

USER ACTIVITIES:

REVIEWER ACTIVITIES:  
DLA-1S

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AMSC N/A

FED SUP CLASS 5306			
TABLE I DASH NUMBER AND DIMENSIONS			
DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100
-06	.500	✓	1.29
-07	.562	✓	1.36
-08	.625	✓	1.44
-09	.688	✓	1.51
-10	.750	✓	1.58
-11	.812	✓	1.65
-12	.875	.125	1.72
-13	.938	.188	1.79
-14	1.000	.250	1.86
-15	1.062	.312	1.93
-16	1.125	.375	2.00
-17	1.188	.438	2.08
-18	1.250	.500	2.15
-19	1.312	.562	2.22
-20	1.375	.625	2.29
-21	1.438	.688	2.36
-22	1.500	.750	2.43
-23	1.562	.812	2.50
-24	1.625	.875	2.57
-25	1.688	.938	2.64
-26	1.750	1.000	2.72
-27	1.875	1.125	2.86
-28	2.000	1.250	3.00
-29	2.125	1.375	3.14
-30	2.250	1.500	3.29
-31	2.375	1.625	3.43
-32	2.500	1.750	3.57
-33	2.625	1.875	3.71
-34	2.750	2.000	3.85
-35	2.875	2.125	4.00
-36	3.000	2.250	4.14
-37	3.125	2.375	4.29
-38	3.250	2.500	4.43
-39	3.375	2.625	4.58
-40	3.500	2.750	4.72
-41	3.625	2.875	4.85
-42	3.750	3.000	4.99
-43	3.875	3.125	5.13
-44	4.000	3.250	5.27
-45	4.125	3.375	5.42
-46	4.250	3.500	5.56
-47	4.375	3.625	5.71
-48	4.500	3.750	5.85
-49	4.625	3.875	6.00
-50	4.750	4.000	6.14
-51	4.875	4.125	6.29
-52	5.000	4.250	6.43
-53	5.125	4.375	6.56
-54	5.250	4.500	6.70
-55	5.375	4.625	6.84
-56	5.500	4.750	6.99
-57	5.625	4.875	7.13
-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 IMPERFECT THREADS.

REQUIREMENTS:

- MATERIAL:** STEEL AMS 6322.
- THREADS:** THREADS IN ACCORDANCE WITH MIL-G-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
- HARDNESS:** 26-32 HRC
- FINISH:** BLACK OXIDE TREATMENT IN ACCORDANCE WITH AMS 2485.
- DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
- WRENCHING CONFIGURATION:** WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
- SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICRONS EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI B46.1.
- MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640.

**(A) ENTIRE STANDARD REVISED**

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .250-28, BLACK OXIDE	MILITARY STANDARD MS9170
AIR FORCE-11			
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES.	PAGE 1	OF 2

DD FORM 672-1 (COORDINATED)

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APPROVED 5 AUG 57  
REVISED (A) 6 MAY 87

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 .001-.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: MS9170-06

DASH NUMBER

BASIC MS NUMBER

MS9170-06 INDICATES: BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD,  
.250-28, BLACK OXIDE, .500 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.

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

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