



TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100
-05	.438	$\frac{1}{2}$	.95
-06	.500	$\frac{1}{2}$	.99
-07	.562	$\frac{1}{2}$	1.03
-08	.625	$\frac{1}{2}$	1.07
-09	.688	$\frac{1}{2}$	1.11
-10	.750	.125	1.15
-11	.812	.188	1.19
-12	.875	.250	1.23
-13	.938	.312	1.27
-14	1.000	.375	1.31
-15	1.062	.438	1.35
-16	1.125	.500	1.39
-17	1.188	.562	1.43
-18	1.250	.625	1.47
-19	1.312	.688	1.51
-20	1.375	.750	1.55
-21	1.438	.812	1.59
-22	1.500	.875	1.63

DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100
-23	1.562	.938	1.67
-24	1.625	1.000	1.71
-25	1.688	1.062	1.75
-26	1.750	1.125	1.79
-27	1.875	1.250	1.87
-28	2.000	1.375	1.95
-29	2.125	1.500	2.03
-30	2.250	1.625	2.11
-31	2.375	1.750	2.19
-32	2.500	1.875	2.27
-33	2.625	2.000	2.35
-34	2.750	2.125	2.43
-35	2.875	2.250	2.51
-36	3.000	2.375	2.59

ⓑ ENTIRE STANDARD REVISED

PA <b>NAVY-AS</b> Other Cust <b>AIR FORCE-II</b>	INTERNATIONAL INTEREST	TITLE  <b>BOLT, MACHINE, 12 POINT HEAD,          STEEL, .190-32 UNF-3A</b>	<b>MILITARY STANDARD</b>
			<b>MS9146</b>
PROCUREMENT SPECIFICATION <b>AMS 7452</b>	SUPERSEDES	PAGE 1 OF 2	

FED. SUP CLASS  
5306

## REQUIREMENTS:

1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6322-80.
2. FINISH: CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80. DIMENSIONS SPECIFIED ARE AFTER PLATING.
3. HARDNESS: 26-32HRC.
4. THREADS: THREADS IN ACCORDANCE WITH MIL-8-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
6. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS870.
7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI B46.1.
8. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83.
9. TOLERANCE: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
10. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9146-05

DASH NUMBER

BASIC MS NUMBER

MS9146-05 INDICATES: BOLT, MACHINE, 12 POINT HEAD, STEEL;  
.190-32 UNF-3A; LENGTH .438.

## NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. DO NOT USE UNASSIGNED PART NUMBERS.
3. 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.
4. 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.
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
6. AS AND AMS ARE SAE PUBLICATIONS.

P. A. NAVY-AS Other Cost AIR FORCE-11	INTERNATIONAL INTEREST	TITLE  BOLT, MACHINE, 12 POINT HEAD, STEEL, .190-32 UNF-3A	MILITARY STANDARD  MS9146
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2 OF 2	

USER ACTIVITIES

REVIEWER ACTIVITIES  
DLA - IS

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 when applicable.

APPROVED 5 AUG 57 REVISED (A) 28 FEB 84 (B) FOR CHANGES SEE PAGES 1 AND 2