

## USER ACTIVITIES:

**REVIEWER ACTIVITIES:**  
**DLA-15**

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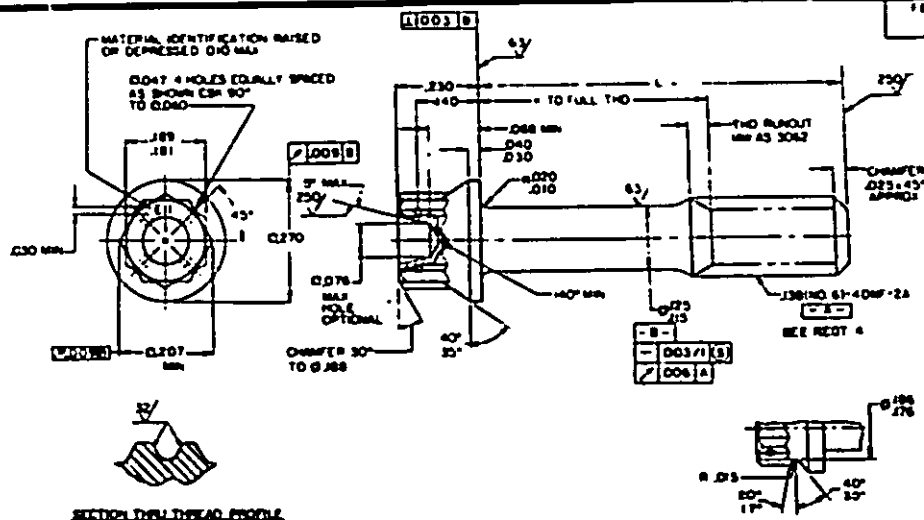


TABLE 1. DASH NUMBERING AND DIMENSIONS

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LB/100
-02	.250	✓	.297
-03	.312	✓	.318
-04	.375	✓	.340
-05	.438	✓	.361
-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.

**REQUIREMENTS:**

1. MATERIAL: STEEL AIG 6322 (UNS G87400).
2. HARDNESS: 26-32 HRC
3. FINISH: BLACK OXIDE TREATMENT IN ACCORDANCE WITH AMS 2485
4. THREADS: THREADS IN ACCORDANCE WITH MIL-8-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH AMS Y14.5M.
6. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED SHALL BE 125 MICRONS EXCEPT UPSET HEAD.
8. MAGNETIC PARTICLE DEFLECTION: MAGNETIC PARTICLE DEFLECTION 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.

**INACTIVE FOR NEW DESIGN AFTER 13 DEC 72**

© ENTIRE STANDARD REVISED

P.A. <b>NAVY-AS</b>		INTERNATIONAL INTEREST	TITLE	<b>MILITARY STANDARD</b>	
Other Code			<b>BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .138(NQ.6)-40, BLACK OXIDE</b>	<b>MS9191</b>	
<b>AIR FORCE -B2</b>				PAGE 1 OF 2	
PROCUREMENT SPECIFICATION <b>AMS 7452</b>		SUPPLEMENTARY NOTES			

**5306-1176**

AMSC N/A

DD FORM 672-1 COORDINATED

THIS IS THE FIRST OF TWO PAGES OF THE DOCUMENT

APPROVED 31 MAR 88 REVISED © 13 JUL 87

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11. **PART NUMBER:** THE PART SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9191-02

— DASH NUMBER  
— BASIC MS NUMBER

MS9191-02 INDICATES: BOLT-MACHINE, STEEL, DRILLED, 12 POINT HEAD, .138-40, BLACK OXIDE, .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.

USER ACTIVITIES:

REVIEWER ACTIVITIES:  
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 56 REVISED (C) FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY-AS Other Cost	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, STEEL, DRILLED 12 POINT HEAD, .138(NQ. 6)-40, BLACK OXIDE	MILITARY STANDARD MS9191
AIR FORCE-82	PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2 OF 2

DD FORM 1 MAY 72 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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