

USER ACTIVITIES

REVISOR ACTIVITIES  
AIR FORCE-82  
DLA-1S

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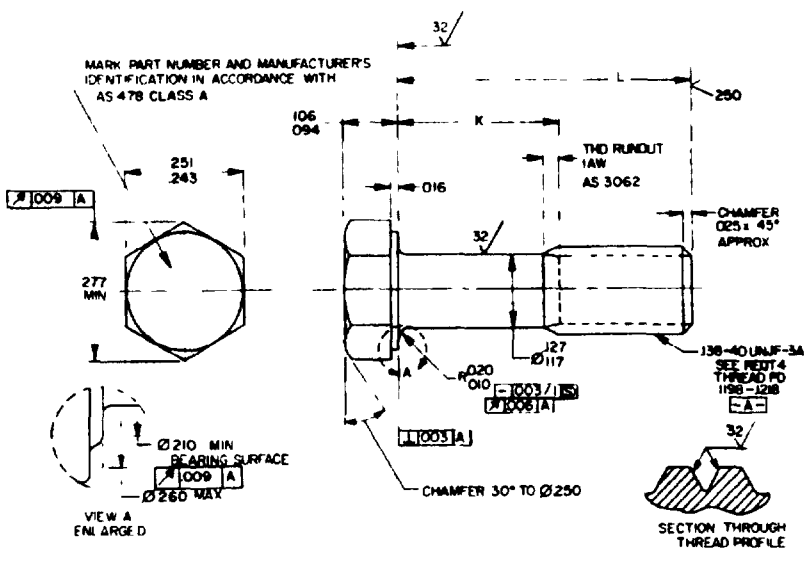


TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	F	APPROX WEIGHT LB./100
-02	.250	.058-.078	.25
-03	.312	.058-.078	.27
-04	.375	.058-.078	.30
-05	.438	.058-.078	.32
-06	.500	.058-.078	.34
-07	.562	.058-.078	.37
-08	.625	.058-.099	.39
-09	.688	.102-.162	.42
-10	.750	.164-.224	.44
-11	.812	.226-.286	.46
-12	.875	.289-.349	.49
-13	.938	.352-.412	.51
-14	1.000	.414-.474	.53
-15	1.062	.476-.536	.56
-16	1.125	.539-.599	.58
-17	1.188	.602-.662	.61
-18	1.250	.664-.724	.63
-19	1.312	.726-.786	.65
-20	1.375	.789-.849	.68
-21	1.438	.852-.912	.70
-22	1.500	.914-.974	.72

© ENTIRE STANDARD REVISED

APPROVED 2 FEB 68 REVISED 22 MAY 86

NAVY-AS Other Code ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .138-40 UNJF-3A	MILITARY STANDARD
			MS9516
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES	PAGE 1 OF 2	

AMSC N/A

DD FORM 672-1 (COORDINATED)

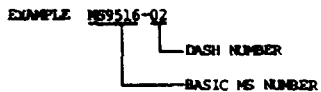
PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5305-1623

FED SUP CLASS  
5305

**REQUIREMENTS**

1. MATERIAL IN ACCORDANCE WITH AMS 6322-80
2. PROTECTIVE COATING AND SURFACE TREATMENT CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80 DIMENSIONS SPECIFIED ARE AFTER PLATING.
3. HARDNESS: 26-32 HRC
4. THREADS THREADS IN ACCORDANCE WITH MIL-S-8879
5. SURFACE TEXTURE SURFACE TEXTURE IN ACCORDANCE WITH ANSI B46.1. UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES, EXCEPT HEXAGON.
6. DIMENSIONING AND TOLERANCING DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M
7. 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 EXCEPT DASH NUMBER SIZES -10 AND SMALLER.
8. TOLERANCE: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$
9. MAGNETIC PARTICLE INSPECTION MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83
10. EDGES. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED
11. PART NUMBER THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1



MS9516-02 INDICATES - SCREW, MACHINE, HEXAGON HEAD, 138-40 UNJF-3A, LENGTH 250

**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 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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AIR FORCE-82  
DLA-13

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