

USER SYMBOLS:

REVIEWER SYMBOLS:

ARMY - AV
DLA - IS
NAVY - AS
USAF - 99

"Review/revise" information is current as of the date of this document.
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This military standard is approved for use by all Departments
& Agencies of the Department of Defense. Selection for all new
engineering and design applications and for replacing use shall
be made from this document.

P.A.
NAVY - AS
Other Code

USAF - 11
ARMY - AV

PROCUREMENT SPECIFICATION
MIL-B-23964

TITLE

BOLT, SELF-RETAINING, POSITIVE LOCKING, CRES
90 KSI F_{tu}, 63 KSI F_{ty}, PAN HEAD, 450°F & 650°F

SUPERSEDES

MS21125 (ASG)

MILITARY STANDARD

MS21125

SHEET 1 OF 6

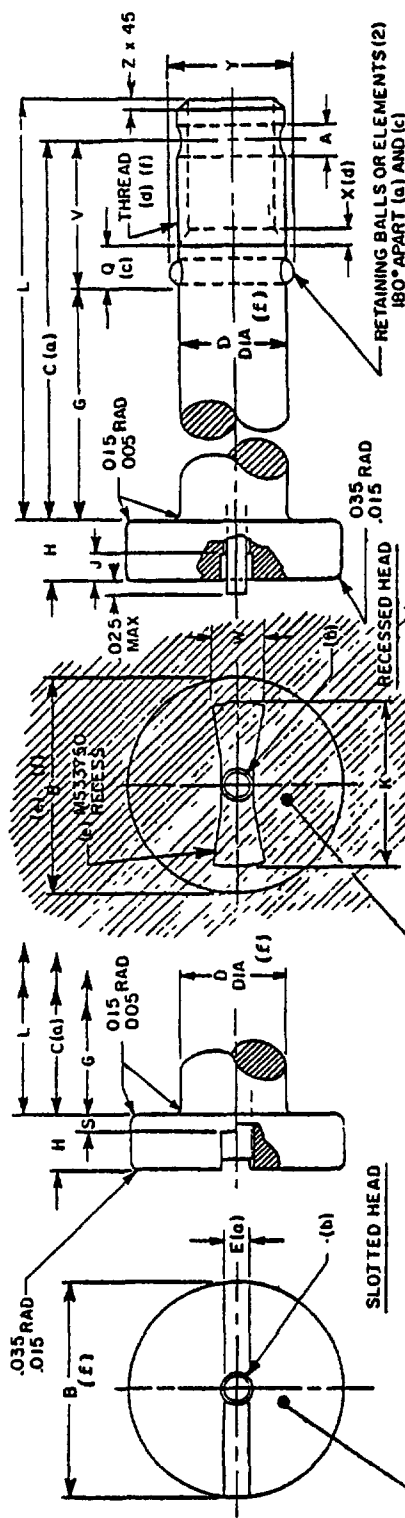
DD FORM 1347-672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PROJECT NO. 5306-0802

PLATE NO. 23065

FED SUP CLASS
5306



INACTIVE FOR DESIGN AFTER 15 MAY 1981
CANCELLED AFTER 1 JUN 1981 USE SLOTTED
HEAD

MARK MS21125A (FOR A-286 MATERIAL) OR
MS21125B (FOR PH 13-8Mo MATERIAL)
AND MANUFACTURERS IDENTIFICATION,
RAISED OR DEPRESSED .010 MAX.

F DENOTES CHANGE

APPROVED 15 DEC 67 REVISED D 12 OCT 79 E 11 MARCH 1981 F 30 APRIL 1983

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TABLE I																												
DIA DASH NO.	THREAD DESIGNATION MIL-S-8879	A		B (E)		D (F)		E		H		J		K		(C) Q		S		V		W		Y		Z		(e) RECESS NO.
		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	BASIC	MAX	MIN	MAX	MIN	MAX	MIN	MAX	
3	.1900-32 UNJF-3A	.080	.070	.374	.360	1.894	1.889	.057	.047	.110	.095	.057	.054	.270	.094	.079	.032	.022	.293	.098	.094	.225	.215	.041	.021			2
4	.2500-28 UNJF-3A	.086	.076	.492	.477	2.492	2.487	.073	.063	.141	.126	.072	.069	.340	.125	.110			.333	.111	.107	.294	.284				3	
5	.3125-24 UNJF-3A			.625	.610	3.117	3.112	.088	.076	.172	.157	.097	.094	.545	.156	.141	.047	.037	.375	.147	.143	.360	.370					4
6	.3750-24 UNJF-3A	.116	.106	.740	.722	3.742	3.737	.104	.094	.204	.189	.111	.107	.630	.171	.156			.421	.164	.160	.445	.435	.057	.037			5
7	.4375-20 UNJF-3A			.813	.795	4.367	4.362			.235	.220	.118	.114	.730	.292	.282	.187	.063	.053	.460	.193	.188	.514	.504				6
8	.5000-20 UNJF-3A			.915	.905	4.991	4.986			.266	.251	.134	.130	.815	.341	.319	.078	.068	.523	.221	.216	.599	.589					7
9	.5625-18 UNJF-3A	.151	.141	1.035	1.015	5.616	5.611	.119	.109	.297	.282	.149	.145	.900	.265	.250	.094	.084	.628	.262	.257	.671	.661	.072	.052			8
P.A. NAVY-AS Other Cust		USAF - 11 ARMY - AV										TITLE BOLT, SE 90 KSI F																
PROCUREMENT SPECIFICATION MIL-B-23964														SUPERSEDES														

GENERAL DIMENSIONAL AND MECHANICAL REQUIREMENTS

- (a) COTTER PIN HOLE SHALL BE WITHIN .010 INCH OF BOLT CENTERLINE FOR BOLTS .312 DIA. AND SMALLER, AND WITHIN .015 INCH FOR BOLTS .375 DIA AND LARGER. THE PIN HOLE SHALL BE PERPENDICULAR TO BOLT CENTERLINE WITHIN 2". LOCATION OF COTTER PIN HOLE FROM TOP OF HEAD IS GIVEN IN C-(G MIN +V) ± .010. THE COTTER PIN HOLE SHALL BE PERPENDICULAR TO THE SLOT IN HEAD WITHIN 5". ORIENTATION OF BALLS OR ELEMENT TO COTTER PIN HOLE SHALL BE IN LINE WITHIN 5". BALL OR ELEMENT PROTRUSION FROM THE BOLT CENTERLINE SHALL BE EQUAL OR LESS THAN 1/2 Y MAX.
- (b) THE RETAINING DEVICE SHALL BE RELEASED ONLY BY DEPRESSING THE PLUNGER LOCATED IN THE HEAD OF THE BOLT. MAX DIAMETER OF PLUNGER FOR RECESS HEAD SHALL BE THE MIN VALUE FOR "W" DIMENSION ON MS21125.
- (c) BALLS OR RETAINING ELEMENTS SHALL BE LOCATED WITHIN THE LIMITS OF "Q" DIMENSION, AND AT MAXIMUM PROTRUSION SHALL FIT WITHIN THE GROVES OF THE APPROPRIATE SPACER OF MS21125 AND MS21128 WITHOUT INTERFERENCE OR BINDING.
- (d) THREAD: IN ACCORDANCE WITH MIL-S-4879 EXCEPT THAT INCOMPLETE THREAD LENGTH (A) SHALL BE A MAXIMUM OF 1-1/2 AND A MINIMUM OF 1/2 THREAD PITCHES IN LENGTH AND MAJOR DIA SHALL BE .001 LESS THAN THE MEASURED SHANK DIA.
- (e) RECESS SHALL BE LOCATED AT TRUE POSITION "B" WITHIN .010 AND SHALL CONFORM TO MS33750 EXCEPT THAT RECESS DIMPLE IS OPTIONAL.
- (f) CONCENTRICITY. D AND B TO BE CONCENTRIC TO P.D. OF THREAD WITHIN .002 TIR AT MAXIMUM MATERIAL CONDITION.

FED. SUP CLASS
5306

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MIL-B-23964

TITLE

BOLT, SELF-RETAINING, POSITIVE LOCKING, CRES
90 KSI F_u, .63 KSI F_{ty}, PAN HEAD, 450°F & 650°F

SUPERSEDES

MS21125(ASG)

MILITARY STANDARD

MS21125

SHEET 2 OF 6

APPROVED 15 DEC 67 REVISED 7 FOR CHANGES SEE SHEET 6

DD FORM 672-1 (Coordinated)

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PLATE NO. 2306

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FED. SUP CLASS
5306

TABLE II

GRIP DASH NO.	NOMINAL SIZE		1900 (10)		2500 (1/4)		3125 (5/16)		3750 (3/8)		4375 (7/16)		5000 (1/2)		5625 (9/16)		GRIP DASH NO.
	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	
03	.204	.188	.580	.560	.626	.606											03
04	.266	.250	.642	.622	.688	.668	.748	.728	.809	.789							04
05	.328	.312	.705	.685	.751	.731	.810	.790	.871	.851							05
06	.390	.375	.767	.747	.813	.793	.873	.853	.934	.914	.978	.958	1.041	1.021			06
07	.454	.438	.830	.810	.876	.856	.935	.915	.996	.976	1.040	1.020	1.103	1.083	1.244	1.224	07
08	.516	.500	.892	.872	.938	.918	.998	.978	1.059	1.039	1.103	1.083	1.166	1.146	1.306	1.286	08
09	.578	.562	.955	.935	1.001	.981	1.060	1.040	1.121	1.101	1.165	1.145	1.228	1.208	1.369	1.349	09
10	.641	.625	1.017	.997	1.063	1.043	1.123	1.103	1.184	1.164	1.228	1.208	1.291	1.271	1.431	1.411	10
11	.704	.688	1.080	1.060	1.126	1.106	1.185	1.165	1.246	1.226	1.290	1.270	1.353	1.333	1.494	1.474	11
12	.766	.750	1.142	1.122	1.188	1.168	1.248	1.228	1.309	1.289	1.353	1.333	1.416	1.396	1.556	1.536	12
13	.828	.812	1.205	1.185	1.251	1.231	1.310	1.290	1.371	1.351	1.415	1.395	1.478	1.458	1.619	1.599	13
14	.891	.875	1.267	1.247	1.313	1.293	1.373	1.353	1.434	1.414	1.478	1.458	1.541	1.521	1.681	1.661	14
15	.954	.938	1.330	1.310	1.376	1.356	1.435	1.415	1.496	1.476	1.540	1.520	1.603	1.583	1.744	1.724	15
16	1.016	1.000	1.392	1.372	1.438	1.418	1.498	1.478	1.559	1.539	1.603	1.583	1.666	1.646	1.806	1.786	16
17	1.078	1.062	1.455	1.435	1.501	1.481	1.560	1.540	1.621	1.601	1.665	1.645	1.728	1.708	1.869	1.849	17
18	1.141	1.125	1.517	1.497	1.563	1.543	1.623	1.603	1.684	1.664	1.728	1.708	1.791	1.771	1.931	1.911	18
19	1.203	1.188	1.580	1.560	1.626	1.606	1.685	1.665	1.746	1.726	1.790	1.770	1.853	1.833	1.994	1.974	19
20	1.266	1.250	1.642	1.622	1.688	1.668	1.748	1.728	1.809	1.789	1.853	1.833	1.916	1.896	2.056	2.036	20
21	1.328	1.312	1.705	1.685	1.751	1.731	1.810	1.790	1.871	1.851	1.915	1.895	1.978	1.958	2.119	2.099	21
22	1.391	1.375	1.767	1.747	1.813	1.793	1.873	1.853	1.934	1.914	1.978	1.958	2.041	2.021	2.181	2.161	22
23	1.454	1.438	1.830	1.810	1.876	1.856	1.935	1.915	1.996	1.976	2.040	2.020	2.103	2.083	2.244	2.224	23
24	1.516	1.500	1.892	1.872	1.938	1.918	1.998	1.978	2.059	2.039	2.103	2.083	2.166	2.146	2.306	2.286	24
25	1.578	1.562	1.954	1.934	2.001	1.981	2.060	2.040	2.121	2.101	2.165	2.145	2.228	2.208	2.369	2.349	25
26	1.641	1.625	2.017	1.997	2.063	2.043	2.123	2.103	2.184	2.164	2.228	2.208	2.291	2.271	2.431	2.411	26
27	1.704	1.688	2.080	2.060	2.126	2.106	2.185	2.165	2.246	2.226	2.290	2.270	2.353	2.333	2.494	2.474	27
28	1.766	1.750	2.142	2.122	2.188	2.168	2.248	2.228	2.309	2.289	2.353	2.333	2.416	2.396	2.556	2.536	28
29	1.828	1.812	2.205	2.185	2.251	2.231	2.310	2.290	2.371	2.351	2.415	2.395	2.478	2.458	2.619	2.599	29
30	1.891	1.875	2.267	2.247	2.313	2.293	2.373	2.353	2.434	2.414	2.478	2.458	2.541	2.521	2.681	2.661	30
31	1.953	1.937	2.330	2.310	2.376	2.356	2.435	2.415	2.496	2.476	2.540	2.520	2.603	2.583	2.744	2.724	31
32	2.016	2.000	2.392	2.372	2.438	2.418	2.498	2.478	2.559	2.539	2.603	2.583	2.666	2.646	2.806	2.786	32
33	2.078	2.062	2.455	2.435	2.501	2.481	2.560	2.540	2.621	2.601	2.665	2.645	2.728	2.708	2.869	2.849	33
34	2.141	2.125	2.517	2.497	2.563	2.543	2.623	2.603	2.684	2.664	2.728	2.708	2.791	2.771	2.931	2.911	34

P A NAVY - AS

Other Cust

USAF - 11
ARMY - AV

TITLE

BOLTS, SELF-RETAINING, POSITIVE LOCKING, CRES
90 KSI Fsu, 83 KSI Ftu, PAN HEAD, 450°F & 650°F

MILITARY STANDARD

MS21125

PROCUREMENT SPECIFICATION
MIL-B-23964

SUPERSEDES.

MS 21125 (ASG)

SHEET 3 OF 6

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 15320

APPROVED 15 Dec 67 REVISED (F) For changes see sheet 6

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FED. SUP CLASS
5306

TABLE III																	
GRIP DASH NO.	NOMINAL SIZE		1900 (10)		2500 (1/4)		3125 (5/16)		3750 (3/8)		4375 (7/16)		5000 (1/2)		5625 (9/16)		GRIP DASH NO.
	THREAD DESIGNATION		32 UNJF-3A		28 UNJF-3A		24 UNJF-3A		24 UNJF-3A		20 UNJF-3A		20 UNJF-3A		18 UNJF-3A		
	G-GRIP LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		
	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	
35	2.204	2.188	2.580	2.560	2.626	2.606	2.685	2.665	2.746	2.726	2.790	2.770	2.853	2.833	2.994	2.974	35
36	2.266	2.250	2.642	2.622	2.688	2.668	2.748	2.728	2.809	2.789	2.853	2.833	2.916	2.896	3.056	3.036	36
37	2.328	2.312	2.705	2.685	2.751	2.731	2.810	2.790	2.871	2.851	2.915	2.895	2.978	2.958	3.119	3.099	37
38	2.390	2.375	2.767	2.747	2.813	2.793	2.873	2.853	2.934	2.914	2.978	2.958	3.041	3.021	3.181	3.161	38
39	2.454	2.438	2.830	2.810	2.876	2.856	2.935	2.915	2.996	2.976	3.040	3.020	3.103	3.083	3.244	3.224	39
40	2.516	2.500	2.892	2.872	2.938	2.918	2.998	2.978	3.059	3.039	3.103	3.083	3.166	3.146	3.306	3.286	40
41	2.578	2.562	2.954	2.934	3.001	2.981	3.060	3.040	3.121	3.101	3.165	3.145	3.228	3.208	3.369	3.349	41
42	2.641	2.625	3.017	2.997	3.063	3.043	3.123	3.103	3.184	3.164	3.228	3.208	3.291	3.271	3.431	3.411	42
43	2.704	2.688	3.080	3.060	3.126	3.106	3.185	3.165	3.246	3.226	3.290	3.270	3.353	3.333	3.494	3.474	43
44	2.766	2.750	3.142	3.122	3.188	3.168	3.248	3.228	3.309	3.289	3.353	3.333	3.416	3.396	3.556	3.536	44
45	2.828	2.812	3.205	3.185	3.251	3.231	3.310	3.290	3.371	3.351	3.415	3.395	3.478	3.458	3.619	3.599	45
46	2.891	2.875	3.267	3.247	3.313	3.293	3.373	3.353	3.434	3.414	3.478	3.458	3.541	3.521	3.681	3.661	46
47	2.954	2.938	3.330	3.310	3.376	3.356	3.435	3.415	3.496	3.476	3.540	3.520	3.603	3.583	3.744	3.724	47
48	3.016	3.000	3.392	3.372	3.438	3.418	3.498	3.478	3.559	3.539	3.603	3.583	3.666	3.646	3.806	3.786	48
49	3.078	3.062	3.455	3.435	3.501	3.481	3.560	3.540	3.621	3.601	3.665	3.645	3.728	3.708	3.869	3.849	49
50	3.141	3.125	3.517	3.497	3.563	3.543	3.623	3.603	3.684	3.664	3.728	3.708	3.791	3.771	3.931	3.911	50
51	3.203	3.188	3.580	3.560	3.626	3.606	3.685	3.665	3.746	3.726	3.790	3.770	3.853	3.833	3.994	3.974	51
52	3.266	3.250	3.642	3.622	3.688	3.668	3.748	3.728	3.809	3.789	3.853	3.833	3.916	3.896	4.056	4.036	52
53	3.328	3.312	3.705	3.685	3.751	3.731	3.810	3.790	3.871	3.851	3.915	3.895	3.978	3.958	4.119	4.099	53
54	3.391	3.375	3.767	3.747	3.813	3.793	3.873	3.853	3.934	3.914	3.978	3.958	4.041	4.021	4.181	4.161	54
55	3.454	3.438	3.830	3.810	3.876	3.856	3.935	3.915	3.996	3.976	4.040	4.020	4.103	4.083	4.244	4.224	55
56	3.516	3.500	3.892	3.872	3.938	3.918	3.998	3.978	4.059	4.039	4.103	4.083	4.166	4.146	4.306	4.286	56
57	3.578	3.562	3.954	3.934	4.001	3.981	4.060	4.040	4.121	4.101	4.165	4.145	4.228	4.208	4.369	4.349	57
58	3.641	3.625	4.017	3.997	4.063	4.043	4.123	4.103	4.184	4.164	4.228	4.208	4.291	4.271	4.431	4.411	58
59	3.704	3.688	4.080	4.060	4.126	4.106	4.185	4.165	4.246	4.226	4.290	4.270	4.353	4.333	4.494	4.474	59
60	3.766	3.750	4.142	4.122	4.188	4.168	4.248	4.228	4.309	4.289	4.353	4.333	4.416	4.396	4.556	4.536	60
61	3.828	3.812	4.205	4.185	4.251	4.231	4.310	4.290	4.371	4.351	4.415	4.395	4.478	4.458	4.619	4.599	61

P.A. NAVY - AS
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ARMY-AV

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NUTS, SELF-RETAINING, POSITIVE LOCKING, CRES
90 KSI Fuu, 63 KSI Fuu, PAN HEAD, 450° F & 650° F

MILITARY STANDARD

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PROCUREMENT SPECIFICATION
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SUPERSEDES:
MS 21125 (ASG)

SHEET 4 OF 6

DD FORM 672-1 (Coordinated)

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PLATE NO 17788

APPROVED 15 Dec 67 REVISED (F) For changes see sheet 6

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GRIP DASH NO		NOMINAL SIZE		1900 (10)		2500 (1/4)		3125 (5/16)		3750 (3/8)		4375 (7/16)		5000 (1/2)		5625 (9/16)		GRIP DASH NO	
THREAD DESIGNATION		G-GRIP LENGTH		32 UNJF-3A		28 UNJF-3A		24 UNJF-3A		24 UNJF-3A		20 UNJF-3A		20 UNJF-3A		18 UNJF-3A			
				L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH		L-LENGTH			
				MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		
62	3.891	3.875		4.267	4.247	4.313	4.293	4.373	4.353	4.434	4.414	4.478	4.458	4.541	4.521	4.681	4.661	62	
63	3.953	3.937		4.330	4.310	4.376	4.356	4.435	4.415	4.496	4.476	4.540	4.520	4.603	4.583	4.744	4.724	63	
64	4.016	4.000		4.392	4.372	4.438	4.418	4.498	4.478	4.559	4.539	4.603	4.583	4.666	4.646	4.806	4.786	64	
65	4.078	4.062		4.455	4.435	4.501	4.481	4.560	4.540	4.621	4.601	4.665	4.645	4.728	4.708	4.869	4.849	65	
66	4.141	4.125		4.517	4.497	4.563	4.543	4.623	4.603	4.684	4.664	4.728	4.708	4.791	4.771	4.931	4.911	66	
67	4.203	4.188		4.580	4.560	4.626	4.606	4.685	4.665	4.746	4.726	4.790	4.770	4.853	4.833	4.994	4.974	67	
68	4.266	4.250		4.642	4.622	4.688	4.668	4.748	4.728	4.809	4.789	4.853	4.833	4.916	4.896	5.056	5.036	68	
69	4.328	4.312		4.705	4.685	4.751	4.731	4.810	4.790	4.871	4.851	4.915	4.895	4.978	4.958	5.119	5.099	69	
70	4.391	4.375		4.767	4.747	4.813	4.793	4.873	4.853	4.934	4.914	4.978	4.958	5.041	5.021	5.181	5.161	70	
71	4.454	4.438		4.830	4.810	4.876	4.856	4.935	4.915	4.996	4.976	5.040	5.020	5.103	5.083	5.244	5.224	71	
72	4.516	4.500		4.892	4.872	4.938	4.918	4.998	4.978	5.059	5.039	5.103	5.083	5.166	5.146	5.306	5.286	72	
73	4.578	4.562		4.954	4.934	5.001	4.981	5.060	5.040	5.121	5.101	5.165	5.145	5.228	5.208	5.369	5.349	73	
74	4.641	4.625		5.017	4.997	5.063	5.043	5.123	5.103	5.184	5.164	5.228	5.208	5.291	5.271	5.431	5.411	74	
75	4.704	4.688		5.080	5.060	5.126	5.106	5.185	5.165	5.246	5.226	5.290	5.270	5.353	5.333	5.494	5.474	75	
76	4.766	4.750		5.142	5.122	5.188	5.168	5.248	5.228	5.309	5.289	5.353	5.333	5.416	5.396	5.556	5.536	76	
77	4.828	4.812		5.205	5.185	5.251	5.231	5.310	5.290	5.371	5.351	5.415	5.395	5.478	5.458	5.619	5.599	77	
78	4.891	4.875		5.267	5.247	5.313	5.293	5.373	5.353	5.434	5.414	5.478	5.458	5.541	5.521	5.681	5.661	78	
79	4.953	4.937		5.330	5.310	5.376	5.356	5.435	5.415	5.496	5.476	5.540	5.520	5.603	5.583	5.744	5.724	79	
80	5.016	5.000		5.392	5.372	5.438	5.418	5.498	5.478	5.559	5.539	5.603	5.583	5.666	5.646	5.806	5.786	80	
81	5.078	5.062		5.455	5.435	5.501	5.481	5.560	5.540	5.621	5.601	5.665	5.645	5.728	5.708	5.869	5.849	81	
82	5.141	5.125		5.517	5.497	5.563	5.543	5.623	5.603	5.684	5.664	5.728	5.708	5.791	5.771	5.931	5.911	82	
83	5.203	5.188		5.580	5.560	5.626	5.606	5.685	5.665	5.746	5.726	5.790	5.770	5.853	5.833	5.994	5.974	83	
84	5.266	5.250		5.642	5.622	5.688	5.668	5.748	5.728	5.809	5.789	5.853	5.833	5.916	5.896	6.056	6.036	84	
85	5.328	5.312		5.705	5.685	5.751	5.731	5.810	5.790	5.871	5.851	5.915	5.895	5.978	5.958	6.119	6.099	85	
86	5.390	5.375		5.767	5.747	5.813	5.793	5.873	5.853	5.934	5.914	5.978	5.958	6.041	6.021	6.181	6.161	86	

P.A. NAVY - AS Other Cust USAF-11 ARMY-AV		TITLE BOLTS, SELF-RETAINING, POSITIVE LOCKING, CRES 90 KSI F _{tu} , 83 KSI F _{tu} , PAN HEAD, 450°F & 650°F		MILITARY STANDARD MS21125	
PROCUREMENT SPECIFICATION MIL-B-23964		SUPERSEDES MS 21125 (ASG)		SHEET 5 OF 6	

