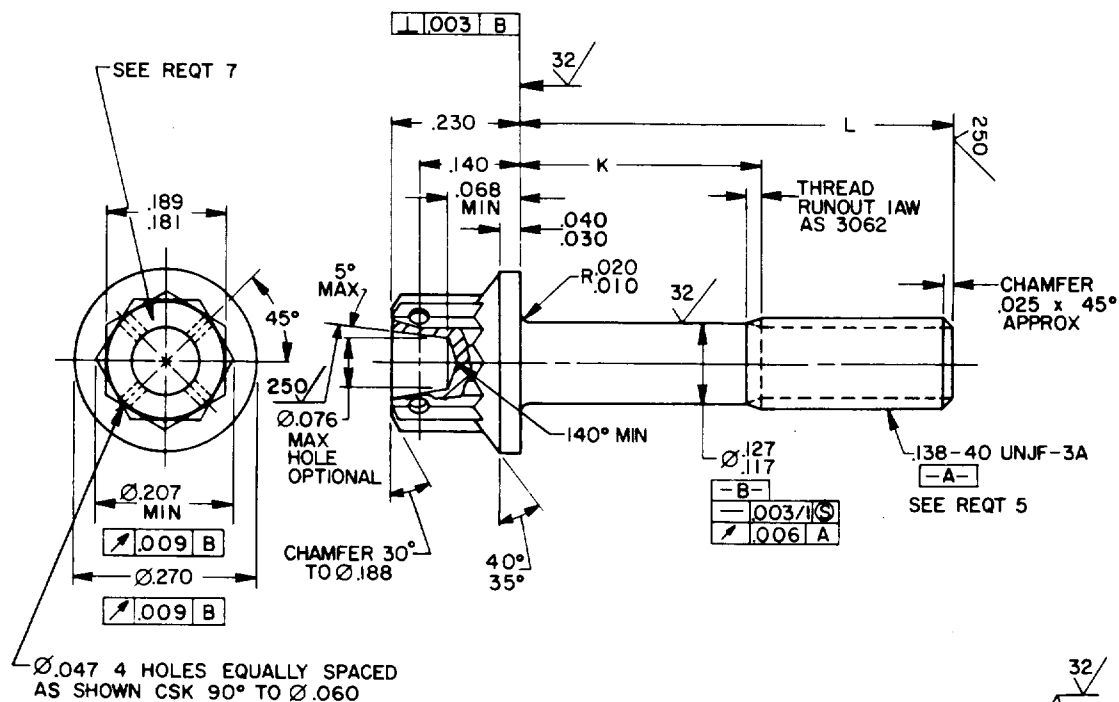


USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA - IS

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SECTION THRU
THREAD PROFILE

TABLE I DASH NUMBERS AND DIMENSIONS

DASH NO.	L	K	APPROX WEIGHT LB/100	DASH NO.	L	K	APPROX WEIGHT LB/100
-02	.250	.058-.078	.297	-13	.938	.352-.412	.539
-03	.312	.058-.078	.318	-14	1.000	.414-.474	.561
-04	.375	.058-.078	.340	-15	1.062	.476-.536	.583
-05	.438	.058-.078	.363	-16	1.125	.539-.599	.605
-06	.500	.058-.078	.386	-17	1.188	.602-.662	.627
-07	.562	.058-.078	.406	-18	1.250	.664-.724	.649
-08	.625	.058-.078	.429	-19	1.312	.726-.786	.671
-09	.688	.102-.162	.451	-20	1.375	.789-.849	.693
-10	.750	.164-.224	.473	-21	1.438	.852-.912	.715
-11	.812	.226-.286	.495	-22	1.500	.914-.974	.737
-12	.875	.289-.349	.517				

① ENTIRE STANDARD REVISED

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE-STEEL DIFFUSED NICKEL-CADMIUM PLATE, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, .138 40 UNJF 3A	MILITARY STANDARD	
			MS9215	
PROCUREMENT SPECIFICATION AMS 7459	SUPERSEDES		PAGE 1 OF 2	

REQUIREMENTS:

1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6304 (UNS K14675).
2. HARDNESS: ROCKWELL C42-46.
3. FINISH: DIFFUSED NICKEL-CADMIUM PLATE PER AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAX BEFORE PLATING.
4. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION PER AMS 2640 BEFORE PLATING.
5. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
6. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
7. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478 CLASS A.
8. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
9. SURFACE TEXTURE: SURFACE TEXTURE IN ACCORDANCE WITH ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACE TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
10. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSION $\pm 5^\circ$.
11. PART NUMBER: THE PART NUMBER SHALL CONSIST TO THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FOR TABLE 1.

EXAMPLE: MS9215-02

DASH NUMBER

BASIC MS NUMBER

MS9215-02 INDICATES: BOLT, MACHINE-STEEL AMS 6304, DIFFUSED NICKEL, CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED .138-40 UNJF-3A X .250 LONG.

NOTES:

1. ALL DIMENSIONS 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 NONGOVERNMENT) 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.

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE-STEEL DIFFUSED NICKEL-CADMIUM PLATE, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, .138-40 UNJF-3A	MILITARY STANDARD MS9215
PROCUREMENT SPECIFICATION AMS 7459	SUPERSEDES	PAGE 2 OF 2	

USER ACTIVITIES:

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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 10 DEC 63
REVISED (A) FOR CHANGES SEE PAGES 1 AND 2