

FED SUP CLASS
5307

USER ACTIVITIES

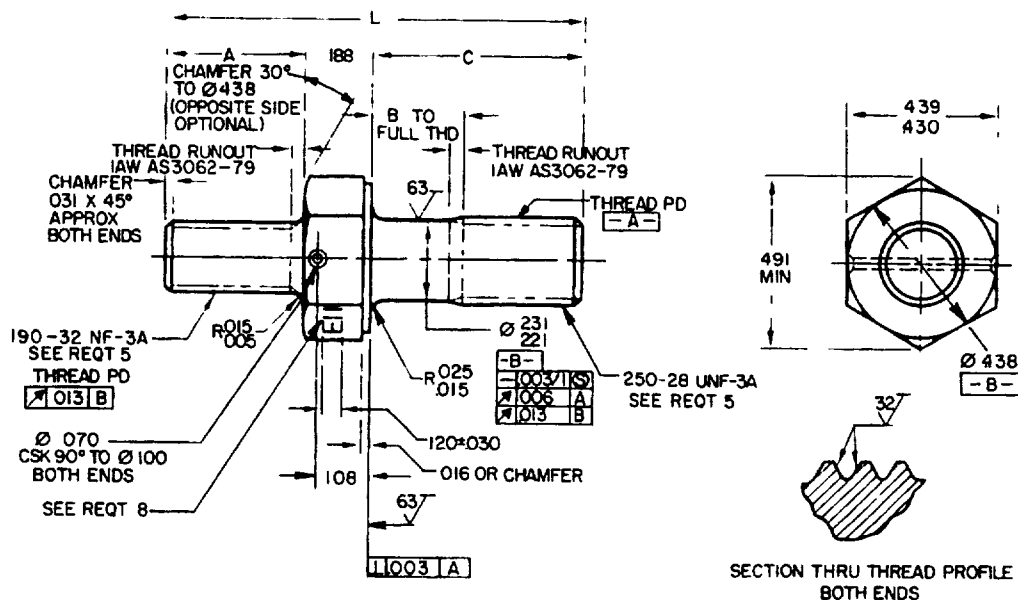


TABLE I DASH NUMBERS AND DIMENSIONS

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 MS9309
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	L 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