

TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
				-31	2 625	1 690-1.750	5 88
				-32	2 750	1.815-1 875	6 10
				-33	2.875	1 940-2 000	6.33
-04	500	088- 108	2 05	-34	3 000	2 065-2 125	6.55
-05	562	088- 108	2.16	-35	3 125	2 190-2 250	6.78
-06	625	088- 108	2 27	-36	3 250	2 315-2 375	7.01
-07	688	088- 108	2.38	-37	3 375	2 440-2 500	7.23
-08	750	088- 108	2 49	-38	3 500	2 565-2 625	7 46
-09	812	088- 108	2 60	-39	3 625	2 690-2 750	7 68
-10	875	088- 108	2 72	-40	3 750	2 815-2 875	7 91
-11	938	088- 108	2 83	-41	3 875	2 940-3 000	8 13
-12	1 000	088- 125	2 94	-42	4 000	3 065-3.125	8.36
-13	1.062	128- 188	3 06	-43	4 125	3 190-3 250	8 59
-14	1 125	190- 250	3 17	-44	4 250	3.315-3.375	8 81
-15	1 188	253- 313	3.28	-45	4 375	3 440-3.500	9 04
-16	1 250	315- 375	3 39	-46	4 500	3.565-3 625	9 26
-17	1 312	377- 437	3.51	-47	4 625	3 690-3 750	9 49
-18	1 375	440- 500	3.62	-48	4 750	3 815-3 875	9 71
-19	1 438	503- 563	3 73	-49	4 875	3 940-4 000	9 94
-20	1 500	565- 625	3 85	-50	5 000	4.065-4 125	10 17
-21	1 562	627- 687	3 96	-51	5 125	4 190-4 250	10 39
-22	1 625	690- 750	4 07	-52	5.250	4 315-4 375	10.62
-23	1 688	753- 813	4 18	-53	5 375	4 440-4.500	10 84
-24	1.750	815- 875	4 30	-54	5 500	4 565-4 625	11.07
-25	1 875	940-1 000	4 52	-55	5 625	4 690-4 750	11 29
-26	2.000	1.065-1 125	4.75	-56	5 750	4 815-4.875	11 52
-27	2 125	1 190-1 250	4 97	-57	5.875	4 940-5 000	11.74
-28	2.250	1 315-1 375	5 20	-58	6 000	5 065-5 125	11 97
-29	2 375	1.440-1.500	5 43				
-30	2.500	1 565-1.625	5 65				

Ⓐ ENTIRE STANDARD REVISED

P A NAVY-AS Other Cust ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE  BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .3125-24 UNJF-3A	MILITARY STANDARD	
			MS9520	
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE 1 OF 2	

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.

FED SUP CLASS  
5306

## 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 -14 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

EXAMPLE MS9520-04

DASH NUMBER

BASIC MS NUMBER

MS9520-04 INDICATES - BOLT, MACHINE, HEXAGON HEAD, 3125-24  
UNJF-3A, LENGTH 500

## 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

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

P A NAVY-AS Other Cust ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .3125-24 UNJF-3A	MILITARY STANDARD
PROCUREMENT SPECIFICATION AMS 7452		SUPERSEDES:	MS9520 PAGE 2 OF 2