

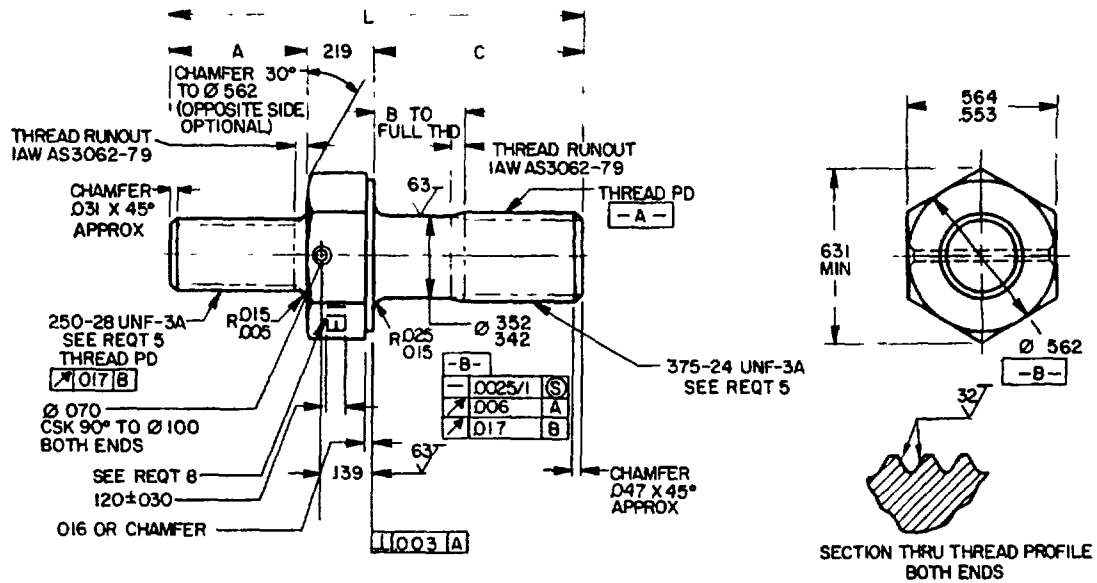
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5307

TABLE 1 DASHI NUMBERS AND DIMENSIONS

DASHI NUMBER	A	B + .000 - .060	C	L REF	APPROX WEIGHT LBS/100	DASHI NUMBER	A	B + .000 - .060	C	L REF	APPROX WEIGHT LBS/100
-001	438	1/	750	1 406	4.10	-050	500	1/	750	1.469	4.27
-002	438	1/	.812	1 469	4.27	-051	500	1/	.812	1.531	4.44
-003	438	1/	.875	1 531	4.44	-052	500	1/	.875	1.594	4.61
-004	438	1/	.938	1 594	4.61	-053	500	1/	.938	1.656	4.78
-005	438	1/	1 000	1.656	4.78	-054	.500	1/	1 000	1 719	4.95
-006	438	1/	1 062	1 719	4.95	-055	500	1/	1.062	1 781	5.12
-007	438	.125	1 125	1 781	5.12	-056	500	.125	1 125	1.844	5.29
-008	438	.188	1.188	1.844	5.29	-057	500	.188	1 188	1 906	5.43
-009	438	.250	1.250	1 906	5.43	-058	500	.250	1 250	1 969	5.60
-010	438	.312	1 312	1.969	5.60	-059	500	.312	1 312	2 031	5.77
-011	438	.375	1.375	2 031	5.77	-060	500	.375	1.375	2 094	5.94
-012	438	.438	1.438	2.094	5.94	-061	500	.438	1.438	2.156	6.14
-013	438	.500	1.500	2.156	6.14	-062	500	.500	1 500	2 219	6.28
-014	438	.562	1 562	2 219	6.28	-063	500	.562	1 562	2.281	6.45
-015	438	.625	1 625	2.281	6.45	-064	500	.625	1 625	2.344	6.62
-016	438	.688	1.688	2 344	6.62	-065	500	.688	1.688	2 406	6.76
-017	438	.750	1 750	2 406	6.76	-066	500	.750	1 750	2 469	6.93
-018	438	.812	1 812	2 469	6.93	-067	500	.812	1 812	2 531	7.10
-019	438	.875	1.875	2 531	7.10	-068	500	.875	1.875	2.594	7.27
-020	.438	.938	1.938	2 594	7.27	-069	500	.938	1 938	2 656	7.44
-021	438	1.000	2 000	2.656	7.44	-070	.500	1.000	2 000	2 719	7.61
-022	.438	1 062	2.062	2 719	7.61	-071	500	1 062	2 062	2 781	7.78
-023	438	1 125	2 125	2.781	7.78	-072	500	1 125	2 125	2 844	8.09
-024	438	1.250	2 250	2 906	8.09	-073	500	1 250	2 250	2 969	8.43
-025	438	1.375	2.375	3 031	8.43	-074	500	1 375	2 375	3 094	8.77
-026	.438	1.500	2.500	3.156	8.77	-075	500	1 500	2.500	3 219	9.11
-027	.438	1.625	2.625	3.281	9.11	-076	.500	1 625	2.625	3 344	9.42
-028	438	1 750	2.750	3.406	9.42	-077	.500	1 750	2.750	3 469	9.76
-029	.438	1.875	2 875	3 531	9.76	-078	.500	1.875	2.875	3.594	10.11
-030	.438	2.000	3.000	3 656	10.11	-079	.500	2.000	3.000	3.719	10.15

(B) ENTIRE STANDARD REVISED

NAVY-AS Other Cost ARMY-AR AIR FORCE-99	INTERNATIONAL INTEREST	TITLE: STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL, 250-28 UNF-3A X .375-24 UNF-3A	MILITARY STANDARD MS 9312
PROCUREMENT SPECIFICATION AMS 7452-73	SUPERSEDES:	PAGE 1 OF 3	

DD FORM 1 MAY 71 672-1 (COORDINATED)

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5307-0446

APPROVED 24 FEB 60 REVISED (B) 22 MAY 86

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DLA-1S

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TABLE 1 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/	.750	1.531	4.44	-150	.625	1/	.750	1.594	4.61
-101	.562	1/	.812	1.594	4.61	-151	.625	1/	.812	1.656	4.78
-102	.562	1/	.875	1.656	4.78	-152	.625	1/	.875	1.719	4.95
-103	.562	1/	.938	1.719	4.95	-153	.625	1/	.938	1.781	5.12
-104	.562	1/	1.000	1.781	5.12	-154	.625	1/	1.000	1.844	5.29
-105	.562	1/	1.062	1.844	5.29	-155	.625	1/	1.062	1.906	5.43
-106	.562	.125	1.125	1.906	5.43	-156	.625	.125	1.125	1.969	5.60
-107	.562	.188	1.188	1.969	5.60	-157	.625	.188	1.188	2.031	5.77
-108	.562	.250	1.250	2.031	5.77	-158	.625	.250	1.250	2.094	5.94
-109	.562	.312	1.312	2.094	5.94	-159	.625	.312	1.312	2.156	6.14
-110	.562	.375	1.375	2.156	6.14	-160	.625	.375	1.375	2.219	6.28
-111	.562	.438	1.438	2.219	6.28	-161	.625	.438	1.438	2.281	6.45
-112	.562	.500	1.500	2.281	6.45	-162	.625	.500	1.500	2.344	6.62
-113	.562	.562	1.562	2.344	6.62	-163	.625	.562	1.562	2.406	6.76
-114	.562	.625	1.625	2.406	6.76	-164	.625	.625	1.625	2.469	6.93
-115	.562	.688	1.688	2.469	6.93	-165	.625	.688	1.688	2.531	7.10
-116	.562	.750	1.750	2.531	7.10	-166	.625	.750	1.750	2.594	7.27
-117	.562	.812	1.812	2.593	7.27	-167	.625	.812	1.812	2.656	7.44
-118	.562	.875	1.875	2.656	7.44	-168	.625	.875	1.875	2.719	7.61
-119	.562	.938	1.938	2.719	7.61	-169	.625	.938	1.938	2.781	7.78
-120	.562	1.000	2.000	2.781	7.78	-170	.625	1.000	2.000	2.844	8.09
-121	.562	1.062	2.062	2.844	8.09	-171	.625	1.062	2.062	2.906	8.43
-122	.562	1.125	2.125	2.906	8.43	-172	.625	1.125	2.125	2.969	8.77
-123	.562	1.250	2.250	3.031	8.77	-173	.625	1.250	2.250	3.094	9.11
-124	.562	1.375	2.375	3.156	9.11	-174	.625	1.375	2.375	3.219	9.42
-125	.562	1.500	2.500	3.281	9.42	-175	.625	1.500	2.500	3.344	9.76
-126	.562	1.625	2.625	3.406	9.76	-176	.625	1.625	2.625	3.469	10.11
-127	.562	1.750	2.750	3.531	10.11	-177	.625	1.750	2.750	3.594	10.15
-128	.562	1.875	2.875	3.656	10.15	-178	.625	1.875	2.875	3.719	10.27
-129	.562	2.000	3.000	3.781	10.27	-179	.625	2.000	3.000	3.844	10.30

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 1

EXAMPLE: MS9312-001

DASH NUMBER

BASIC MS NUMBER

MS9312-001 INDICATES STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, DRILLED, STEEL,
.250-28 UNF-3A X .375-24 UNF-3A, LENGTH 1.406

P A 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 .375-24 UNF-3A	MILITARY STANDARD MS9312
PROCUREMENT SPECIFICATION AMS 7452-73		SUPERSEDES:	PAGE 2 OF 3

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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 REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
4. 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.
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION
6. AS AND AMS ARE SAE PUBLICATIONS.

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