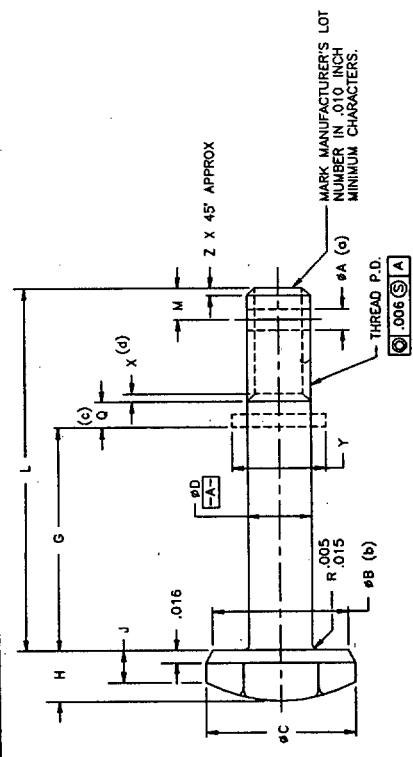


THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION: MIL-B-83050

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

| FIRST DASH NO | NOMINAL DIAMETER | THREAD DESIGNATION (d) | #A (g) | | #B | #C | #D | | H | | M | Q | | J | | W | | Y | | Z | |
|---------------|------------------|------------------------|--------|------|-------|-------|-------|------|------|------|------|------|------|------|-------|-------|-------|-------|------|------|------|
| | | | MAX | MIN | | | MIN | MAX | MIN | MAX | | MIN | MAX | MIN | MAX | MIN | MAX | MIN | MAX | MIN | MAX |
| -3 | .1900 | .1800-32 UNJF-3A | .080 | .070 | .358 | .413 | .1884 | .110 | .095 | .083 | .120 | .074 | .083 | .063 | .376 | .367 | .225 | .196 | .041 | .021 | .021 |
| -4 | .2500 | .2500-28 UNJF-3A | .086 | .076 | .422 | .486 | .2492 | .141 | .126 | .080 | .120 | .105 | .104 | .084 | .439 | .430 | .294 | .256 | .041 | .021 | .021 |
| -5 | .3125 | .3125-24 UNJF-3A | .086 | .076 | .484 | .557 | .3117 | .172 | .157 | .105 | .151 | .120 | .125 | .105 | .502 | .492 | .380 | .320 | .057 | .037 | .037 |
| -6 | .3750 | .3750-24 UNJF-3A | .116 | .106 | .546 | .628 | .3742 | .204 | .188 | .105 | .166 | .120 | .146 | .126 | .564 | .553 | .445 | .382 | .057 | .037 | .037 |
| -7 | .4375 | .4375-20 UNJF-3A | .116 | .106 | .609 | .698 | .4367 | .235 | .220 | .110 | .197 | .120 | .166 | .146 | .627 | .617 | .514 | .450 | .057 | .037 | .037 |
| -8 | .5000 | .5000-20 UNJF-3A | .116 | .106 | .734 | .840 | .4991 | .266 | .251 | .110 | .229 | .120 | .188 | .168 | .692 | .682 | .593 | .530 | .057 | .037 | .037 |
| -9 | .5625 | .5625-18 UNJF-3A | .151 | .141 | .858 | .978 | .5616 | .297 | .282 | .115 | .260 | .120 | .228 | .208 | .744 | .734 | .665 | .602 | .057 | .037 | .037 |
| -10 | .6250 | .6250-18 UNJF-3A | .151 | .141 | .922 | 1.050 | .6241 | .328 | .313 | .115 | .287 | .120 | .288 | .268 | .840 | .828 | .743 | .685 | .057 | .037 | .037 |
| -12 | .7500 | .7500-16 UNJF-3A | .151 | .141 | 1.047 | 1.194 | .7491 | .391 | .376 | .147 | .320 | .120 | .268 | .249 | 1.064 | 1.052 | .900 | .755 | .087 | .067 | .067 |
| -14 | .8750 | .8750-14 UNJF-3A | .151 | .141 | 1.314 | 1.403 | .8741 | .454 | .439 | .147 | .352 | .120 | .310 | .290 | 1.252 | 1.239 | 1.050 | .880 | .087 | .067 | .067 |
| -16 | 1.0000 | 1.0000-12 UNJF-3A | .151 | .141 | 1.422 | 1.615 | .9881 | .516 | .501 | .147 | .383 | .120 | .351 | .331 | 1.440 | 1.427 | 1.200 | 1.010 | .087 | .067 | .067 |



IDENTIFY PARTS IN ACCORDANCE WITH NAS1347 TYPE IV EXCEPT CHARACTERS TO BE .010 INCH MINIMUM.

MARK MANUFACTURER'S LOT NUMBER IN .010 INCH MINIMUM CHARACTERS.

Z X 45° APPROX

THREAD P.D. .0065 A

R .005

R .015

#B (b)

#D

#A (g)

#C

#B

#A (g)

THREAD DESIGNATION (d)

NOMINAL DIAMETER

FIRST DASH NO

INTERNATIONAL INTEREST ASCC AIR STD 17/2

PREPARING ACTMITY: DLA-IS

CUSTODIANS: ARMY- AV NAVY- AS

AIR FORCE- 99 DLA-

REVIEW: IS, 82

USER:

PROJECT NUMBER: 5306-1696

DISTRIBUTION STATEMENT

A. Approved for public release; distribution is unlimited.

Form Approved OMB No. 0704-0188

INCH-POUND

SPECIFICATION SHEET NUMBER MS27576 E 18 OCT 93

SUPERSEDING MS27576 D 25 JAN 1978

AMSC- N/A FSC 5306

Page 1 of 4

TABLE II

| NOMINAL SIZE | SHANK ULTIMATE DOUBLE SHEAR STRENGTH LBS MIN | BOLT ULTIMATE TENSILE STRENGTH LBS MIN |
|--------------|--|--|
| 0.1900 | 5,380 | 2,530 |
| 0.2500 | 9,300 | 4,680 |
| 0.3125 | 14,600 | 7,510 |
| 0.3750 | 21,000 | 11,540 |
| 0.4375 | 28,600 | 15,560 |
| 0.5000 | 37,300 | 21,160 |
| 0.5625 | 47,200 | 26,870 |
| 0.6250 | 58,300 | 34,100 |
| 0.7500 | 83,900 | 39,800 |
| 0.8750 | 114,200 | 55,840 |
| 1.0000 | 149,200 | 74,000 |

MATERIALS: BOLT: ALLOY STEEL: SEE PROCUREMENT SPECIFICATION.
 CRES STEEL: 17-4PH (UNS 17400) IN ACCORDANCE WITH AMS5643 EXCEPT THAT AGING TEMPERATURE SHALL NOT BE LESS THAN 1000°F OR 13-8 MO (UNS 13800) IN ACCORDANCE WITH AMS 5629.

RETAINING ELEMENT: 17-4PH (UNS 17400) IN ACCORDANCE WITH AMS5643, 17-7PH IN ACCORDANCE WITH AMS5644 OR AMS5678, ^(E) OR 440C CRES STEEL (UNS 44004) IN ACCORDANCE WITH QQ-S-763.

SURFACE FINISH: UNTHREADED SHANK AND BEARING SURFACE UNDER HEAD: $\sqrt{63}$ IN ACCORDANCE WITH ANSI/ASME B46.1.
 ALL OTHER SURFACES: $\sqrt{125}$ IN ACCORDANCE WITH ANSI/ASME B46.1.

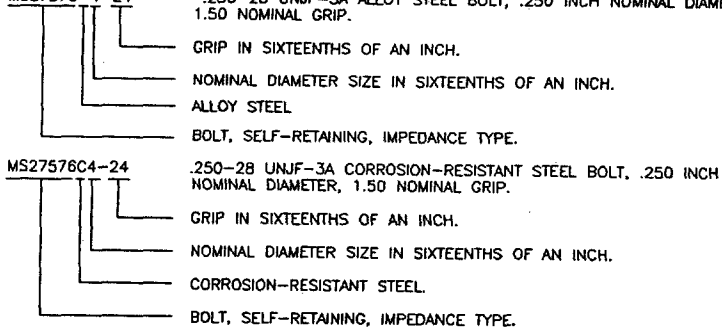
HEAT TREATMENT: IN ACCORDANCE WITH MIL-H-6875 TO ROCKWELL C36 TO C41.

PROTECTIVE TREATMENT: ALLOY STEEL: CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 2.
 CRES STEEL: PASSIVATE IN ACCORDANCE WITH QQ-P-35.

BOLTS SHALL BE FREE FROM ALL BURRS AND SLIVERS, BREAK ALL SHARP EDGES.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR $\pm .010$, ANGULAR $\pm 2'$.

EXAMPLES OF PART NUMBER: MS27576-4-24 .250-28 UNJF-3A ALLOY STEEL BOLT, .250 INCH NOMINAL DIAMETER, 1.50 NOMINAL GRIP.



CERTAIN PROVISIONS (THE ACROSS FLATS DIMENSION) OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ASCC AIR STD 17/2. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED, THE DEPARTMENTAL CUSTODIAN WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICE SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED.

IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.

REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.

INTERNATIONAL INTEREST
ASCC AIR STD
17/2

PREPARING ACTIVITY: DLA-IS
 CUSTODIANS: ARMY- AV NAVY-AS
 AIR FORCE-99 DLA-

REVIEW: IS, 82
 USER:
 PROJECT NUMBER: 5306-1696

MILITARY SPECIFICATION SHEET
 TITLE
 BOLT, SELF-RETAINING, IMPEDANCE TYPE,
 95 KSI FSU, HEX HEAD, 450°F

SPECIFICATION SHEET NUMBER
MS27576 E 18 OCT 93
 SUPERSEDING
 MS27576 D 25 JAN 1978
 AMSC- N/A FSC 5306

DISTRIBUTION STATEMENT

A. Approved for public release; distribution is unlimited.

Page 2 of 4

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THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

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 DODDIS SPECIFIED IN THE SOLICITATION: MIL-B-83050

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

| 2ND DASH NO | FIRST DASH NO | | -3 | -4 | -5 | -6 | -7 | -8 | -9 | -10 | -12 | -14 | -16 |
|-------------|---------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | G-GRIP LENGTH | | | | | | | | | | | | |
| | MAX | MIN | | | | | | | | | | | |
| 03 | .204 | .188 | .570 | .616 | | | | | | | | | |
| 04 | .266 | .250 | .632 | .678 | .738 | .799 | | | | | | | |
| 05 | .328 | .312 | .695 | .741 | .800 | .861 | | | | | | | |
| 06 | .390 | .375 | .757 | .803 | .863 | .924 | .968 | 1.031 | | | | | |
| 07 | .454 | .438 | .820 | .866 | .925 | .986 | 1.030 | 1.093 | 1.234 | 1.296 | | | |
| 08 | .516 | .500 | .882 | .928 | .988 | 1.049 | 1.093 | 1.156 | 1.296 | 1.359 | 1.523 | 1.630 | 1.742 |
| 09 | .578 | .562 | .945 | .991 | 1.050 | 1.111 | 1.155 | 1.218 | 1.359 | 1.421 | 1.585 | 1.692 | 1.804 |
| 10 | .641 | .625 | 1.007 | 1.053 | 1.113 | 1.174 | 1.218 | 1.281 | 1.421 | 1.484 | 1.647 | 1.755 | 1.867 |
| 11 | .704 | .688 | 1.070 | 1.116 | 1.175 | 1.236 | 1.280 | 1.343 | 1.484 | 1.546 | 1.710 | 1.818 | 1.930 |
| 12 | .766 | .750 | 1.132 | 1.178 | 1.238 | 1.299 | 1.343 | 1.406 | 1.546 | 1.609 | 1.772 | 1.880 | 1.992 |
| 13 | .828 | .812 | 1.195 | 1.241 | 1.300 | 1.361 | 1.405 | 1.468 | 1.609 | 1.671 | 1.835 | 1.942 | 2.054 |
| 14 | .891 | .875 | 1.257 | 1.303 | 1.363 | 1.424 | 1.468 | 1.531 | 1.671 | 1.734 | 1.897 | 2.005 | 2.117 |
| 15 | .954 | .938 | 1.320 | 1.366 | 1.425 | 1.486 | 1.530 | 1.593 | 1.734 | 1.796 | 1.960 | 2.068 | 2.180 |
| 16 | 1.016 | 1.000 | 1.382 | 1.428 | 1.488 | 1.549 | 1.593 | 1.656 | 1.796 | 1.859 | 2.023 | 2.130 | 2.242 |
| 17 | 1.078 | 1.062 | 1.445 | 1.491 | 1.550 | 1.611 | 1.655 | 1.718 | 1.859 | 1.921 | 2.085 | 2.192 | 2.304 |
| 18 | 1.141 | 1.125 | 1.507 | 1.553 | 1.613 | 1.674 | 1.718 | 1.781 | 1.921 | 1.984 | 2.147 | 2.255 | 2.367 |
| 19 | 1.204 | 1.188 | 1.570 | 1.616 | 1.675 | 1.736 | 1.780 | 1.843 | 1.984 | 2.046 | 2.209 | 2.318 | 2.430 |
| 20 | 1.266 | 1.250 | 1.632 | 1.678 | 1.738 | 1.799 | 1.843 | 1.906 | 2.046 | 2.109 | 2.272 | 2.380 | 2.492 |
| 21 | 1.328 | 1.312 | 1.695 | 1.741 | 1.800 | 1.861 | 1.905 | 1.968 | 2.109 | 2.171 | 2.335 | 2.442 | 2.554 |
| 22 | 1.391 | 1.375 | 1.757 | 1.803 | 1.863 | 1.924 | 1.968 | 2.031 | 2.171 | 2.234 | 2.397 | 2.505 | 2.617 |
| 23 | 1.454 | 1.438 | 1.820 | 1.866 | 1.925 | 1.986 | 2.030 | 2.093 | 2.234 | 2.296 | 2.460 | 2.568 | 2.680 |
| 24 | 1.516 | 1.500 | 1.882 | 1.928 | 1.988 | 2.049 | 2.093 | 2.156 | 2.296 | 2.359 | 2.522 | 2.630 | 2.742 |
| 25 | 1.578 | 1.562 | 1.945 | 1.991 | 2.050 | 2.111 | 2.155 | 2.218 | 2.359 | 2.421 | 2.585 | 2.692 | 2.804 |
| 26 | 1.641 | 1.625 | 2.007 | 2.053 | 2.113 | 2.174 | 2.218 | 2.281 | 2.421 | 2.484 | 2.647 | 2.755 | 2.867 |
| 27 | 1.704 | 1.688 | 2.070 | 2.116 | 2.175 | 2.236 | 2.280 | 2.343 | 2.484 | 2.546 | 2.710 | 2.818 | 2.930 |
| 28 | 1.766 | 1.750 | 2.132 | 2.178 | 2.238 | 2.299 | 2.343 | 2.406 | 2.546 | 2.609 | 2.772 | 2.880 | 2.992 |
| 29 | 1.828 | 1.812 | 2.195 | 2.241 | 2.300 | 2.361 | 2.405 | 2.468 | 2.609 | 2.671 | 2.835 | 2.942 | 3.054 |
| 30 | 1.891 | 1.875 | 2.257 | 2.303 | 2.363 | 2.424 | 2.468 | 2.531 | 2.671 | 2.734 | 2.897 | 3.005 | 3.117 |
| 31 | 1.954 | 1.938 | 2.320 | 2.366 | 2.425 | 2.486 | 2.530 | 2.593 | 2.734 | 2.796 | 2.960 | 3.068 | 3.180 |
| 32 | 2.016 | 2.000 | 2.382 | 2.428 | 2.488 | 2.549 | 2.593 | 2.656 | 2.796 | 2.859 | 3.023 | 3.130 | 3.242 |
| 33 | 2.078 | 2.062 | 2.445 | 2.491 | 2.550 | 2.611 | 2.655 | 2.718 | 2.859 | 2.921 | 3.085 | 3.192 | 3.304 |
| 34 | 2.141 | 2.125 | 2.507 | 2.553 | 2.613 | 2.674 | 2.718 | 2.781 | 2.921 | 2.984 | 3.147 | 3.255 | 3.367 |
| 35 | 2.204 | 2.188 | 2.570 | 2.616 | 2.675 | 2.736 | 2.780 | 2.843 | 2.984 | 3.046 | 3.209 | 3.318 | 3.430 |
| 36 | 2.266 | 2.250 | 2.632 | 2.678 | 2.738 | 2.799 | 2.843 | 2.906 | 3.046 | 3.109 | 3.272 | 3.380 | 3.492 |
| 37 | 2.328 | 2.312 | 2.695 | 2.741 | 2.800 | 2.861 | 2.905 | 2.968 | 3.109 | 3.171 | 3.335 | 3.442 | 3.554 |
| 38 | 2.391 | 2.375 | 2.757 | 2.803 | 2.863 | 2.924 | 2.968 | 3.031 | 3.171 | 3.234 | 3.397 | 3.505 | 3.617 |
| 39 | 2.454 | 2.438 | 2.820 | 2.866 | 2.925 | 2.986 | 3.030 | 3.093 | 3.234 | 3.296 | 3.460 | 3.568 | 3.680 |
| 40 | 2.516 | 2.500 | 2.882 | 2.928 | 2.988 | 3.049 | 3.093 | 3.156 | 3.296 | 3.359 | 3.522 | 3.630 | 3.742 |
| 41 | 2.578 | 2.562 | 2.945 | 2.991 | 3.050 | 3.111 | 3.155 | 3.218 | 3.359 | 3.421 | 3.585 | 3.692 | 3.804 |
| 42 | 2.641 | 2.625 | 3.007 | 3.053 | 3.113 | 3.174 | 3.218 | 3.281 | 3.421 | 3.484 | 3.647 | 3.755 | 3.867 |
| 43 | 2.704 | 2.688 | 3.070 | 3.116 | 3.175 | 3.236 | 3.280 | 3.343 | 3.484 | 3.546 | 3.710 | 3.818 | 3.930 |
| 44 | 2.766 | 2.750 | 3.132 | 3.178 | 3.238 | 3.299 | 3.343 | 3.406 | 3.546 | 3.609 | 3.772 | 3.880 | 3.992 |
| 45 | 2.828 | 2.812 | 3.195 | 3.241 | 3.300 | 3.361 | 3.405 | 3.468 | 3.609 | 3.671 | 3.835 | 3.942 | 4.054 |
| 46 | 2.891 | 2.875 | 3.257 | 3.303 | 3.363 | 3.424 | 3.468 | 3.531 | 3.671 | 3.734 | 3.897 | 4.005 | 4.117 |
| 47 | 2.954 | 2.938 | 3.320 | 3.366 | 3.425 | 3.486 | 3.530 | 3.593 | 3.734 | 3.796 | 3.960 | 4.068 | 4.180 |
| 48 | 3.016 | 3.000 | 3.382 | 3.428 | 3.488 | 3.549 | 3.593 | 3.656 | 3.796 | 3.859 | 4.023 | 4.130 | 4.242 |
| 49 | 3.078 | 3.062 | 3.445 | 3.491 | 3.550 | 3.611 | 3.655 | 3.718 | 3.859 | 3.921 | 4.085 | 4.192 | 4.304 |
| 50 | 3.141 | 3.125 | 3.507 | 3.553 | 3.613 | 3.674 | 3.718 | 3.781 | 3.921 | 3.984 | 4.147 | 4.255 | 4.367 |
| 51 | 3.204 | 3.188 | 3.570 | 3.616 | 3.675 | 3.736 | 3.780 | 3.843 | 3.984 | 4.046 | 4.209 | 4.318 | 4.430 |
| 52 | 3.266 | 3.250 | 3.632 | 3.678 | 3.738 | 3.799 | 3.843 | 3.906 | 4.046 | 4.109 | 4.272 | 4.380 | 4.492 |
| 53 | 3.328 | 3.312 | 3.695 | 3.741 | 3.800 | 3.861 | 3.905 | 3.968 | 4.109 | 4.171 | 4.335 | 4.442 | 4.554 |
| 54 | 3.391 | 3.375 | 3.757 | 3.803 | 3.863 | 3.924 | 3.968 | 4.031 | 4.171 | 4.234 | 4.397 | 4.505 | 4.617 |
| 55 | 3.454 | 3.438 | 3.820 | 3.866 | 3.925 | 3.986 | 4.030 | 4.093 | 4.234 | 4.296 | 4.460 | 4.568 | 4.680 |
| 56 | 3.516 | 3.500 | 3.882 | 3.928 | 3.988 | 4.049 | 4.093 | 4.156 | 4.296 | 4.359 | 4.522 | 4.630 | 4.742 |
| 57 | 3.578 | 3.562 | 3.945 | 3.991 | 4.050 | 4.111 | 4.155 | 4.218 | 4.359 | 4.421 | 4.585 | 4.692 | 4.804 |
| 58 | 3.641 | 3.625 | 4.007 | 4.053 | 4.113 | 4.174 | 4.218 | 4.281 | 4.421 | 4.484 | 4.647 | 4.755 | 4.867 |
| 59 | 3.704 | 3.688 | 4.070 | 4.116 | 4.175 | 4.236 | 4.280 | 4.343 | 4.484 | 4.546 | 4.710 | 4.818 | 4.930 |
| 60 | 3.766 | 3.750 | 4.132 | 4.178 | 4.238 | 4.299 | 4.343 | 4.406 | 4.546 | 4.609 | 4.772 | 4.880 | 4.992 |
| 61 | 3.828 | 3.812 | 4.195 | 4.241 | 4.300 | 4.361 | 4.405 | 4.468 | 4.609 | 4.671 | 4.835 | 4.942 | 5.054 |
| 62 | 3.891 | 3.875 | 4.257 | 4.303 | 4.363 | 4.424 | 4.468 | 4.531 | 4.671 | 4.734 | 4.897 | 5.005 | 5.117 |

INTERNATIONAL INTEREST
ASCC AIR STD
17/2

PREPARING ACTMITY: DLA-IS
CUSTODIANS: ARMY- AV NAVY- AS
AIR FORCE-99 DLA-
REVIEW: IS, 82
USER:
PROJECT NUMBER: 5306-1696

MILITARY SPECIFICATION SHEET
TITLE
BOLT, SELF-RETAINING, IMPEDANCE TYPE,
95 KSI FSU, HEX HEAD, 450F

SPECIFICATION SHEET NUMBER
MS27576 E 18 OCT 93
SUPERSEDING
MS27576 D 25 JAN 1978
AMSC- N/A FSC 5306

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