

USER ACTIVITIES:

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OLA-19

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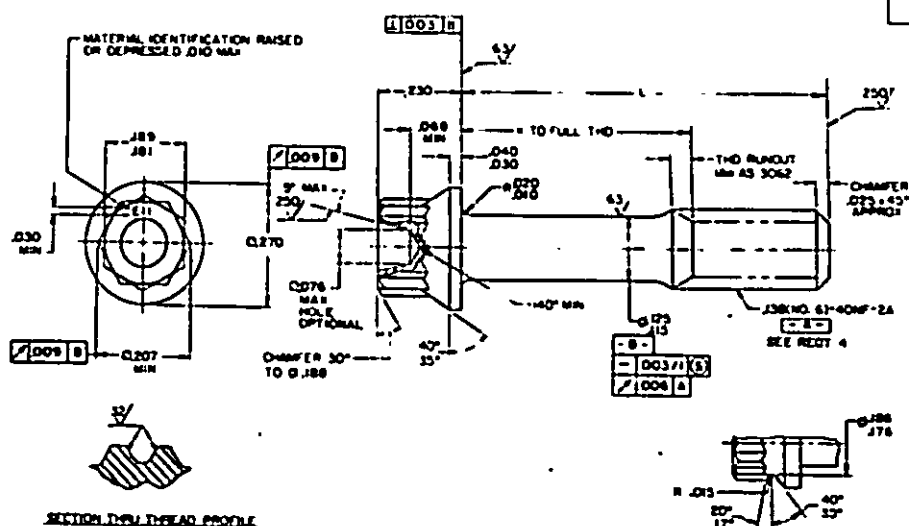


TABLE I DASH NUMBERS AND DIMENSIONS

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LB/100
-02	.250	✓	.297
-03	.312	✓	.318
-04	.375	✓	.340
-05	.438	✓	.363
-06	.500	✓	.386
-07	.562	✓	.406
-08	.625	✓	.429
-09	.688	.125	.451
-10	.750	.188	.473
-11	.812	.250	.495
-12	.875	.312	.517
-13	.938	.375	.539
-14	1.000	.438	.561
-15	1.062	.500	.583
-16	1.125	.562	.605

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

REPUTED REPORTS:

1. MATERIAL: STEEL AND 6322 (UNS C87400).
2. HARDNESS: 26-32 HRC
3. FINISH: CADMIUM PLATE PER AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
4. THREADS: THREADS IN ACCORDANCE WITH MIL-G-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
6. WEIGHING CONFIGURATION: WEIGHING CONFIGURATION IN ACCORDANCE WITH AS 870.
7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED SHALL BE 125 MICRONS EXCEPT UPSET HEAD.
8. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION PER AMS 2640.
9. TOLERANCE: 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.

© ENTIRE STANDARD REVISED

P.A. NAVY-AS Other Cost	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, STEEL, 12 POINT HEAD, .138(NO. 6)-40, CADMIUM PLATE	MILITARY STANDARD		
			MS9185		
AIR FORCE - 82			PROCUREMENT SPECIFICATION AMS 7452	SUPPLIES DES:	PAGE - OF 1 2

INACTIVE FOR NEW DESIGN AFTER 17 MAR 72

APPROVED 31 MAR 58 REVISED © 13 JUL 87

FED SUP CLASS
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11. **PART NUMBER:** THE PART SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS9185-02

DASH NUMBER

BASIC MS NUMBER

MS9185-02 INDICATES: SCREW, MACHINE, STEEL, 12 POINT HEAD, .138-40,
CADMIUM PLATE, .250 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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DLA-1S

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 31 MAR 58 REVISED © FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, STEEL, 12 POINT HEAD, .138(NO. 6)-40, CADMIUM PLATE	MILITARY STANDARD MS9185
AIR FORCE-82	PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2 OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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