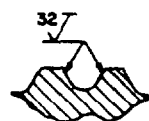
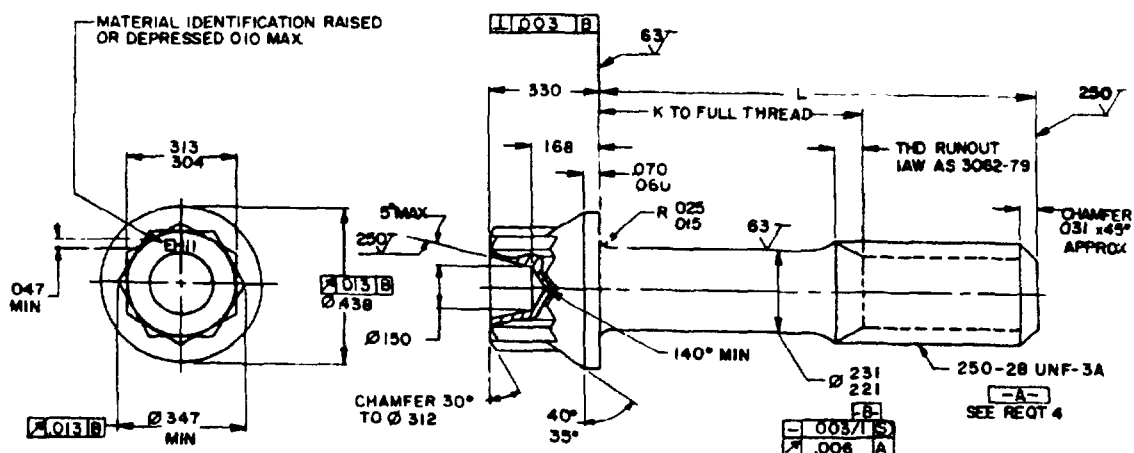
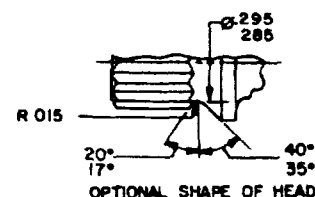


USER ACTIVITIES  
ARMY-ME

REVIEWER ACTIVITIES  
DLA-15

SECTION THRU THREAD PROFILE



INACTIVE FOR DESIGN AFTER 28 FEB 84  
FOR PARTS WITH MIL-S-8879 SCREW THREADS SEE MS 9915

**TABLE I. DASH NUMBERS AND DIMENSIONS**

DASH NUMBER	L	K + 000 - 060	APPROX WEIGHT LBS/100	DASH NUMBER	L	K + 000 - 060	APPROX WEIGHT LBS/100	DASH NUMBER	L	K + 000 - 060	APPROX WEIGHT LBS/100
-06	.500	1/	1.29	-23	1.562	812	2.50	-41	3.625	2.875	4.85
-07	.562	1/	1.36	-24	1.625	.875	2.57	-42	3.750	3.000	4.99
-08	.625	1/	1.44	-25	1.688	.938	2.64	-43	3.875	3.125	5.13
-09	.688	1/	1.51	-26	1.750	1.000	2.72	-44	4.000	3.250	5.27
-10	.750	1/	1.58	-27	1.875	1.125	2.86	-45	4.125	3.375	5.42
-11	.812	1/	1.65	-28	2.000	1.250	3.00	-46	4.250	3.500	5.56
-12	.875	.125	1.72	-29	2.125	1.375	3.14	-47	4.375	3.625	5.71
-13	.938	.188	1.79	-30	2.250	1.500	3.29	-48	4.500	3.750	5.85
-14	1.000	.250	1.86	-31	2.375	1.625	3.43	-49	4.625	3.875	6.00
-15	1.062	.312	1.93	-32	2.500	1.750	3.57	-50	4.750	4.000	6.14
-16	1.125	.375	2.00	-33	2.625	1.875	3.71	-51	4.875	4.125	6.29
-17	1.188	.438	2.08	-34	2.750	2.000	3.85	-52	5.000	4.250	6.43
-18	1.250	.500	2.15	-35	2.875	2.125	4.00	-53	5.125	4.375	6.56
-19	1.312	.562	2.22	-36	3.000	2.250	4.14	-54	5.250	4.500	6.70
-20	1.375	.625	2.29	-37	3.125	2.375	4.29	-55	5.375	4.625	6.84
-21	1.438	.688	2.36	-38	3.250	2.500	4.43	-56	5.500	4.750	6.99
-22	1.500	.750	2.43	-39	3.375	2.625	4.58	-57	5.625	4.875	7.13
				-40	3.500	2.750	4.72	-58	5.750	5.000	7.28
								-59	5.875	5.125	7.42
								-60	6.000	5.250	7.57

1/ THREAD TO HEAD    MAXIMUM TWO INCOMPLETE THREADS

ⓑ ENTIRE STANDARD REVISED

PA <b>NAVY-AS</b> Other Call <b>AIR FORCE-11</b>	INTERNATIONAL INTEREST	TITLE <b>BOLT, MACHINE, 12 POINT HEAD,          STEEL, .250-28 UNF-3A</b>	<b>MILITARY STANDARD</b> <b>MS9147</b>
PROCUREMENT SPECIFICATION <b>AMS 7452</b>	SUPERSEDES		PAGE 1 OF 2

**DISTRIBUTION STATEMENT A** Approved for public release; distribution is unlimited

AMSC N/A

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

**5306-1145**

APPROVED 5 AUG 57 REVISED (A) 28 FEB 84 (B) 4 NOV 86

USER ACTIVITIES  
ARMY-ME

REVIEWER ACTIVITIES  
DLA-IS

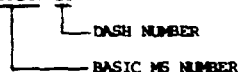
This standard is approved for use by all Departments and Agencies of the Department of Defense. Instructions for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

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-S-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. MS9147-06



MS9147-06 INDICATES. BOLT, MACHINE, 12 POINT HEAD, STEEL;  
.250-29 UNF-3A; LENGTH .500.

## 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.

APPROVED 5 AUG 57 REVISED 15 FOR CHANGES SEE PAGES 1 AND 2

NAVY-AS Other Code AIR FORCE-II	INTERNATIONAL INTEREST	TITLE  BOLT, MACHINE, 12 POINT HEAD, STEEL, .250-28 UNF-3A	MILITARY STANDARD  MS9147
PROCUREMENT SPECIFICATION AMS 7452		SUPERSEDED	PAGE 2 OF 2