

INCH-POUND

MS9317A
27 OCTOBER 1995
SUPERSEDING
MS9317(ASG)
16 MAY 60

MILITARY SPECIFICATION SHEET

SCREW, MACHINE-STEEL, SLOTTED
HEXAGON HEAD, 250-28,
NI-CAD PLATE

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS
AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST
OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING DOCUMENT
LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS
AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION. (SEE REQ 13)

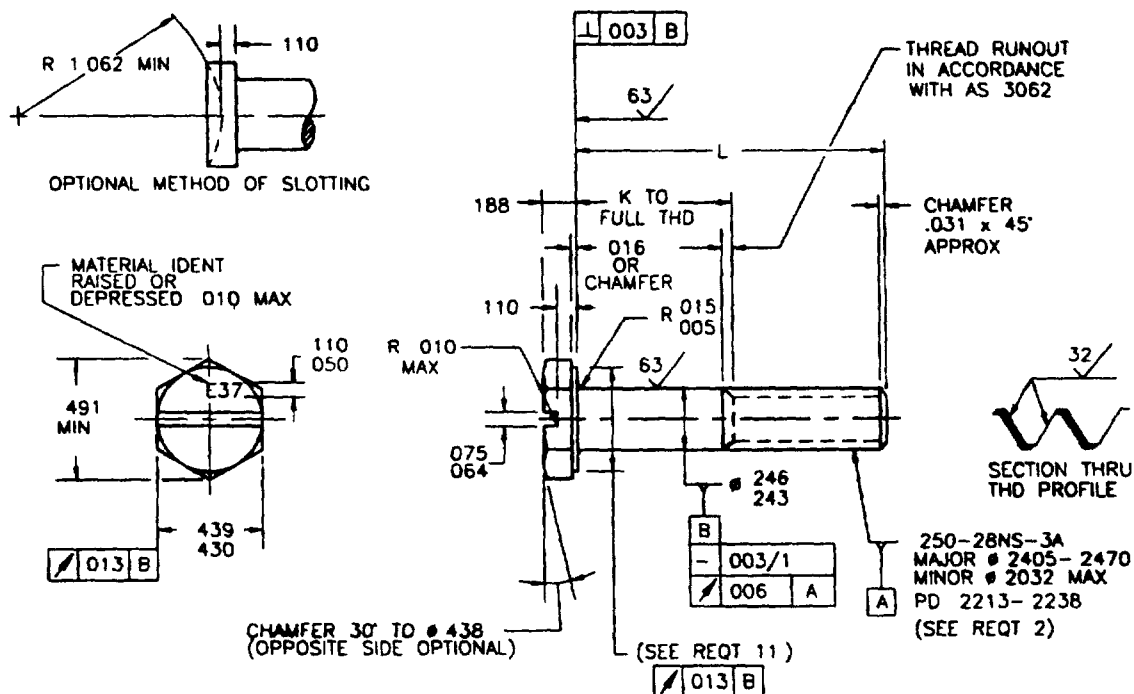


TABLE 1 DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-02	.500	(a)	1.50
-03	.562	(a)	1.68
(b) -04	.625	(a)	1.87
-05	.688	(a)	2.06
-06	.750	(a)	2.25
-07	.812	(a)	2.44
(b) -08	.875	.125	2.62
-09	.938	.188	2.81
-10	1.000	.250	3.00
-12	1.125	.375	3.37
-14	1.250	.500	3.75
-16	1.375	.625	4.12
-18	1.500	.750	4.50

(a) THREAD TO HEAD MAXIMUM TWO IMPERFECT THREADS

(b) PREFERRED LENGTHS

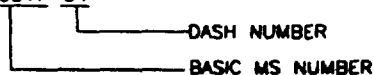
(A) ENTIRE DOCUMENT REVISED

MS9317A

REQUIREMENTS

- 1 MATERIAL STEEL PER AMS 6304
- 2 THREADS THREADS PER MIL-S-7742
- 3 DIMENSIONING AND TOLERANCING DIMENSIONING AND TOLERANCING SHALL BE PER ASME Y14.5M
- 4 HEAD TO SHANK FILLET HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS
- 5 MAGNETIC PARTICLE INSPECTION MAGNETIC PARTICLE INSPECTION SHALL BE PER AMS 2640
- 6 HARDNESS ROCKWELL C32-36
- 7 FINISH FINISH SHALL BE DIFFUSED NICKEL-CADMIUM PLATE PER AMS 2416. CONTACT POINTS PERMISSIBLE PD MAY BE MODIFIED .0012 MAX BEFORE PLATING. DIMENSIONS SPECIFIED ARE AFTER PLATING
- 8 SURFACE TEXTURE SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 250 MICROINCHES EXCEPT UPSET HEAD PER ANSI/ASME B46.1
- 9 TOLERANCE UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$
- 10 EDGES BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED
- 11 BEARING SURFACE BEARING SURFACE SHALL BE FLAT AND WASHER FACED. DIAMETER OF BEARING SURFACE SHALL BE EQUAL TO THE MAXIMUM WIDTH ACROSS FLATS WITHIN A TOLERANCE OF MINUS 10% IN ACCORDANCE WITH ANSI B18.2.1
- 12 PART NUMBER THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1

EXAMPLE MS9317-04



MS9317-04 INDICATES SCREW, MACHINE-STEEL, SLOTTED HEXAGON HEAD,
250-28, NI-CAD PLATE, LENGTH .625

- 13 PROCUREMENT SPECIFICATION, AMS 7452

NOTES.

- 1 ALL DIMENSIONS IN INCHES
- 2 DO NOT USE UNASSIGNED PART NUMBERS
- 3 IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.
- 4 UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION
- 5 THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION
- 6 AS AND AMS ARE SAE PUBLICATIONS

MILITARY INTERESTS

CUSTODIANS

NAVY - AS

PREPARING ACTIVITY

DLA-15

(PROJECT 5305-2114)