

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	.812	1/	5.51	-24	2.125	1.000	10.38	-45	4.750	3.625	20.12
-07	.875	1/	5.74	-25	2.250	1.125	10.85	-46	4.875	3.750	20.59
-08	.938	1/	5.97	-26	2.375	1.250	11.32	-47	5.000	3.875	21.05
-09	1.000	1/	6.20	-27	2.500	1.375	11.79	-48	5.125	4.000	21.51
-10	1.062	1/	6.43	-28	2.625	1.500	12.26	-49	5.250	4.125	21.97
-11	1.125	1/	6.67	-29	2.750	1.625	12.72	-50	5.375	4.250	22.33
-12	1.188	1/	6.90	-30	2.875	1.750	13.19	-51	5.500	4.375	22.30
-13	1.250	.125	7.13	-31	3.000	1.875	13.66	-52	5.625	4.500	23.27
-14	1.312	.188	7.36	-32	3.125	2.000	14.12	-53	5.750	4.625	23.74
-15	1.375	.250	7.59	-33	3.250	2.125	14.59	-54	5.875	4.750	24.21
-16	1.438	.312	7.82	-34	3.375	2.250	15.06	-55	6.000	4.875	24.67
-17	1.500	.375	8.05	-35	3.500	2.375	15.52				
-18	1.562	.438	8.27	-36	3.625	2.500	15.99				
-19	1.625	.500	8.50	-37	3.750	2.625	16.45				
-20	1.688	.562	8.73	-38	3.875	2.750	16.92				
-21	1.750	.625	8.96	-39	4.000	2.875	17.39				
-22	1.875	.750	9.43	-40	4.125	3.000	17.85				
-23	2.000	.875	9.90	-41	4.250	3.125	18.31				
				-42	4.375	3.250	18.75				
				-43	4.500	3.375	19.31				
				-44	4.625	3.500	19.66				

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

REQUIREMENTS:

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

INACTIVE FOR NEW DESIGN AFTER 26 OCT 72
NO SUPERSEDING STANDARD

ENTIRE STANDARD REVISED

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, 12 POINT HEAD, .4375-20, BLACK OXIDE	MILITARY STANDARD
PROCUREMENT SPECIFICATION AMS7452			SUPERSEDES: PAGE 1 OF 2
MS9161(AS)			

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REVIEWER ACTIVITIES:
DLA-IS

AMSC N/A

DD FORM 672-1 (COORDINATED)
1 MAY 73

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5306-N157

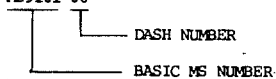
APPROVED 5 AUG 57 REVISED 8 22 JUN 87

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FED. SUP CLASS
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8. **MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640
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: MS9161-06



MS9161-06 INDICATES: BOLT-MACHINE, STEEL, 12 POINT HEAD, .4375-20,
BLACK OXIDE, .812 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 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 ⑧ FOR CHANGES SEE PAGES 1 AND 2

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PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2	OF 2

DD FORM 1 MAY 73 672-1 (COORDINATED)

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