

USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA-1S

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AMSC N/A

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SECTION THRU THREAD PROFILE

OPTIONAL SHAPE OF HEAD

TABLE 1 DASH NUMBER AND DIMENSIONS

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100
-06	.750	1/	3.74
-07	.812	1/	3.90
-08	.875	1/	4.07
-09	.938	1/	4.24
-10	1.000	1/	4.41
-11	1.062	1/	4.58
-12	1.125	.125	4.75
-13	1.188	.188	4.91
-14	1.250	.250	5.08
-15	1.312	.312	5.25
-16	1.375	.375	5.43
-17	1.438	.438	5.60
-18	1.500	.500	5.76
-19	1.562	.562	5.93
-20	1.625	.625	6.10
-21	1.688	.688	6.27
-22	1.750	.750	6.44
-23	1.875	.875	6.77
-24	2.000	1.000	7.11
-25	2.125	1.125	7.44
-26	2.250	1.250	7.78
-27	2.375	1.375	8.11
-28	2.500	1.500	8.44
-29	2.625	1.625	8.78
-30	2.750	1.750	9.12
-31	2.875	1.875	9.46
-32	3.000	2.000	9.80
-33	3.125	2.125	10.13
-34	3.250	2.250	10.47
-35	3.375	2.375	10.80
-36	3.500	2.500	11.14
-37	3.625	2.625	11.47
-38	3.750	2.750	11.80
-39	3.875	2.875	12.14
-40	4.000	3.000	12.47
-41	4.125	3.125	12.80
-42	4.250	3.250	13.13
-43	4.375	3.375	13.46
-44	4.500	3.500	13.89
-45	4.625	3.625	14.23
-46	4.750	3.750	14.56
-47	4.875	3.875	14.89
-48	5.000	4.000	15.23
-49	5.125	4.125	15.57
-50	5.250	4.250	15.90
-51	5.375	4.375	16.23
-52	5.500	4.500	16.56
-53	5.625	4.625	16.89
-54	5.750	4.750	17.23
-55	5.875	4.875	17.57
-56	6.000	5.000	17.91

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 PILET.
- 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 Cust	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .375-24, BLACK OXIDE	MILITARY STANDARD MS9172
AIR FORCE-II			
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES	PAGE 1	OF 2

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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: MS9172-06

└── DASH NUMBER

└── BASIC MS NUMBER

MS9172-06 INDICATES: BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD,
.375-24, BLACK OXIDE, .750 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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PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES	PAGE 2	OF 2

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PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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