

FED. SUP CLASS  
5307

USER ACTIVITIES:

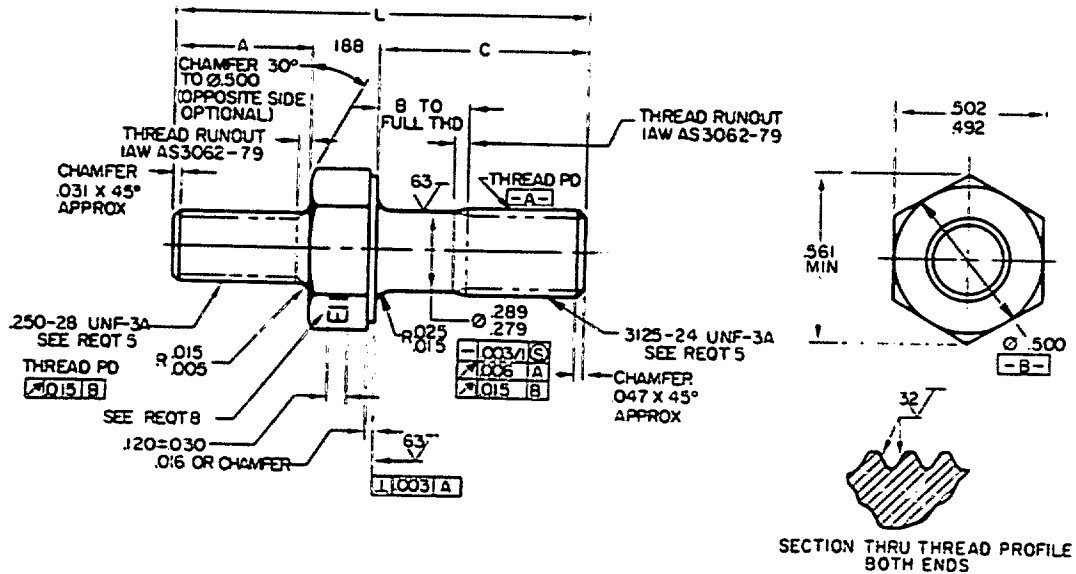


TABLE 1. DASH NUMBERS AND DIMENSIONS

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	.438		.500	1.125	2.54	-050	.500		.500	1.188	2.66
-002	.438		.562	1.188	2.66	-051	.500		.562	1.250	2.77
-003	.438		.625	1.250	2.77	-052	.500		.625	1.312	2.88
-004	.438		.688	1.312	2.88	-053	.500		.688	1.375	2.99
-005	.438		.750	1.375	2.99	-054	.500		.750	1.438	3.11
-006	.438		.812	1.438	3.11	-055	.500		.812	1.500	3.22
-007	.438		.875	1.500	3.22	-056	.500		.875	1.562	3.33
-008	.438		.930	1.562	3.33	-057	.500		.938	1.625	3.45
-009	.438	.125	1.000	1.625	3.45	-058	.500	.125	1.000	1.688	3.56
-010	.438	.188	1.062	1.688	3.56	-059	.500	.188	1.062	1.750	3.67
-011	.438	.250	1.125	1.750	3.67	-060	.500	.250	1.125	1.812	3.79
-012	.438	.312	1.188	1.812	3.79	-061	.500	.312	1.188	1.875	3.90
-013	.438	.375	1.250	1.875	3.90	-062	.500	.375	1.250	1.938	4.01
-014	.438	.438	1.312	1.938	4.01	-063	.500	.438	1.312	2.000	4.13
-015	.438	.500	1.375	2.000	4.13	-064	.500	.500	1.375	2.062	4.24
-016	.438	.562	1.438	2.062	4.24	-065	.500	.562	1.438	2.125	4.35
-017	.438	.625	1.500	2.125	4.35	-066	.500	.625	1.500	2.188	4.47
-018	.438	.688	1.562	2.188	4.47	-067	.500	.688	1.562	2.250	4.58
-019	.438	.750	1.625	2.250	4.58	-068	.500	.750	1.625	2.312	4.69
-020	.438	.812	1.688	2.312	4.69	-069	.500	.812	1.688	2.375	4.81
-021	.438	.875	1.750	2.375	4.81	-070	.500	.875	1.750	2.438	4.92
-022	.438	.938	1.812	2.438	4.92	-071	.500	.938	1.812	2.500	5.03
-023	.438	1.000	1.875	2.500	5.03	-072	.500	1.000	1.875	2.562	5.15
-024	.438	1.062	1.938	2.562	5.15	-073	.500	1.062	1.938	2.625	5.26
-025	.438	1.125	2.000	2.625	5.26	-074	.500	1.125	2.000	2.688	5.37

(B) ENTIRE STANDARD REVISED

P. A. NAVY-AS Other Cust ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, STEEL, 250-28 UNF-3A X 3125-24 UNF-3A	MILITARY STANDARD <b>MS9306</b>
PROCUREMENT SPECIFICATION AMS 7452-73		SUPERSEDES:	PAGE 1 OF 2

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FORM 100-10

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5307-0440

APPROVED 24 FEB 60 REVISED (B) 22 MAY 86

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5307

TABLE I. DASH NUMBERS AND DIMENSIONS - CONTINUED

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	.562	1/	.500	1.250	2.77	-150	.625	1/	.500	1.312	2.88
-101	.562	1/	.562	1.312	2.88	-151	.625	1/	.562	1.375	2.99
-102	.562	1/	.625	1.375	2.99	-152	.625	1/	.625	1.438	3.11
-103	.562	1/	.688	1.438	3.11	-153	.625	1/	.688	1.500	3.22
-104	.562	1/	.750	1.500	3.22	-154	.625	1/	.750	1.562	3.33
-105	.562	1/	.812	1.562	3.33	-155	.625	1/	.812	1.625	3.45
-106	.562	1/	.875	1.625	3.45	-156	.625	1/	.875	1.688	3.56
-107	.562	1/	.938	1.688	3.56	-157	.625	1/	.938	1.750	3.67
-108	.562	.125	1.000	1.750	3.67	-158	.625	.125	1.000	1.812	3.79
-109	.562	.188	1.062	1.812	3.79	-159	.625	.188	1.062	1.875	3.90
-110	.562	.250	1.125	1.875	3.90	-160	.625	.250	1.125	1.938	4.01
-111	.562	.312	1.188	1.938	4.01	-161	.625	.312	1.188	2.000	4.13
-112	.562	.375	1.250	2.000	4.13	-162	.625	.375	1.250	2.062	4.24
-113	.562	.438	1.312	2.062	4.24	-163	.625	.438	1.312	2.125	4.35
-114	.562	.500	1.375	2.125	4.35	-164	.625	.500	1.375	2.188	4.47
-115	.562	.562	1.438	2.188	4.47	-165	.625	.562	1.438	2.250	4.58
-116	.562	.625	1.500	2.250	4.58	-166	.625	.625	1.500	2.312	4.69
-117	.562	.688	1.562	2.312	4.69	-167	.625	.688	1.562	2.375	4.81
-118	.562	.750	1.625	2.375	4.81	-168	.625	.750	1.625	2.438	4.92
-119	.562	.812	1.688	2.438	4.92	-169	.625	.812	1.688	2.500	5.03
-120	.562	.875	1.750	2.500	5.03	-170	.625	.875	1.750	2.562	5.15
-121	.562	.938	1.812	2.562	5.15	-171	.625	.938	1.812	2.625	5.26
-122	.562	1.000	1.875	2.625	5.26	-172	.625	1.000	1.875	2.688	5.37
-123	.562	1.062	1.938	2.688	5.37	-173	.625	1.062	1.938	2.750	5.48
-124	.562	1.125	2.000	2.750	5.48	-174	.625	1.125	2.000	2.812	5.59

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

## REQUIREMENTS:

1. **MATERIAL:** STEEL IN ACCORDANCE WITH AMS 6322-90.
2. **FINISH:** CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80.
3. **HARDNESS:** 26-32HRC.
4. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH AMS Y14.5M.
5. **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.
6. **SURFACE TEXTURE:** SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH A1291-64.
7. **MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-81.
8. **MARKING:** MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2300-76. DEPRESSED .010 MAX.
9. **TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
10. **EDGES:** BREAK SHARP EDGES .003 - .015, UNLESS OTHERWISE SPECIFIED.
11. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9306-001

MS9306-001  
 MS9306 DASH NUMBER  
 001 BASIC MS NUMBER

MS9306-001 INDICATES: STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, STEEL,  
 .250-28 UNF-3A X .3125-24 UNF-3A; LENGTH 1.100.

## NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. DO NOT USE UNASSIGNED PART NUMBERS.
3. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE UNPUBLISHED WORK HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
4. REFERENCED GOVERNMENT OR NONGOVERNMENT DOCUMENTS OF THE UNITED STATES IN ANY ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) APPLICABLE TO THE SPECIFICATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE AUTOMOTIVE WRENCHING MANUFACTURING DIVISION.
6. ALL AMS ARE SAE PUBLICATIONS.

P. A. NAVY-AS Other Cust ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, STEEL, .250-28 UNF-3A X .3125-24 UNF-3A	MILITARY STANDARD MS9306
PROCUREMENT SPECIFICATION AMS 7452-73	SUPERSEDES:	PAGE 2 OF 2	

DD FORM 672-1 COORDINATED

5307-0440

USER ACTIVITIES

REVIEWER ACTIVITIES  
AIR FORCE-82  
DLA-15This 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) FOR CHANGES SEE PAGES 1 AND 2