

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
-05	.438	1/	.95	-23	1.562	.938	1.67
-06	.500	1/	.99	-24	1.625	1.000	1.71
-07	.562	1/	1.03	-25	1.688	1.062	1.75
-08	.625	1/	1.07	-26	1.750	1.125	1.79
-09	.688	1/	1.11	-27	1.875	1.250	1.87
-10	.750	.125	1.15	-28	2.000	1.375	1.95
-11	.812	.188	1.19	-29	2.125	1.500	2.03
-12	.875	.250	1.23	-30	2.250	1.625	2.11
-13	.938	.312	1.27	-31	2.375	1.750	2.19
-14	1.000	.375	1.31	-32	2.500	1.875	2.27
-15	1.062	.438	1.35	-33	2.625	2.000	2.35
-16	1.125	.500	1.39	-34	2.750	2.125	2.43
-17	1.188	.562	1.43	-35	2.875	2.250	2.51
-18	1.250	.625	1.47	-36	3.000	2.375	2.59
-19	1.312	.688	1.51				
-20	1.375	.750	1.55				
-21	1.438	.812	1.59				
-22	1.500	.875	1.63				

REQUIREMENTS:

INACTIVE FOR NEW DESIGN AFTER 26 OCT 72
NO SUPERSEDING STANDARD

- NO SUPERSEEDING 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: BLACK OXIDE TREATMENT IN ACCORDANCE WITH AMS 2485.
 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 IN ACCORDANCE WITH AMS 2640.

ⓑ ENTIRE STANDARD REVISED

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, 12 POINT HEAD, .190(NO.10)-32, BLACK OXIDE	MILITARY STANDARD
			MS9157(AS)
PROCUREMENT SPECIFICATION AMS7452	SUPERSEDES:		PAGE 1 OF 2

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USER ACTIVITIES:

REVIEWER ACTIVITIES:

DLA-15

AMSC N/A

DD FORM 672-1 (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-N153

APPROVED
5 AUG 57
REVISED
B 22 JUN 87

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FED. SUP CLASS
5306

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 I.

EXAMPLE: MS9157-05

DASH NUMBER

BASIC MS NUMBER

MS9157-05 INDICATES: BOLT-MACHINE, STEEL, 12 POINT HEAD, .190-32,
BLACK OXIDE, .438 LONG

NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. DO NOT USE UNASSIGNED PART NUMBER
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 THE 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-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 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, .190(NO.10)-32, BLACK OXIDE	MILITARY STANDARD MS9157(AS)
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2	OF 2