

USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA-15

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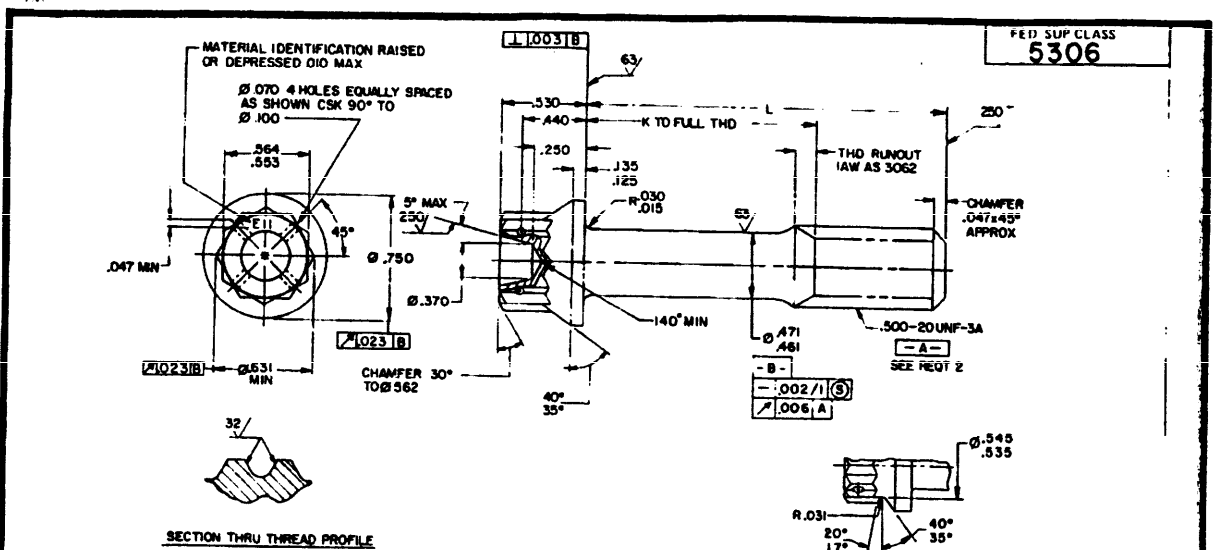


TABLE I DASH NUMBER AND DIMENSIONS

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100
-06	.938	✓	8.41
-07	1.000	✓	8.70
-08	1.062	✓	8.99
-09	1.125	✓	9.28
-10	1.188	✓	9.57
-11	1.250	✓	9.86
-12	1.312	✓	10.15
-13	1.375	.125	10.45
-14	1.438	.188	10.74
-15	1.500	.250	11.04
-16	1.562	.312	11.33
-17	1.625	.375	11.63
-18	1.688	.438	11.92
-19	1.750	.500	12.22
-20	1.875	.625	12.81

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100
-21	2.000	.750	13.41
-22	2.125	.875	14.00
-23	2.250	1.000	14.61
-24	2.375	1.125	15.21
-25	2.500	1.250	15.82
-26	2.625	1.375	16.42
-27	2.750	1.500	17.01
-28	2.875	1.625	17.61
-29	3.000	1.750	18.22
-30	3.125	1.875	18.83
-31	3.250	2.000	19.43
-32	3.375	2.125	20.04
-33	3.500	2.250	20.65
-34	3.625	2.375	21.26
-35	3.750	2.500	21.86
-36	3.875	2.625	22.47
-37	4.000	2.750	23.07
-38	4.125	2.875	23.68

OPTIONAL SHAPE OF HEAD

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LBS/100
-39	4.250	3.000	24.29
-40	4.375	3.125	24.89
-41	4.500	3.250	25.50
-42	4.625	3.375	26.11
-43	4.750	3.500	26.71
-44	4.875	3.625	27.32
-45	5.000	3.750	27.92
-46	5.125	3.875	28.53
-47	5.250	4.000	29.13
-48	5.375	4.125	29.74
-49	5.500	4.250	30.35
-50	5.625	4.375	30.95
-51	5.750	4.500	31.56
-52	5.875	4.625	32.16
-53	6.000	4.750	32.77

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 Cust	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .500-20, BLACK OXIDE	MILITARY STANDARD
AIR FORCE-11			MS9174
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 1 OF 2	

AMSC N/A

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1168

APPROVED 5 AUG 57
REVISED (A) 6 MAY 87

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			FED. SUP. CLASS 5306	
<p>9. <u>TOLERANCES</u> : UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.</p> <p>10. <u>EDGES</u> : BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.</p> <p>11. <u>PART NUMBER</u> : THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.</p> <p>EXAMPLE: MS9174-06</p> <div style="margin-left: 100px;"> <p>└── DASH NUMBER</p> <p>└── BASIC MS NUMBER</p> </div> <p>MS9174-06 INDICATES: BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .500-20, BLACK OXIDE, .938 LONG.</p> <p>NOTES:</p> <ol style="list-style-type: none"> 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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