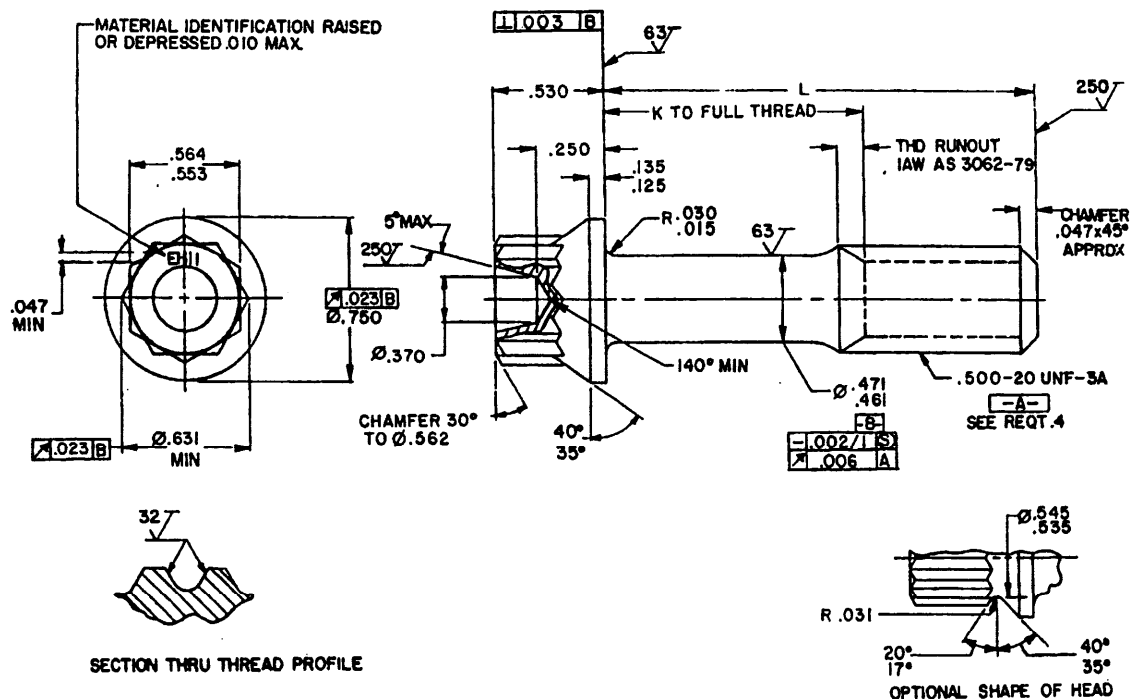


USER ACTIVITIES:

REVIEWER ACTIVITIES:

DLA-IS



INACTIVE FOR DESIGN AFTER 28 FEB 1984
FOR PARTS WITH MIL-S-8879 SCREW THREADS SEE MS9919

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100
-06	.938	1/	8.41
-07	1.000	1/	8.70
-08	1.062	1/	8.99
-09	1.125	1/	9.28
-10	1.188	1/	9.57
-11	1.250	1/	9.86
-12	1.312	1/	10.15
-13	1.375	.125	10.45
-14	1.438	.188	10.74
-15	1.500	.250	11.04
-16	1.562	.312	11.33
-17	1.625	.375	11.63
-18	1.688	.438	11.92
-19	1.750	.500	12.22
-20	1.875	.625	12.81
-21	2.000	.750	13.41
-22	2.125	.875	14.00

DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100
-23	2.250	1.000	14.61
-24	2.375	1.125	15.21
-25	2.500	1.250	15.82
-26	2.625	1.375	16.42
-27	2.750	1.500	17.01
-28	2.875	1.625	17.61
-29	3.000	1.750	18.22
-30	3.125	1.875	18.83
-31	3.250	2.000	19.43
-32	3.375	2.125	20.04
-33	3.500	2.250	20.65
-34	3.625	2.375	21.26
-35	3.750	2.500	21.86
-36	3.875	2.625	22.47
-37	4.000	2.750	23.07
-38	4.125	2.875	23.68
-39	4.250	3.000	24.29

DASH NUMBER	L	K + .000 - .060	APPROX WEIGHT LBS/100
-40	4.375	3.125	24.89
-41	4.500	3.250	25.50
-42	4.625	3.375	26.11
-43	4.750	3.500	26.71
-44	4.875	3.625	27.32
-45	5.000	3.750	27.92
-46	5.125	3.875	28.53
-47	5.250	4.000	29.13
-48	5.375	4.125	29.74
-49	5.500	4.250	30.35
-50	5.625	4.375	30.95
-51	5.750	4.500	31.56
-52	5.875	4.625	32.16
-53	6.000	4.750	32.77

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

ⓑ ENTIRE STANDARD REVISED

P.A. NAVY-AS	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, 12 POINT HEAD, STEEL, .500-20 UNF-3A	MILITARY STANDARD
Other Cust AIR FORCE-11			MS9151
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE 1 OF 2

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AMSC N/A

DD FORM 672-1 (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1149

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

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: MS9151-06

DASH NUMBER

BASIC MS NUMBER

MS9151-06 INDICATES: BOLT, MACHINE, 12 POINT HEAD, STEEL;
.500-20 UNF-3A; LENGTH .938.

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	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, 12 POINT HEAD, STEEL, .500-20 UNF-3A	MILITARY STANDARD MS9151
AIR FORCE-II			
PROCUREMENT SPECIFICATION AMS7452	SUPERSEDES:	PAGE 2 OF 2	

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1149

USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA-1S

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APPROVED 5 AUG 57 REVISED (B) FOR CHANGES SEE PAGES 1 AND 2