

INCH-POUND

MS9281B
27 OCTOBER 1995
SUPERSEDING
MS9281A
26 OCTOBER 1972

MILITARY SPECIFICATION SHEET

SCREW, MACHINE-STEEL AMS 6322,
BLACK OXIDE, HEXAGON HEAD,
.138-40 UNJF-3A

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS
AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST
OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING DOCUMENT
LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS
AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION (SEE REQT 13)

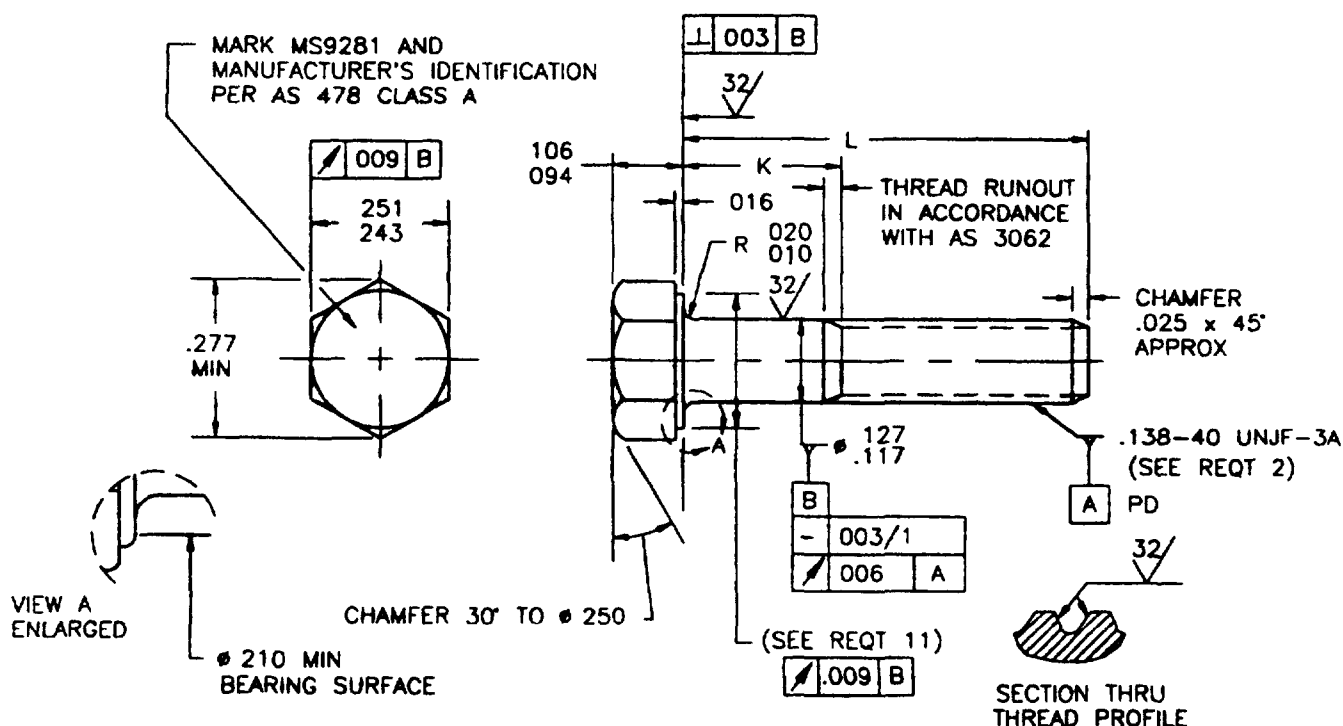


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-02	.250	.058-.078	.25
-03	.312	.058-.078	.27
-04	.375	.058-.078	.30
-05	.438	.058-.078	.32
-06	.500	.058-.078	.34
-07	.562	.058-.078	.37
-08	.625	.058-.099	.39
-09	.688	.102-.162	.42
-10	.750	.164-.224	.44
-11	.812	.226-.286	.46
-12	.875	.289-.349	.49
-13	.938	.352-.412	.51
-14	1.000	.414-.474	.53
-15	1.062	.476-.536	.56

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-16	1.125	.539-.599	.56
-17	1.188	.602-.662	.61
-18	1.250	.664-.724	.63
-19	1.312	.726-.786	.65
-20	1.375	.789-.849	.68
-21	1.438	.852-.912	.70
-22	1.500	.914-.974	.72

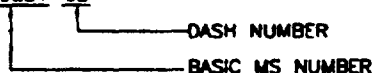
(B) ENTIRE DOCUMENT REVISED

MS9281B

REQUIREMENTS

- 1 MATERIAL STEEL IN ACCORDANCE WITH AMS 6322
- 2 THREADS THREADS IN ACCORDANCE WITH MIL-S-8879
- 3 DIMENSIONING AND TOLERANCING DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ASME Y14.5M
- 4 HEAD TO SHANK FILLET HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS
- 5 MAGNETIC PARTICLE INSPECTION MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640
- 6 HARDNESS ROCKWELL C26-32.
- 7 FINISH FINISH SHALL BE BLACK OXIDE TREATMENT IN ACCORDANCE WITH AMS 2485
8. SURFACE TEXTURE SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI/ASME B46.1
- 9 TOLERANCE UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS ± 0.010 , ANGULAR DIMENSIONS $\pm 5^\circ$
- 10 EDGES BREAK SHARP EDGES 003-015 UNLESS OTHERWISE SPECIFIED
- 11 BEARING SURFACE BEARING SURFACE SHALL BE FLAT AND WASHER FACED. DIAMETER OF BEARING SURFACE SHALL BE EQUAL TO THE MAXIMUM WIDTH ACROSS FLATS WITHIN A TOLERANCE OF MINUS 10% IN ACCORDANCE WITH ANSI B18.2.1.
- 12 PART NUMBER THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE MS9281-02



MS9281-02 INDICATES SCREW, MACHINE-STEEL AMS 6322, BLACK OXIDE, HEXAGON HEAD,
.138-40 UNJF-3A, LENGTH .250

- 13 PROCUREMENT SPECIFICATION AMS 7452 EXCEPT HEAD MUST BE UPSET

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 DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE
- 4 UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION
- 6 AS AND AMS ARE SAE PUBLICATIONS
- 7 INACTIVE FOR NEW DESIGN AFTER 28 OCTOBER 1972 NO SUPERSEDING DOCUMENT

MILITARY INTERESTS

CUSTODIANS

NAVY - AS
AIR FORCE - 11

PREPARING ACTIVITY

DLA-IS

(PROJECT: 5305-2115)