

FED SUP CLASS  
5307

USER ACTIVITIES

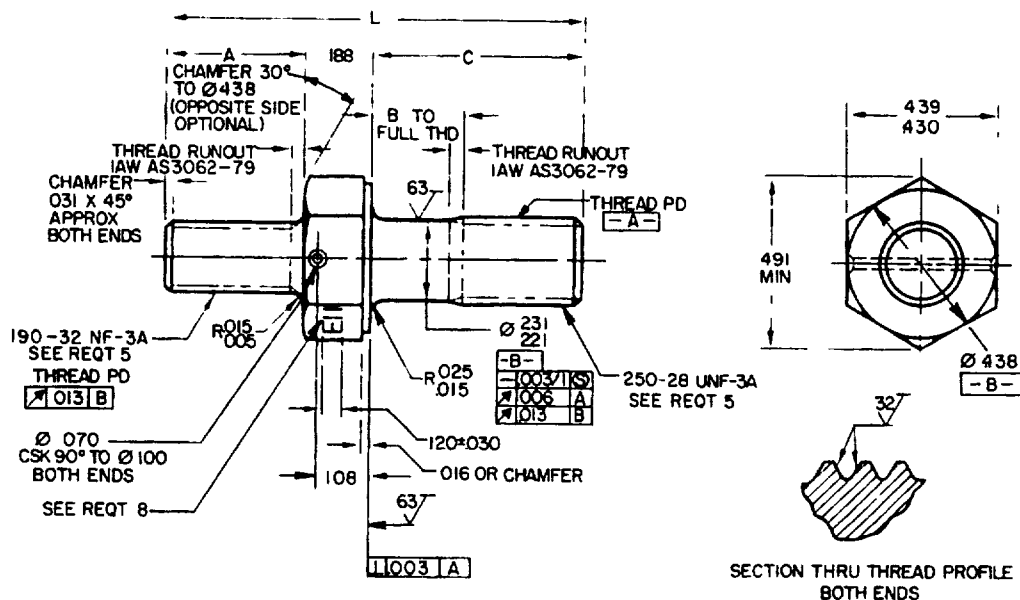


TABLE I DASH NUMBERS AND DIMENSIONS

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	1 062	1 61	-050	438	1/	500	1 125	1 66
-002	375	1/	.562	1 125	1 66	-051	438	1/	.562	1 188	1 75
-003	375	1/	.625	1 188	1 75	-052	438	1/	.625	1 250	1 83
-004	375	1/	.688	1 250	1 83	-053	438	1/	.688	1 312	1 89
-005	375	1/	.750	1 312	1 89	-054	438	1/	.750	1 375	1 95
-006	375	1/	.812	1 375	1 95	-055	438	1/	.812	1 438	2 03
-007	375	.125	.875	1 438	2 03	-056	438	.125	.875	1 500	2 09
-008	375	.188	.938	1 500	2 09	-057	438	.188	.938	1 562	2 17
-009	375	.250	1 000	1 562	2 17	-058	438	.250	1 000	1 625	2 23
-010	375	.312	1 062	1 625	2 23	-059	438	.312	1 062	1 688	2 32
-011	375	.375	1 125	1 688	2 32	-060	438	.375	1 125	1 750	2 40
-012	375	.438	1 188	1 750	2 40	-061	438	.438	1 188	1 812	2 46
-013	375	.500	1 250	1 812	2 46	-062	438	.500	1 250	1 875	2 51
-014	375	.562	1 312	1 875	2 51	-063	438	.562	1 312	1 938	2 60
-015	375	.625	1 375	1 938	2 60	-064	438	.625	1 375	2 000	2 68
-016	375	.688	1 438	2 000	2 68	-065	438	.688	1 438	2 062	2 74
-017	375	.750	1 500	2 062	2 74	-066	438	.750	1 500	2 125	2 80
-018	375	.812	1 562	2 125	2 80	-067	438	.812	1 562	2 188	2 89
-019	375	.875	1 625	2 188	2 89	-068	438	.875	1 625	2 250	2 97
-020	375	.938	1 688	2 250	2 97	-069	438	.938	1 688	2 312	3 02
-021	375	1 000	1 750	2 312	3 02	-070	438	1 000	1 750	2 375	3 08
-022	375	1 062	1 812	2 375	3 08	-071	438	1 062	1 812	2 438	3 16
-023	375	1 125	1 875	2 438	3 16	-072	438	1 125	1 875	2 500	3 25
-024	375	1 188	1 938	2 500	3 25	-073	438	1 188	1 938	2 562	3 28
-025	375	1 250	2 000	2 562	3 28	-074	438	1 250	2 000	2 625	3 31

(B) ENTIRE STANDARD REVISED

P A NAVY-AS Other Cost ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL, .190-32 UNF-3A X .250-28 UNF-3A	MILITARY STANDARD <b>MS9309</b>
PROCUREMENT SPECIFICATION AMS 7452-73	SUPERSEDES:	PAGE 1 OF 2	

APPROVED 24 FEB 60 REVISED (B) 22 MAY 86

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REVIEWER ACTIVITIES  
AIR FORCE-82  
DLA-1S

AMSC N/A

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5307-0443

FED SUP CLASS  
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	REF	APPROX WEIGHT LBS/100
-100	500	1/	500	1.188	1 75	-150	562	1/	500	1 250	1 83
-101	500	1/	562	1 250	1 83	-151	562	1/	562	1 312	1 89
-102	500	1/	625	1 312	1 89	-152	562	1/	625	1 375	1 95
-103	500	1/	.688	1 375	1.95	-153	562	1/	.688	1 438	2 03
-104	500	1/	.750	1 438	2 03	-154	562	1/	.750	1 500	2 09
-105	500	1/	.812	1 500	2 09	-155	562	1/	.812	1 562	2 17
-106	500	.125	.875	1 562	2 17	-156	562	.125	.875	1 625	2 23
-107	500	.188	.938	1 625	2 23	-157	562	.188	.938	1 688	2 32
-108	500	.250	1 000	1.688	2 32	-158	562	.250	1 000	1 750	2 40
-109	500	.312	1.062	1 750	2.40	-159	562	.312	1 062	1 812	2 46
-110	.500	.375	1 125	1.812	2 46	-160	562	.375	1 125	1 875	2 51
-111	.500	.438	1 188	1 875	2 51	-161	562	.438	1 188	1 938	2 60
-112	.500	.500	1.250	1 938	2 60	-162	562	.500	1 250	2 000	2 68
-113	500	.562	1 312	2 000	2 68	-163	562	.562	1 312	2 062	2 74
-114	500	.625	1 375	2 062	2 74	-164	562	.625	1 375	2 125	2 80
-115	500	.688	1 438	2 125	2 80	-165	562	.688	1 438	2 188	2 89
-116	.500	.750	1 500	2.188	2.89	-166	562	.750	1 500	2 250	2 97
-117	500	.812	1.562	2 250	2 97	-167	562	.812	1 562	2 312	3 02
-118	500	.875	1 625	2 312	3 02	-168	562	.875	1 625	2 375	3 08
-119	500	.938	1.688	2.375	3 08	-169	562	.938	1 688	2 438	3 16
-120	.500	1.000	1 750	2 438	3 16	-170	562	1 000	1 750	2 500	3 25
-121	500	1 062	1.812	2.500	3 25	-171	562	1 062	1 812	2 562	3 28
-122	500	1.125	1 875	2.562	3 28	-172	562	1 125	1 875	2 625	3 31
-123	500	1 188	1 938	2 625	3 31	-173	562	1 188	1 938	2 688	3 33
-124	500	1.250	2 000	2 688	3 33	-174	562	1 250	2 000	2 750	3 39

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 MS9309-001

DASH NUMBER

BASIC MS NUMBER

MS9309-001 INDICATES STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL,  
190-32 UNF-3A X 250-28 UNF-3A, LENGTH 1.062

## 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 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
- THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION
- AS AND AMS ARE SAE PUBLICATIONS

F A NAVY-AS Other Cust ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
		STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL, 190-32 UNF-3A X 250-28 UNF-3A	MS9309
PROCUREMENT SPECIFICATION AMS 7452-73	SUPERSEDES:	PAGE 2 OF 2	

USER ACTIVITIES.

REVIEWER ACTIVITIES.  
AIR FORCE - B2  
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) FOR CHANGES SEE PAGES 1 AND 2