

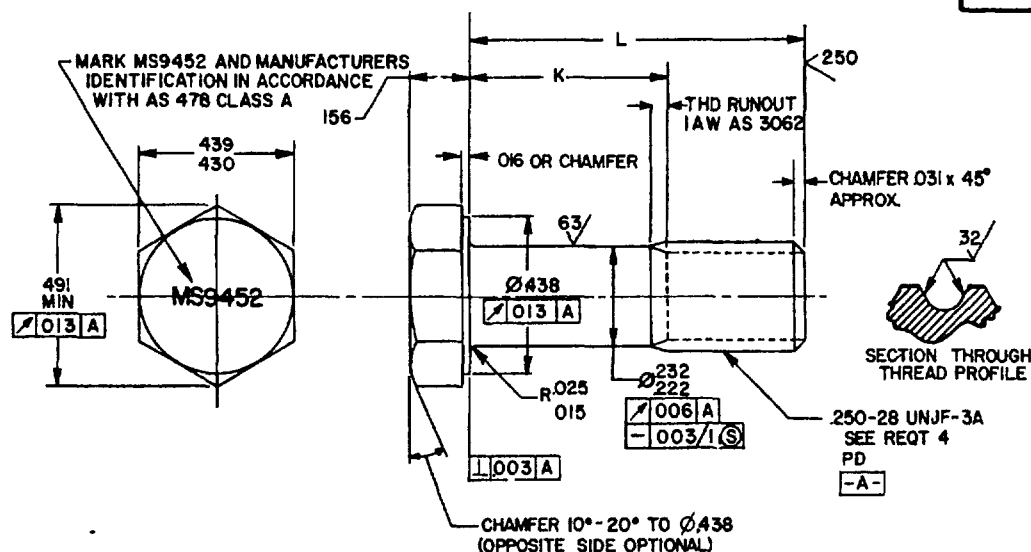
PED SUP CLASS
5306

TABLE I. DASH NUMBERS AND DIMENSIONS.

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	.375	.079-.099	1.16	-31	2.375	1.565-1.625	3.45
-05	.438	.079-.099	1.23	-32	2.500	1.690-1.750	3.59
-06	.500	.079-.099	1.30	-33	2.625	1.815-1.875	3.73
-07	.562	.079-.099	1.37	-34	2.750	1.940-2.000	3.88
-08	.625	.079-.099	1.44	-35	2.875	2.065-2.125	4.02
-09	.688	.079-.099	1.51	-36	3.000	2.190-2.250	4.16
-10	.750	.079-.099	1.58	-37	3.125	2.315-2.375	4.31
-11	.812	.079-.099	1.66	-38	3.250	2.440-2.500	4.45
-12	.875	.125-.145	1.73	-39	3.375	2.565-2.625	4.60
-13	.938	.128-.188	1.80	-40	3.500	2.690-2.750	4.74
-14	1.000	.190-.250	1.87	-41	3.625	2.815-2.875	4.88
-15	1.062	.252-.312	1.94	-42	3.750	2.940-3.000	5.03
-16	1.125	.315-.375	2.01	-43	3.875	3.065-3.125	5.17
-17	1.188	.378-.438	2.09	-44	4.000	3.190-3.250	5.31
-18	1.250	.440-.500	2.16	-45	4.125	3.315-3.375	5.46
-19	1.312	.502-.562	2.23	-46	4.250	3.440-3.500	5.60
-20	1.375	.565-.625	2.30	-47	4.375	3.565-3.625	5.74
-21	1.438	.628-.688	2.37	-48	4.500	3.690-3.750	5.89
-22	1.500	.690-.750	2.44	-49	4.625	3.815-3.875	6.03
-23	1.562	.752-.812	2.52	-50	4.750	3.940-4.000	6.17
-24	1.625	.815-.875	2.59	-51	4.875	4.065-4.125	6.32
-25	1.688	.878-.938	2.66	-52	5.000	4.190-4.250	6.46
-26	1.750	.940-1.000	2.73	-53	5.125	4.315-4.375	6.60
-27	1.875	1.065-1.125	2.87	-54	5.250	4.440-4.500	6.75
-28	2.000	1.190-1.250	3.02	-55	5.375	4.565-4.625	6.89
-29	2.125	1.315-1.375	3.16	-56	5.500	4.690-4.750	7.03
-30	2.250	1.440-1.500	3.30	-57	5.625	4.815-4.875	7.18
				-58	5.750	4.940-5.000	7.32
				-59	5.875	5.065-5.125	7.46
				-60	6.000	5.190-5.250	7.61

Ⓐ ENTIRE STANDARD REVISED

P A NAVY-AS Other Cast AIR FORCE-II	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, 250-28 UNJF-3A	MILITARY STANDARD
			MS 9452
PROCUREMENT SPECIFICATION	SUPERSEDES:		PAGE 1 OF 2

USER ACTIVITIES

REVIEWER ACTIVITIES
AIR FORCE-82
DLA-ISDISTRIBUTION STATEMENT A Approved for public release; distribution is unlimited.
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ANSC N/A

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0974

APPROVED 21 DEC 62 REVISED Ⓐ 31 MAR 86

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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. INCOMPLETE THREADS NOT TO ENTER FILLET.
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 1.

EXAMPLE: MS9452-04

DASH NUMBER

BASIC MS NUMBER

MS9452-04 INDICATES: BOLT, MACHINE-STEEL AMS 6304, DIFFUSED
NICKEL-CADMIUM PLATED, HEXAGON HEAD,
.250-28 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.

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

P A NAVY-AS Other Cust AIR FORCE-II	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, .250-28 UNJF-3A	MILITARY STANDARD MS9452
PROCUREMENT SPECIFICATION		SUPERSEDES:	SHEET 2 OF 2