

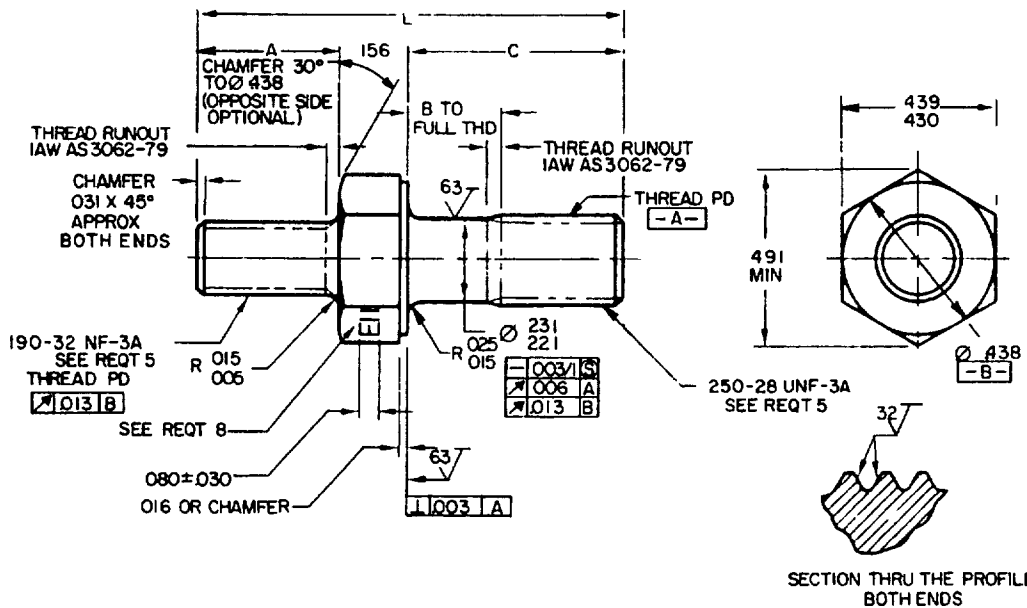
FED SUP CLASS
5307

TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	A	B + 000 - 060	C	L REF	APPROX WEIGHT LBS/100	DASH NUMBER	A	B + 000 - 060	C	L REF	APPROX WEIGHT LBS/100
-001	375	1/	500	1 031	1 52	-050	438	1/	500	1 094	1 58
-002	375	1/	562	1 094	1 58	-051	438	1/	562	1 156	1 66
-003	375	1/	625	1 156	1 66	-052	438	1/	625	1 219	1 75
-004	375	1/	688	1 219	1 75	-053	438	1/	688	1 281	1 81
-005	375	1/	750	1 281	1 81	-054	438	1/	750	1 344	1 86
-006	375	1/	812	1 344	1 86	-055	438	1/	812	1 406	1 95
-007	375	.125	875	1 406	1 95	-056	438	.125	875	1 469	2 00
-008	375	.188	938	1 469	2 00	-057	438	.188	938	1 531	2 09
-009	375	.250	1 000	1 531	2 09	-058	438	.250	1 000	1 594	2 15
-010	375	.312	1 062	1 594	2 15	-059	438	.312	1 062	1 656	2 23
-011	375	.375	1 125	1 656	2 23	-060	438	.375	1 125	1 719	2 32
-012	375	.438	1 188	1 719	2 32	-061	438	.438	1 188	1 781	2 37
-013	375	.500	1 250	1 781	2 37	-062	438	.500	1 250	1 844	2 43
-014	375	.562	1 312	1 844	2 43	-063	438	.562	1 312	1 906	2 51
-015	375	.625	1 375	1 906	2 51	-064	438	.625	1 375	1 969	2 60
-016	375	.688	1 438	1 969	2 60	-065	438	.688	1 438	2 031	2 66
-017	375	.750	1 500	2 031	2 66	-066	438	.750	1 500	2 094	2 71
-018	375	.812	1 562	2 094	2 71	-067	438	.812	1 562	2 156	2 80
-019	375	.875	1 625	2 156	2 80	-068	438	.875	1 625	2 219	2 89
-020	375	.938	1 688	2 219	2 89	-069	438	.938	1 688	2 281	2 94
-021	375	1 000	1 750	2 281	2 94	-070	438	1 000	1 750	2 344	2 99
-022	375	1 062	1 812	2 344	2 99	-071	438	1 062	1 812	2 406	3 08
-023	375	1 125	1 875	2 406	3 08	-072	438	1 125	1 875	2 469	3 16
-024	375	1 188	1 938	2 469	3 16	-073	438	1 188	1 938	2 531	3 22
-025	375	1 250	2 000	2 531	3 22	-074	438	1 250	2 000	2 594	3 25

(B) ENTIRE STANDARD REVISED

P A NAVY-AS Other Cast ARMY-AR	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERS AND STEPPED, HEXAGON WRENCHING, STEEL, .190-32 NF-3A X .250-28 UNF-3A	MILITARY STANDARD MS9304
AIR FORCE-99	PROCUREMENT SPECIFICATION AMS 7452-73	SUPERSEDES:	PAGE 1 OF 2

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5307-0438

USER ACTIVITIES.

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APPROVED 24 FEB 60 REVISED (B) 22 MAY 86

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TABLE I DASH NUMBERS AND DIMENSIONS - CONTINUED

FED SUP CLASS
5307

DASH NUMBER	A	B + 000 - 060	C	L REF	APPROX WEIGHT LBS/100	DASH NUMBER	A	B + 000 - 060	C	L REF	APPROX WEIGHT LBS/100
-100	.500	1/	.500	1 156	1 66	-150	.562	1/	.500	2 9	75
-101	.500	1/	.562	1 219	1 75	-151	.562	1/	.562	1 28	1 8
-102	.500	1/	.625	1 281	1 81	-152	.562	1/	.625	1 344	1 86
-103	.500	1/	.688	1 344	1 86	-153	.562	1/	.688	1 406	1 95
-104	.500	1/	.750	1 406	1 95	-154	.562	1/	.750	1 469	2 00
-105	.500	1/	.812	1 469	2 00	-155	.562	1/	.812	1 531	2 09
-106	.500	.125	.875	1 531	2 09	-156	.562	.125	.875	1 594	2 15
-107	.500	.188	.938	1 594	2 15	-157	.562	.188	.938	1 656	2 23
-108	.500	.250	1 000	1 656	2 23	-158	.562	.250	1 000	1 719	2 32
-109	.500	.312	1 062	1 719	2 32	-159	.562	.312	1 062	1 781	2 37
-110	.500	.375	1 125	1 781	2 37	-160	.562	.375	1 125	1 844	2 43
-111	.500	.438	1 188	1 844	2 43	-161	.562	.438	1 188	1 906	2 51
-112	.500	.500	1 250	1 906	2 51	-162	.562	.500	1 250	1 969	2 60
-113	.500	.562	1 312	1 969	2 60	-163	.562	.562	1 312	2 03	2 66
-114	.500	.625	1 375	2 031	2 66	-164	.562	.625	1 375	2 094	2 71
-115	.500	.688	1 438	2 094	2 71	-165	.562	.688	1 438	2 156	2 80
-116	.500	.750	1 500	2 156	2 80	-166	.562	.750	1 500	2 219	2 89
-117	.500	.812	1 562	2 219	2 89	-167	.562	.812	1 562	2 281	2 94
-118	.500	.875	1 625	2 281	2 94	-168	.562	.875	1 625	2 344	2 99
-119	.500	.938	1 688	2 344	2 99	-169	.562	.938	1 688	2 406	3 08
-120	.500	1.000	1 750	2 406	3 08	-170	.562	1 000	1 750	2 469	3 16
-121	.500	1.062	1 812	2 469	3 16	-171	.562	1 062	1 812	2 531	3 22
-122	.500	1.125	1 875	2 531	3 22	-172	.562	1 125	1 875	2 594	3 25
-123	.500	1.188	1 938	2 594	3 25	-173	.562	1 188	1 938	2 656	3 28
-124	.500	1.250	2 000	2 656	3 28	-174	.562	1 250	2 000	2 719	3 33

1/ THREAD TO HEAD MAXIMUM TWO INCOMPLETE THREADS

REQUIREMENTS

- MATERIAL** STEEL IN ACCORDANCE WITH AMS 6322-80
- FINISH** CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80
- HARDNESS** 26-32HRC
- DIMENSIONING AND TOLERANCING** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M
- THREADS** THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2 ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22
- SURFACE TEXTURE** SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH AS291-64
- MAGNETIC PARTICLE INSPECTION** MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83
- MARKING** MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2800-76 DEPRESSED .010 MAX
- TOLERANCE** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm .5^\circ$
- EDGES** BREAK SHARP EDGES .003 - .015, UNLESS OTHERWISE SPECIFIED
- PART NUMBER** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE MS9304-001

DASH NUMBER

BASIC MS NUMBER

MS9304-001 INDICATES STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, STEEL,
190-32 NF-3A X .250-28 UNF-3A, LENGTH 1.011

NOTES

- ALL DIMENSIONS ARE IN INCHES
- DO NOT USE UNASSIGNED PART NUMBERS
- 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
- REFERENCED GOVERNMENT (OR NONGOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THIS ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DDOISS), SPECIFIED AS THE SOLUTION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN
- THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION
- AS AND AMS ARE SAE PUBLICATIONS

P A NAVY-AS Other Govt ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, STEEL, .190-32 NF-3A X .250-28 UNF-3A	MILITARY STANDARD MS9304
PROCUREMENT SPECIFICATION AMS 7452-73		SUPERSEDES:	PAGE 2 OF 2

APPROVED 24 FEB 60 REVISED (B) FOR CHANGES SEE CHANGES 1 AND 2