

FED SUP CLASS
5307

USER ACTIVITIES

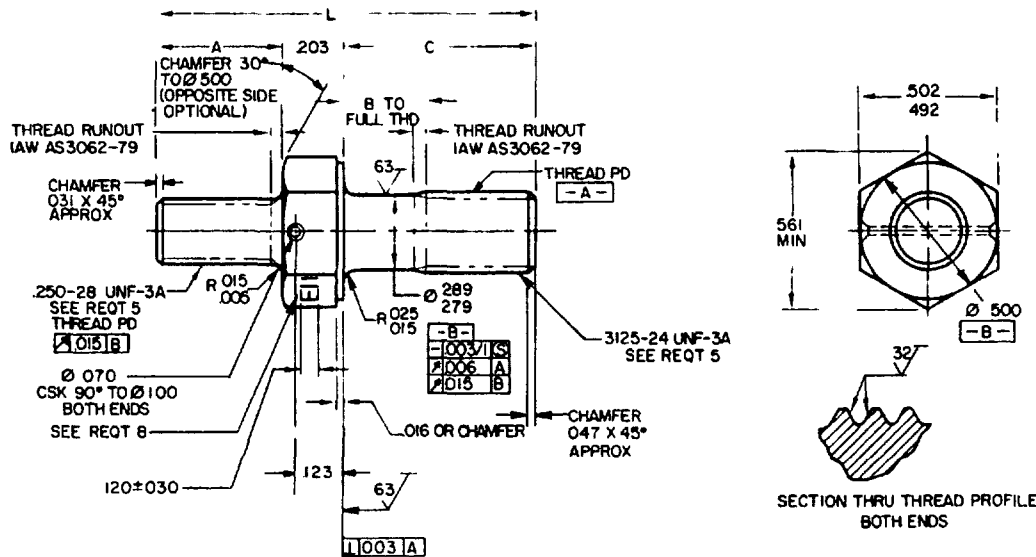
SECTION THRU THREAD PROFILE
BOTH ENDS

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	438	✓	500	1 141	2 57	-050	500	✓	500	1 203	2 68
-002	438	✓	562	1 203	2 60	-051	500	.562	1 266	1 266	2 80
-003	438	✓	625	1 266	2 80	-052	500	✓	625	1 328	2 91
-004	438	✓	688	1 328	2 91	-053	500	✓	688	1 391	3 02
-005	438	✓	750	1 391	3 02	-054	500	✓	750	1 453	3 14
-006	438	✓	812	1 453	3 14	-055	500	✓	812	1 516	3 25
-007	438	✓	875	1 516	3 25	-056	500	✓	.875	1 578	3 36
-008	438	✓	.938	1 578	3 36	-057	500	✓	938	1 641	3 48
-009	438	125	1 000	1 641	3 48	-058	500	125	1 000	1 703	3 59
-010	438	188	1 062	1 703	3 59	-059	500	.188	1 062	1 766	3 70
-011	438	250	1 125	1 766	3 70	-060	500	.250	1 125	1 828	3 84
-012	438	312	1 188	1 828	3 84	-061	500	312	1 188	1 891	3 93
-013	438	.375	1 250	1 891	3 93	-062	500	375	1 250	1 953	4 04
-014	438	438	1 312	1 953	4 04	-063	500	438	1 312	2 016	4 16
-015	438	500	1 375	2 016	4 16	-064	500	500	1 375	2 078	4 27
-016	438	562	1 438	2 078	4 27	-065	500	562	1 438	2 141	4 38
-017	438	625	1 500	2 141	4 38	-066	500	.625	1 500	2 203	4 49
-018	438	688	1 562	2 203	4 49	-067	500	688	1 562	2 266	4 60
-019	438	750	1 625	2 266	4 60	-068	500	.750	1 625	2 328	4 72
-020	438	812	1 688	2 328	4 72	-069	500	812	1 688	2 391	4 83
-021	438	875	1 750	2 391	4 82	-070	500	.875	1 750	2 453	4 95
-022	438	938	.812	2 453	4 95	-071	500	938	1 812	2 516	5 06
-023	438	1 000	1 875	2 516	5 06	-072	500	1 000	1 875	2 578	5 17
-024	438	1 062	1 938	2 578	5 17	-073	500	1 062	1 938	2 641	5 29
-025	438	1 125	2 000	2 641	5 29	-074	500	1 125	2 000	2 703	5 35

(B) ENTIRE STANDARD REVISED

P A NAVY-AS Other Cast ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL, .250-28 UNF-3A X .3125-24 UNF-3A	MILITARY STANDARD MS9311
PROCUREMENT SPECIFICATION AMS 7452-73	SUPSEDES:	PAGE 1 OF 2	

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JSC N/A

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5307-0445

APPROVED 24 FEB 60 REVISED (B) 22 MAY 86

USER ACTIVITIES

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.

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	562	1/	500	1 266	2 80	-150	625	1/	500	1 328	2 91
-101	562	1/	562	1 328	2 91	-151	625	1/	562	1 391	3 02
-102	562	1/	625	1 391	3 02	-152	625	1/	625	1 453	3 14
-103	562	1/	688	1 453	3 14	-153	625	1/	688	1 516	3 25
-104	562	1/	750	1 516	3 25	-154	625	1/	750	1 578	3 36
-105	562	1/	812	1 578	3 36	-155	625	1/	812	1 641	3 48
-106	562	1/	875	1 641	3 48	-156	625	1/	875	1 703	3 59
-107	562	1/	938	1 703	3 59	-157	625	1/	938	1 766	3 70
-108	562	.125	1 000	1 766	3 70	-158	625	.125	1 000	1 828	3 84
-109	562	.188	1 062	1 828	3 84	-159	625	.188	1 062	1 891	3 93
-110	562	.250	1 125	1 891	3 93	-160	625	.250	1 125	1 953	4 04
-111	562	.312	1 188	1 953	4 04	-161	625	.312	1 188	2 016	4 16
-112	562	.375	1 250	2 016	4 16	-162	625	.375	1 250	2 078	4 27
-113	562	.438	1 312	2 078	4 27	-163	625	.438	1 312	2 141	4 38
-114	562	.500	1 375	2 141	4 38	-164	625	.500	1 375	2 203	4 49
-115	562	.562	1 438	2 203	4 49	-165	625	.562	1 438	2 266	4 60
-116	562	.625	1 500	2 266	4 60	-166	.625	.625	1 500	2 328	4 72
-117	562	.688	1 562	2 328	4 72	-167	625	.688	1 562	2 391	4 83
-118	562	.750	1 625	2 391	4 83	-168	625	.750	1 625	2 453	4 95
-119	562	.812	1 688	2 453	4 95	-169	625	.812	1 688	2 516	5 06
-120	562	.875	1 750	2 516	5 06	-170	625	.875	1 750	2 578	5 17
-121	562	.938	1 812	2 578	5 17	-171	625	.938	1 812	2 641	5 29
-122	562	1 000	1 875	2 641	5 29	-172	625	1 000	1 875	2 703	5 35
-123	562	1 062	1 938	2 703	5 35	-173	625	1 062	1 938	2 766	5 40
-124	562	1 125	2 000	2 766	5 40	-174	625	1 125	2 000	2 828	5 49

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: MS9311-001

DASH NUMBER

BASIC MS NUMBER

MS9311-001 INDICATES STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL,
250-28 UNF-3A X 3125-24 UNF-3A; LENGTH 1.141

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

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

NAVY-AS Other Cust ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL, .250-28 UNF-3A X.3125-24 UNF-3A	MILITARY STANDARD MS9311
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