

USER ACTIVITIES:

REVIEWER ACTIVITIES:  
AIR FORCE-82  
DLA-15

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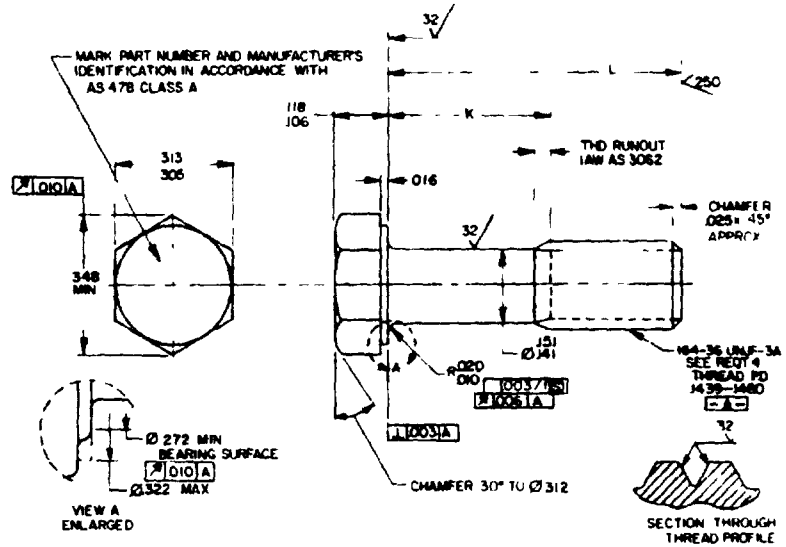


TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-03	312	062- 082	43
-04	375	062- 082	46
-05	438	.062-.062	.49
-06	500	062- 082	53
-07	562	062-.082	56
-08	625	062- 082	.59
-09	.688	.062- .110	.62
-10	.750	112- 172	.65
-11	812	.174-.234	.69
-12	875	.237-.297	.72
-13	.938	.300- .360	.75
-14	1.000	362-.422	.78
-15	1.062	424- 484	.81
-16	1 125	487- 547	.84
-17	1 188	550-.610	.88
-18	1 250	.612-.672	.91
-19	1 312	674-.734	.94
-20	1 375	737- 797	.97
-21	1 438	800- .860	1.00
-22	1 500	.862- 922	1.04
-23	1.562	924- 984	1.07
-24	1 625	987-1 047	1.10
-25	1 688	1 050-1 110	1 13
-26	1.750	1 112-1 172	1 16
-27	1.875	1 237-1 297	1 23
-28	2 000	1.362-1 422	1 29

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NAVY-AS Other Cast ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .164-36UNJF-3A	MILITARY STANDARD	
			MS9517	
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES		PAGE	1 OF 2

MSC N/A

DD FORM 1 MAY 71 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

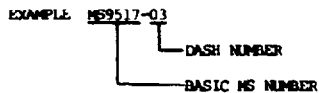
5305-1624

APPROVED 2 FEB 68 REVISED 22 MAY 86

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 MICRONS, 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 -11 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 I



MS9517-03 INDICATES - SCREW, MACHINE, HEXAGON HEAD, 164-36 UNJF-3A, LENGTH 312.

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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REVISIONS ACTIVITIES:  
AIR FORCE - 82  
DLA - 18

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APPROVED 2 FEB 68 REVISED (C) FOR CHANGES SEE PAGES 1 AND 2

P. A. NAVY-AS <small>Other Code</small> ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE <b>SCREW, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .164-36 UNJF-3A</b>	<b>MILITARY STANDARD</b>
			<b>MS9517</b>
PROCUREMENT SPECIFICATION <b>AMS 7452</b>	SUPERSEDES	PAGE 2 OF 2	