004D THRU 20024D 10 AUGUST 1981  
AMSC - N/A FSC 5306

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DD FORM 672 MAY 1988

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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UNASSIGNED DASH NUMBERS SHALL NOT BE USED, EXCEPT THOSE DASH NUMBERS COVERED BY THE FOLLOWING CODING NOTE

DASH NUMBERS INDICATE PREFERRED GRIP LENGTHS IN 125 INCREMENTS. INTERMEDIATE GRIP LENGTHS BETWEEN THOSE LENGTHS LISTED, MAY BE SPECIFIED IN .062 INCREMENTS BY INTERMEDIATE DASH NUMBERS. LENGTH AND GRIP OF A BOLT WITH AN ODD NUMBER FOR THE DASH NUMBER WILL BE .062 GREATER THAN SHOWN FOR THE BOLTS WITH THE PRECEDING EVEN DASH NUMBER. ONLY BOLT DIAMETER FOR WHICH THERE ARE QUALIFIED PRODUCTS LISTED ON QPL-7838 SHALL BE USED FOR DESIGN.

FOR EACH BOLT DIAMETER GRIP LENGTHS GREATER OR LESS THAN THOSE DESIGNATED BY ASSIGNED DASH NUMBERS ON TABLE II ARE INACTIVE FOR DESIGN.

ADD "H" BEFORE DASH NUMBER FOR BOLT WITH DRILLED HEAD

EXAMPLES OF PART NUMBERS MS20017-18 = 1-12 BOLT, 2.438 INCH LONG, 1.125 INCH GRIP, UNDRILLED HEAD  
MS20017H18 = 1-12 BOLT, 2.438 INCH LONG, 1.125 INCH GRIP, DRILLED HEAD.

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PREPARING ACTIVITY NAVY - AS  
CUSTODIANS ARMY - AR NAVY -  
AIR FORCE - 99 DLA -  
REVIEW ARMY - ER, ME, MI DLA - 15 AF - 62  
USER ARMY - AV  
PROJECT NUMBER 5306-12 14

MILITARY SPECIFICATION SHEET  
TITLE BOLT - INTERNAL WRENCHING, 160 KS; FTU  
AND 96 KS; FSL

SPECIFICATION SHEET NUMBER 30 MAY 1989  
MS20004E THRU 20024E  
SUPERSEDING  
MS20004D THRU 20024D 10 AUGUST 1981  
AWSC - N/A FSC 5306

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