

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.

Review activities
Army
Navy
Air Force - II
DSA

User activities
Army - AT, EL, MI
Navy
Air Force
DSA

P.A. Air Force - 82 Other Cast Navy - AS Army - AV		MILITARY STANDARD		MS9100	
PROPOSED SPECIFICATION NONE		SUPPLEMENT		SHEET 1	
<p>63</p> <p>ENLARGED SECTION X-X</p> <p>0.020 MAX RADIUS</p> <p>THD PD SHALL BE SQUARE TO THESE SURFACES WITHIN .005 FIR. AND CONCENTRIC WITH HEX WITHIN .010 FIR. CONCENTRIC WITH THD PD WITHIN .005 FIR.</p> <p>R-2 HOLES LOCATED WITHIN .010 R OF TRUE POSITION AT MAXIMUM MATERIAL CONDITION</p> <p>15° CHAMFER TO BOTH SIDES</p> <p>MARK PART NO. AND MFR IDENT PER AS 478 CLASS C (SEE NOTE 1)</p> <p>CSK 110° TO N-BOTH SIDES THD T MIL-S-8879 (B)</p> <p>THREADS IN ACCORDANCE WITH MIL-S-7742 ARE ACCEPTABLE UNTIL DECEMBER 31, 1975.</p>		<p>APPROVED 15 Oct 58 REVISED (A) 1 MAY 69 (B) 23 Oct 74</p> <p>AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.</p>		<p>APPROVED 15 Oct 58 REVISED (A) 1 MAY 69 (B) 23 Oct 74</p>	

- MULTIPLE MARKING OF BAR STOCK IS PERMISSIBLE PROVIDED POSITIVE IDENTIFICATION IS SHOWN. PARTS SHALL BE MARKED BEFORE THREADING. DASH NUMBERS MAY APPEAR ON ADJACENT FLATS.
- MATERIAL: CORROSION RESISTANT STEEL AMS5639.
- CLEANING: FINISHED PARTS SHALL BE DEGREASED AND IMMERSED FOR NOT LESS THAN 20 MINUTES IN A SOLUTION OF NITRIC ACID. (SP GR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.
- SURFACE TEXTURE: ANSI B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT HEX FACES.
- BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±30°.
- DO NOT USE UNASSIGNED PART NUMBERS.

FED. SUP. CLASS.
5310