

FED SUP CLASS
5306

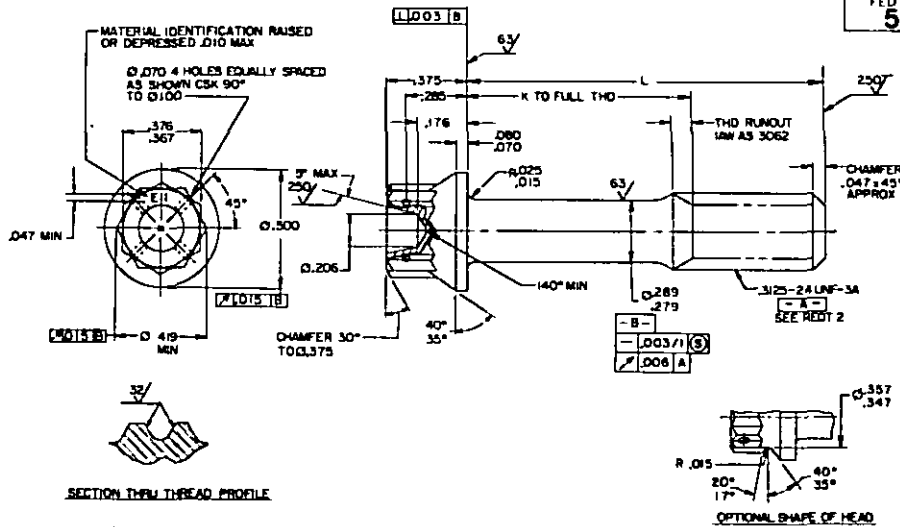


TABLE I DASH NUMBER AND DIMENSIONS

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100	DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100	DASH NO.	L	+.000 -.060	APPROX WEIGHT LBS/100
-05	.562	1/	2.21	-22	1.625	.750	4.10	-40	3.750	2.875	7.95
-06	.625	1/	2.28	-23	1.688	.812	4.22	-41	3.875	3.000	8.17
-07	.688	1/	2.39	-24	1.750	.875	4.33	-42	4.000	3.125	8.40
-08	.750	1/	2.51	-25	1.875	1.000	4.55	-43	4.125	3.250	8.63
-09	.812	1/	2.62	-26	2.000	1.125	4.77	-44	4.250	3.375	8.86
-10	.875	1/	2.73	-27	2.125	1.250	5.00	-45	4.375	3.500	9.08
-11	.938	1/	2.85	-28	2.250	1.375	5.23	-46	4.500	3.625	9.30
-12	1.000	.125	2.96	-29	2.375	1.500	5.45	-47	4.625	3.750	9.52
-13	1.062	.188	3.07	-30	2.500	1.625	5.67	-48	4.750	3.875	9.74
-14	1.125	.250	3.19	-31	2.625	1.750	5.90	-49	4.875	4.000	9.95
-15	1.188	.312	3.30	-32	2.750	1.875	6.13	-50	5.000	4.125	10.17
-16	1.250	.375	3.41	-33	2.875	2.000	6.36	-51	5.125	4.250	10.40
-17	1.312	.438	3.52	-34	3.000	2.125	6.58	-52	5.250	4.375	10.63
-18	1.375	.500	3.64	-35	3.125	2.250	6.80	-53	5.375	4.500	10.86
-19	1.438	.562	3.75	-36	3.250	2.375	7.03	-54	5.500	4.625	11.10
-20	1.500	.625	3.87	-37	3.375	2.500	7.27	-55	5.625	4.750	11.33
-21	1.562	.688	3.98	-38	3.500	2.625	7.50	-56	5.750	4.875	11.56
				-39	3.625	2.750	7.73	-57	5.875	5.000	11.78
								-58	6.000	5.125	12.00

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

REQUIREMENTS:

- MATERIAL:** STEEL AMS 6322.
- THREADS:** THREADS IN ACCORDANCE WITH MIL-S-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 MICROINCHES 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 Curt	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .3125-24, BLACK OXIDE	MILITARY STANDARD
AIR FORCE-11			MS9171
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE 1 OF 2

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AMSC N/A

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1165

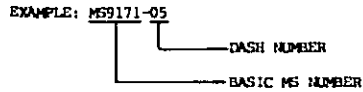
USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA-15

APPROVED 5 AUG 57 REVISED (A) 6 MAY 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.



MS9171-05 INDICATES: BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .3125-24, BLACK OXIDE, .562 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-1S

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PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES	PAGE 2	OF 2