

FED SUP CLASS
5306

USER ACTIVITIES:

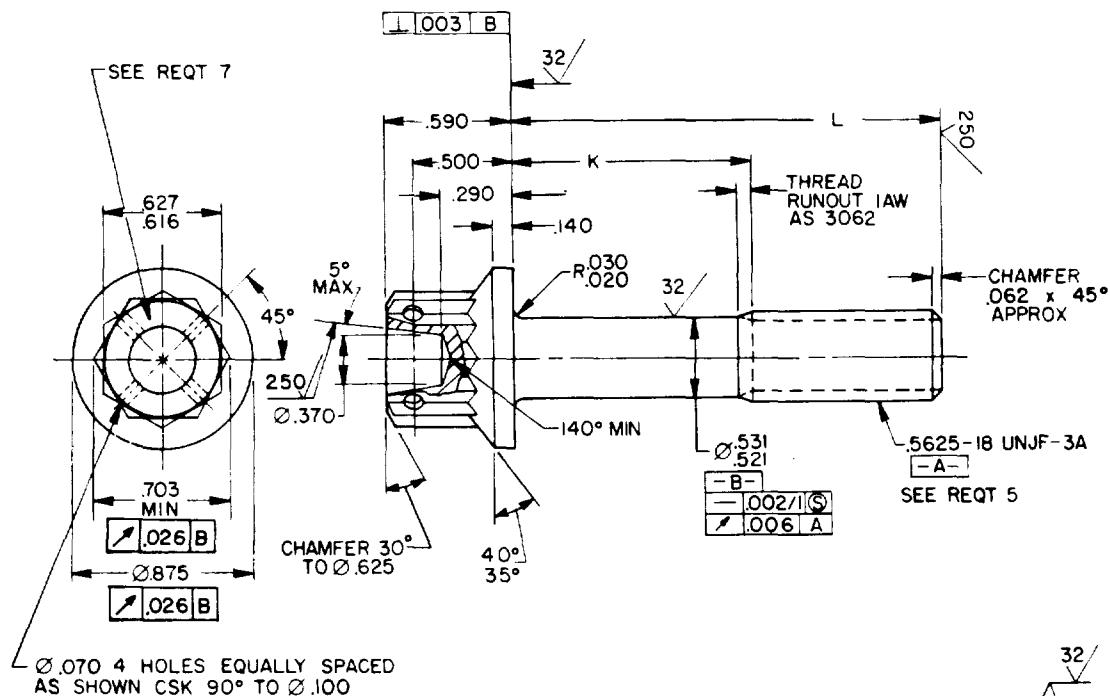
REVIEWER ACTIVITIES:
DLA - IS

TABLE 1 DASH NUMBERS AND DIMENSIONS

DASH NO.	L	K	APPROX WEIGHT LB/100	DASH NO.	L	K	APPROX WEIGHT LB/100	DASH NO.	L	K	APPROX WEIGHT LB/100
-04	.875	.114-.134	11.21	-22	2.125	.690-.750	18.21	-40	4.375	2.940-3.000	30.91
-05	.938	.114-.134	11.56	-23	2.250	.815-.875	18.92	-41	4.500	3.065-3.125	31.62
-06	1.000	.114-.134	11.91	-24	2.375	.940-1.000	19.63	-42	4.625	3.190-3.250	32.32
-07	1.062	.114-.134	12.26	-25	2.500	1.065-1.125	20.34	-43	4.750	3.315-3.375	33.03
-08	1.125	.114-.134	12.61	-26	2.625	1.190-1.250	21.04	-44	4.875	3.440-3.500	33.73
-09	1.188	.114-.134	12.96	-27	2.750	1.315-1.375	21.75	-45	5.000	3.565-3.625	34.44
-10	1.250	.114-.134	13.31	-28	2.875	1.440-1.500	22.45	-46	5.125	3.690-3.750	35.14
-11	1.312	.114-.134	13.66	-29	3.000	1.565-1.625	23.16	-47	5.250	3.815-3.875	35.85
-12	1.375	.114-.134	14.01	-30	3.125	1.690-1.750	23.86	-48	5.375	3.940-4.000	36.55
-13	1.438	.114-.134	14.36	-31	3.250	1.815-1.875	24.57	-49	5.500	4.065-4.125	37.26
-14	1.500	.114-.134	14.71	-32	3.375	1.940-2.000	25.27	-50	5.625	4.190-4.250	37.96
-15	1.562	.128-.188	15.06	-33	3.500	2.065-2.125	25.98	-51	5.750	4.315-4.375	38.67
-16	1.625	.190-.250	15.41	-34	3.625	2.190-2.250	26.68	-52	5.875	4.440-4.500	39.37
-17	1.688	.252-.312	15.76	-35	3.750	2.315-2.375	27.39	-53	6.000	4.565-4.625	40.08
-18	1.750	.315-.375	16.11	-36	3.875	2.440-2.500	28.00				
-19	1.812	.378-.438	16.46	-37	4.000	2.565-2.625	28.80				
-20	1.875	.440-.500	16.81	-38	4.125	2.690-2.750	29.50				
-21	2.000	.565-.625	17.51	-39	4.250	2.815-2.875	30.21				

(A) ENTIRE STANDARD REVISED

P.A. NAVY - AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-STEEL DIFFUSED NICKEL-CADMIUM PLATE, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, 5625-18 UNJF-3A	MILITARY STANDARD MS9223
PROCUREMENT SPECIFICATION AMS 7459	SUPERSEDES	PAGE 1	OF 2

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AMSC N/A

DD FORM 672-1 (LIMITED COORDINATION)

5306-NI72

APPROVED 10 DEC 63
REVISED (A) 9 MAY 88

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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 I.

EXAMPLE: MS9223-04

└── DASH NUMBER
└── BASIC MS NUMBER

MS9223-04 INDICATES: BOLT, MACHINE-STEEL AMS 6304, DIFFUSED NICKEL, CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, .5625-18 UNJF-3A X .875 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.

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