

32981

FED SUP CLASS
5306

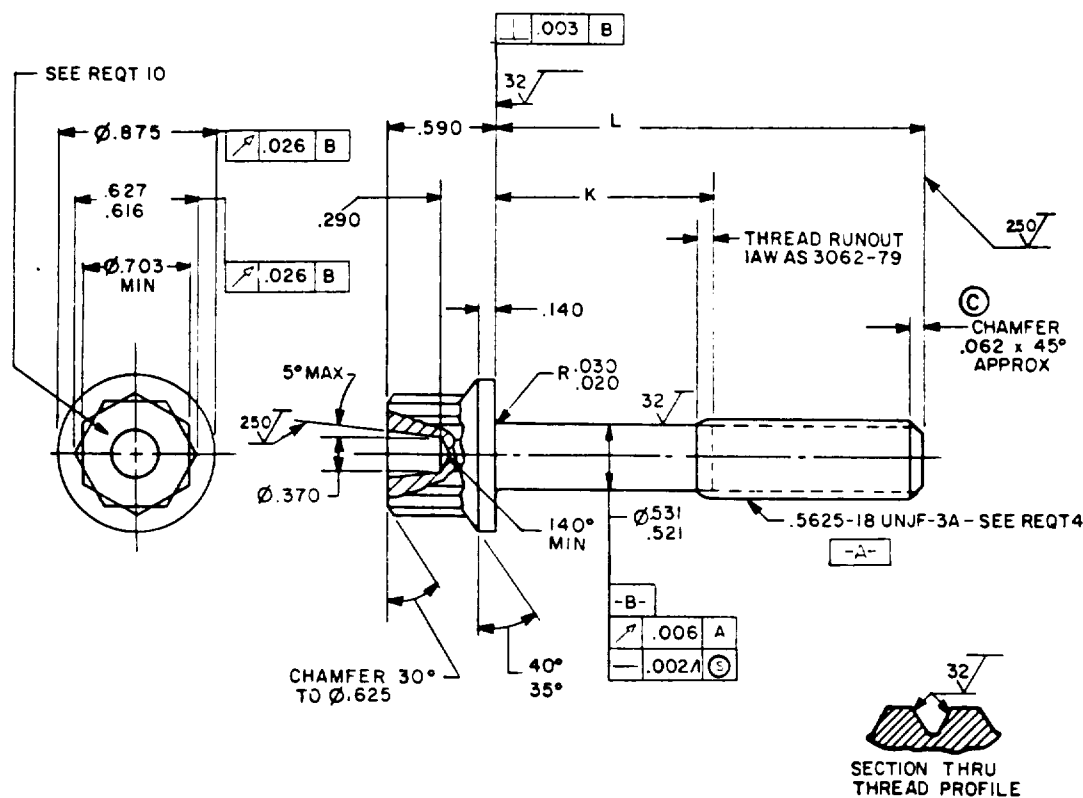


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB./100
-04	.875	.114-.134	11.21
-05	.938	.114-.134	11.56
-06	1.000	.114-.134	11.91
-07	1.062	.114-.134	12.26
-08	1.125	.114-.134	12.61
-09	1.188	.114-.134	12.96
-10	1.250	.114-.134	13.31
-11	1.312	.114-.134	13.66
-12	1.375	.114-.134	14.01
-13	1.438	.114-.134	14.36
-14	1.500	.114-.134	14.71
-15	1.562	.128-.188	15.06
-16	1.625	.190-.250	15.41
-17	1.688	.252-.312	15.76
-18	1.750	.315-.375	16.11
-19	1.812	.378-.438	16.46
-20	1.875	.440-.500	16.81
-21	2.000	.565-.625	17.51

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-22	2.125	.690- .750	18.21
-23	2.250	.815- .875	18.93
-24	2.375	.940-1.000	19.63
-25	2.500	1.065-1.125	20.34
-26	2.625	1.190-1.250	21.04
-27	2.750	1.315-1.375	21.75
-28	2.875	1.440-1.500	22.45
-29	3.000	1.565-1.625	23.16
-30	3.125	1.690-1.750	23.86
-31	3.250	1.815-1.875	24.57
-32	3.375	1.940-2.000	25.27
-33	3.500	2.065-2.125	25.98
-34	3.625	2.190-2.250	26.68
-35	3.750	2.315-2.375	27.39
-36	3.875	2.440-2.500	28.09
-37	4.000	2.565-2.625	28.80
-38	4.125	2.690-2.750	29.50
-39	4.250	2.815-2.875	30.21

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-40	4.375	2.940-3.000	30.91
-41	4.500	3.065-3.125	31.62
-42	4.625	3.190-3.250	32.32
-43	4.750	3.315-3.375	33.03
-44	4.875	3.440-3.500	33.73
-45	5.000	3.565-3.625	34.44
-46	5.125	3.690-3.750	35.14
-47	5.250	3.815-3.875	35.85
-48	5.375	3.940-4.000	36.55
-49	5.500	4.065-4.125	37.26
-50	5.625	4.190-4.250	37.96
-51	5.750	4.315-4.375	38.67
-52	5.875	4.440-4.500	39.37
-53	6.000	4.565-4.625	40.08

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

© DENOTES CHANGES

P.A. NAVY-AS Other Cust AIR FORCE-II	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, DOUBLE HEXAGON EXTENDED WASHER HEAD, STEEL, .5625-18 UNJF-3A	MILITARY STANDARD
			MS9214
PROCUREMENT SPECIFICATION AMS 7459	SUPERSEDES		PAGE 1 OF 2

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REVIEWER ACTIVITIES:
DLA-15

APPROVED 10 DEC 63
REVISED (A) 28 FEB 84 (B) 4 NOV 86 (C) 19 JUN 87

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REQUIREMENTS:

1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6304.
2. FINISH: DIFFUSED NICKEL-CADMIUM PLATE IN ACCORDANCE WITH AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
3. HARDNESS: 42-46HRC.
4. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
6. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS870.
7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI B46.1.
8. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83.
9. TOLERANCE: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
10. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS478-79, CLASS A.
11. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
12. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS9214-04

DASH NUMBER

BASIC MS NUMBER

MS9214-04 INDICATES: BOLT, MACHINE, DOUBLE HEXAGON EXTENDED WASHER HEAD,
STEEL; .5625-18 UNJF-3A; LENGTH .875.

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.

APPROVED 10 DEC 63 REVISED © FOR CHANGES SEE PAGES 1 AND 2

P. A. NAVY-AS Other Cost AIR FORCE-II	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, DOUBLE HEXAGON EXTENDED WASHER HEAD, STEEL, .5625-18 UNJF-3A	MILITARY STANDARD MS9214
PROCUREMENT SPECIFICATION AMS 7459	SUPERSEDES:	PAGE 2 OF 2	

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