

USER ACTIVITIES

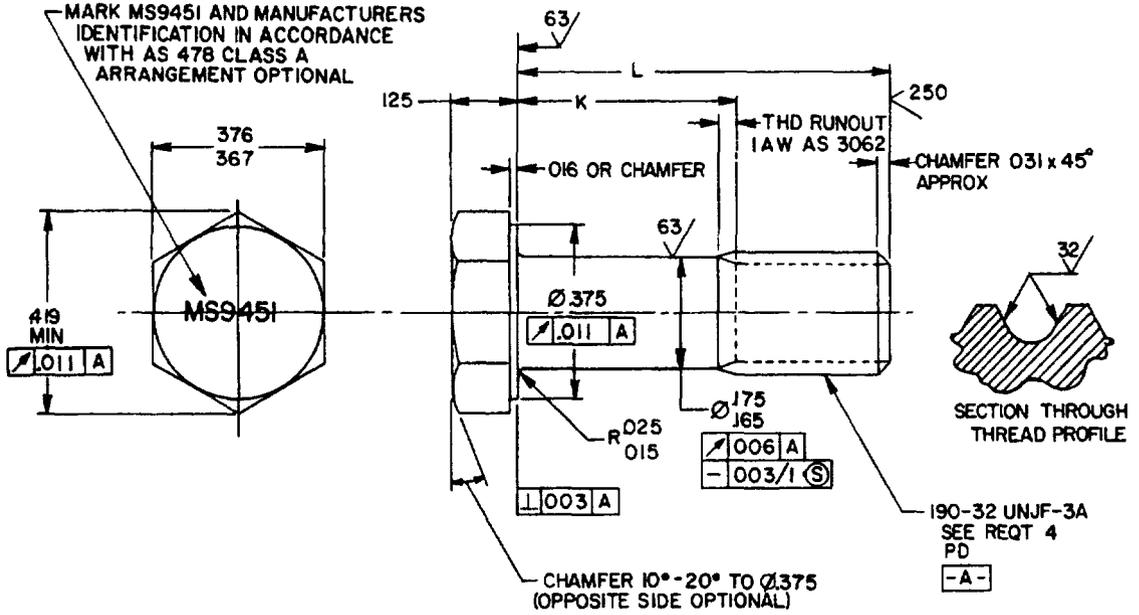


TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB./100	DASH NUMBER	L	K	APPROX WEIGHT LB./100
-04	.375	.072-.092	66	-31	2.375	1.685-1.745	1.95
-05	.438	.072-.092	70	-32	2.500	1.810-1.870	2.03
-06	.500	.072-.092	.74	-33	2.625	1.935-1.995	2.11
-07	.562	.072-.092	.78	-34	2.750	2.060-2.120	2.20
-08	.625	.072-.092	82	-35	2.875	2.185-2.245	2.28
-09	.688	.072-.092	86	-36	3.000	2.310-2.370	2.36
-10	.750	.072-.092	90	-37	3.125	2.435-2.495	2.44
-11	.812	.122-.182	94	-38	3.250	2.560-2.620	2.52
-12	.875	.185-.245	98	-39	3.375	2.685-2.745	2.60
-13	938	248-.308	1.02	-40	3.500	2.810-2.870	2.68
-14	1.000	310-.370	1.07	-41	3.625	2.935-2.995	2.76
-15	1.062	.372-.432	1.11	-42	3.750	3.060-3.120	2.84
-16	1.125	435-.495	1.15	-43	3.875	3.185-3.245	2.92
-17	1.188	.498-.558	1.19				
-18	1.250	560-.620	1.23				
-19	1.312	622-.682	1.27				
-20	1.375	.685-.745	1.31				
-21	1.438	748-.808	1.35				
-22	1.500	.810-.870	1.39				
-23	1.562	.872-.932	1.43				
-24	1.625	.935-.995	1.47				
-25	1.688	998-1.058	1.51				
-26	1.750	1.060-1.120	1.55				
-27	1.875	1.185-1.245	1.63				
-28	2.000	1.310-1.370	1.71				
-29	2.125	1.435-1.495	1.79				
-30	2.250	1.560-1.620	1.87				

(A) ENTIRE STANDARD REVISED

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REVIEWER ACTIVITIES  
AIR FORCE - 82  
DLA - 1S

NAVY - AS Other Cast AIR FORCE - II	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, .190-32 UNJF-3A	MILITARY STANDARD <b>MS9451</b>
	PROCUREMENT SPECIFICATION	SUPERSEDES:	PAGE 1 OF 2

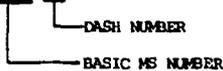
APPROVED 21 DEC 62 REVISED (A) 31 MAR 86

FED SUP CLASS  
5306

REQUIREMENTS:

1. **MATERIAL:** STEEL, IN ACCORDANCE WITH AMS 6304.
2. **PROTECTIVE COATING AND SURFACE TREATMENT:** DIFFUSED NICKEL-CADMIUM PLATE IN ACCORDANCE WITH AMS 2416 DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
3. **HARDNESS:** RC42-46 MAXIMUM.
4. **THREADS:** THREADS IN ACCORDANCE WITH MIL-S-8879.
5. **MANUFACTURING:** MANUFACTURING IN ACCORDANCE WITH AMS 7455-80 PARTS SUBJECT TO MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640-83 BEFORE PLATING.
6. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M
7. **SURFACE TEXTURE:** SURFACE TEXTURE IN ACCORDANCE WITH AS 291-64, UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON.
8. **MARKING:** MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478-79 CLASS A
9. **PART NUMBER.** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE: MS9451-04



MS9451-04 INDICATES: BOLT, MACHINE-STEEL AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, HEXAGON HEAD, .190-32 UNJF-3A, LENGTH .375

NOTES:

1. ALL DIMENSIONS IN INCHES.
2. UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$
3. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
4. DO NOT USE UNASSIGNED PART NUMBERS.
5. 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.
6. 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.
7. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
8. AS AND AMS ARE SAE PUBLICATIONS

USER ACTIVITIES.

REVIEWER ACTIVITIES:  
AIR FORCE-82  
DLA-1S

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.

APPROVED 21 DEC 62 REVISED (A) FOR CHANGES SEE PAGES 1 AND 2

P A NAVY-AS Other Cost AIR FORCE-11	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, .190-32 UNJF-3A	MILITARY STANDARD
			MS 9451
PROCUREMENT SPECIFICATION	SUPERSEDES:		SHEET 2 OF 2