

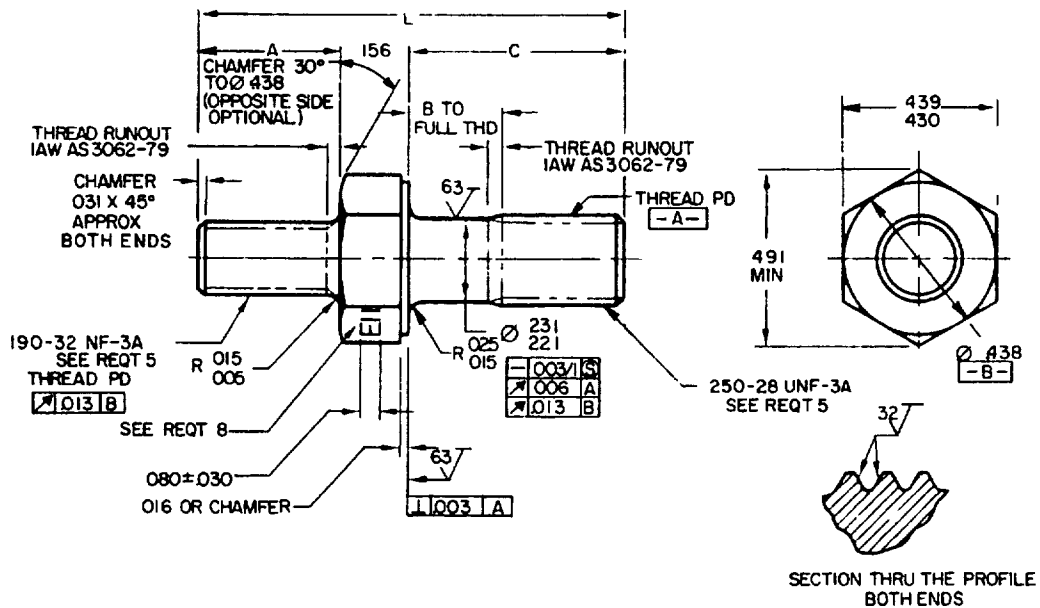
FED SUP CLASS
5307

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 | 1.125 | 875 | 1 406 | 1 95 | -056 | 438 | 1.125 | 875 | 1 469 | 2 00 |
| -008 | 375 | 1.188 | 938 | 1 469 | 2 00 | -057 | 438 | 1.188 | 938 | 1 531 | 2 09 |
| -009 | 375 | 1.250 | 1 000 | 1 531 | 2 09 | -058 | 438 | 1.250 | 1 000 | 1 594 | 2 15 |
| -010 | 375 | 1.312 | 1 062 | 1 594 | 2 15 | -059 | 438 | 1.312 | 1 062 | 1 656 | 2 23 |
| -011 | 375 | 1.375 | 1 125 | 1 656 | 2 23 | -060 | 438 | 1.375 | 1 125 | 1 719 | 2 32 |
| -012 | 375 | 1.438 | 1 188 | 1 719 | 2 32 | -061 | 438 | 1.438 | 1 188 | 1 781 | 2 37 |
| -013 | 375 | 1.500 | 1 250 | 1 781 | 2 37 | -062 | 438 | 1.500 | 1 250 | 1 844 | 2 43 |
| -014 | 375 | 1.562 | 1 312 | 1 844 | 2 43 | -063 | 438 | 1.562 | 1 312 | 1 906 | 2 51 |
| -015 | 375 | 1.625 | 1 375 | 1 906 | 2 51 | -064 | 438 | 1.625 | 1 375 | 1 969 | 2 60 |
| -016 | 375 | 1.688 | 1 438 | 1 969 | 2 60 | -065 | 438 | 1.688 | 1 438 | 2 031 | 2 66 |
| -017 | 375 | 1.750 | 1 500 | 2 031 | 2 66 | -066 | 438 | 1.750 | 1 500 | 2 094 | 2 71 |
| -018 | 375 | 1.812 | 1 562 | 2 094 | 2 71 | -067 | 438 | 1.812 | 1 562 | 2 156 | 2 80 |
| -019 | 375 | 1.875 | 1 625 | 2 156 | 2 80 | -068 | 438 | 1.875 | 1 625 | 2 219 | 2 89 |
| -020 | 375 | 1.938 | 1 688 | 2 219 | 2 89 | -069 | 438 | 1.938 | 1 688 | 2 281 | 2 94 |
| -021 | 375 | 2 000 | 1 750 | 2 281 | 2 94 | -070 | 438 | 2 000 | 1 750 | 2 344 | 2 99 |
| -022 | 375 | 2 062 | 1 812 | 2 344 | 2 99 | -071 | 438 | 2 062 | 1 812 | 2 406 | 3 08 |
| -023 | 375 | 2 125 | 1 875 | 2 406 | 3 08 | -072 | 438 | 2 125 | 1 875 | 2 469 | 3 16 |
| -024 | 375 | 2 188 | 1 938 | 2 469 | 3 16 | -073 | 438 | 2 188 | 1 938 | 2 531 | 3 22 |
| -025 | 375 | 2 250 | 2 000 | 2 531 | 3 22 | -074 | 438 | 2 250 | 2 000 | 2 594 | 3 25 |

(B) ENTIRE STANDARD REVISED

| | | | |
|--------------------------------------|--|---|-----------------------------|
| P A NAVY-AS Other Cast ARMY-AR | INTERNATIONAL INTEREST | TITLE STUD, SHOULDERED 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.

DISTRIBUTION STATEMENT A Approved for public release; distribution is unlimited

REVIEWER ACTIVITIES.
AIR FORCE-82
DLA-IS

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 24 FEB 60 REVISED (B) 22 MAY 86

USER ACTIVITIES.

REVIEWER ACTIVITIES.
AIR FORCE-82
DLA-IS

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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 THE INDEX 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

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|--|---------------------------|--|---|
| 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