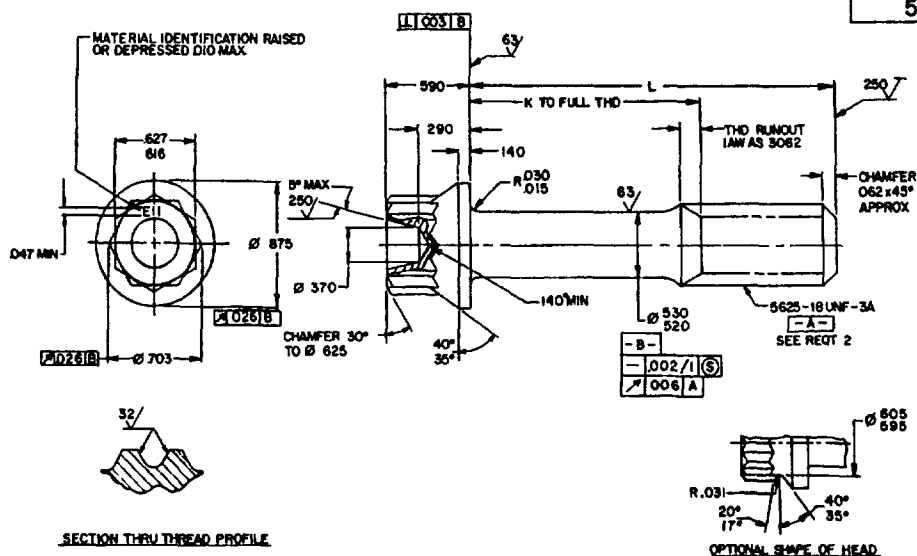


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### TABLE I DASH NUMBERS AND DIMENSIONS

DASH NO.	L	K + .000 - .060	APPROX WEIGHT LBS/100	DASH NO.	L	K + .000 - .060	APPROX WEIGHT LBS/100	DASH NO.	L	K + .000 - .060	APPROX WEIGHT LBS/100
-06	1.000	1/	11.91	-23	2.375	1.000	19.63	-40	4.500	3.125	31.62
-07	1.062	1/	12.26	-24	2.500	1.125	20.34	-41	4.625	3.250	32.32
-08	1.125	1/	12.61	-25	2.625	1.250	21.04	-42	4.750	3.375	33.03
-09	1.188	1/	12.96	-26	2.750	1.375	21.75	-43	4.875	3.500	33.73
-10	1.250	1/	13.31	-27	2.875	1.500	22.45	-44	5.000	3.625	34.44
-11	1.312	1/	13.66	-28	3.000	1.625	23.16	-45	5.125	3.750	35.14
-12	1.375	1/	14.01	-29	3.125	1.750	23.86	-46	5.250	3.875	35.85
-13	1.438	1/	14.36	-30	3.250	1.875	24.57	-47	5.375	4.000	36.55
-14	1.500	.125	14.71	-31	3.375	2.000	25.27	-48	5.500	4.125	37.26
-15	1.562	.188	15.06	-32	3.500	2.125	25.98	-49	5.625	4.250	37.96
-16	1.625	.250	15.41	-33	3.625	2.250	26.68	-50	5.750	4.375	38.67
-17	1.688	.312	15.76	-34	3.750	2.375	27.39	-51	5.875	4.500	39.37
-18	1.750	.375	16.11	-35	3.875	2.500	28.09	-52	6.000	4.625	40.08
-19	1.875	.500	16.81	-36	4.000	2.625	28.80				
-20	2.000	.625	17.51	-37	4.125	2.750	29.50				
-21	2.125	.750	18.21	-38	4.250	2.875	30.21				
-22	2.250	.875	18.93	-39	4.375	3.000	30.91				

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

**REQUIREMENTS:**

- NO SUPERSEDING STANDARD
1. MATERIAL: STEEL AMS 6322
  2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
  3. HARDNESS: 26-32 HRC
  4. FINISH: CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80 DIMENSIONS SPECIFIED ARE AFTER PLATING.
  5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M
  6. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870
  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 PER AMS 2640.

INACTIVE FOR NEW DESIGN AFTER 26 OCT 72  
NO SUPERSEDING STANDARD

ⓑ ENTIRE STANDARD REVISED

P.A <b>NAVY-AS</b> Other Cust	INTERNATIONAL INTEREST	TITLE <b>BOLT - MACHINE, STEEL,          12 POINT HEAD,          .5625-18, CADMIUM PLATE</b>	<b>MILITARY STANDARD</b>	
			<b>MS 9152 (AS)</b>	
PROCUREMENT SPECIFICATION <b>AMS 7452</b>	SUPERSEDES	PAGE 1 OF 2		

DD FORM 672-1 (COORDINATED)  
1 MAY 53

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-N152

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	REVIEWER ACTIVITIES	USER ACTIVITIES
DLA-IS		

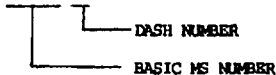
APPROVED 5 AUG 57 REVISED 22 JUN 87

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9. TOLERANCES: 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 1.

EXAMPLE: MS9152-06



MS9152-06 INDICATES: BOLT-MACHINE, STEEL, 12 POINT HEAD, .5625-18, CADMIUM PLATE, 1.000 LONG

## 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

USER ACTIVITIES

REVIEWER ACTIVITIES  
DLA-15

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

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, 12 POINT HEAD, .5625-18, CADMIUM PLATE	MILITARY STANDARD MS9152(AS)
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES	PAGE 2 OF 2	