

INCH-POUND

MS33537E
AMENDMENT 1
15 November 1994

MILITARY SPECIFICATION SHEET

INSERT, SCREW THREAD, HELICAL COIL, INCH SERIES, COARSE
AND FINE THREAD, STANDARD ASSEMBLY DIMENSIONS FOR

This amendment forms a part of MS33537E, dated 11 Jun 1991, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 1

Paragraph 4.1, second line, after "following" delete "example" and substitute "examples":

After "Example 1", add:

EXAMPLE 2

MINOR DIA .3215-.3288 x .791-.851 DEEP
.36-.39 DIA X 115°-125°CSK
THD PER MS33537 FOR
.3125-24 UNF-3B HELICAL COIL INSERT
.67 MIN FULL THD DEPTH
PITCH DIA .3395-.3421
MAJOR DIA .3666 MIN

MINOR DIA .3215-.3288 THRU
.36-.39 DIA X 115°-125°CSK
THD THRU PER MS33537 FOR
.3125-24 UNF-3B HELICAL COIL INSERT
PITCH DIA .3395-.3421
MAJOR DIA .3666 MIN
INSTALL INSERT .75-1.5 TURNS
BELOW SURFACE
REMOVE TANG - (NOT REQUIRED WITH
TANGLESS INSERTS)

Custodians:
Air Force - 99
Army - AV
Navy - AS

Preparing activity:
Air Force - 82
(Project No. 5340-2134)

Review activities:
DLA-IS