

FED SUP CLASS  
5306

USER ACTIVITIES

REVIEWER ACTIVITIES  
AIR FORCE-82  
DLA-15

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NSC N/A

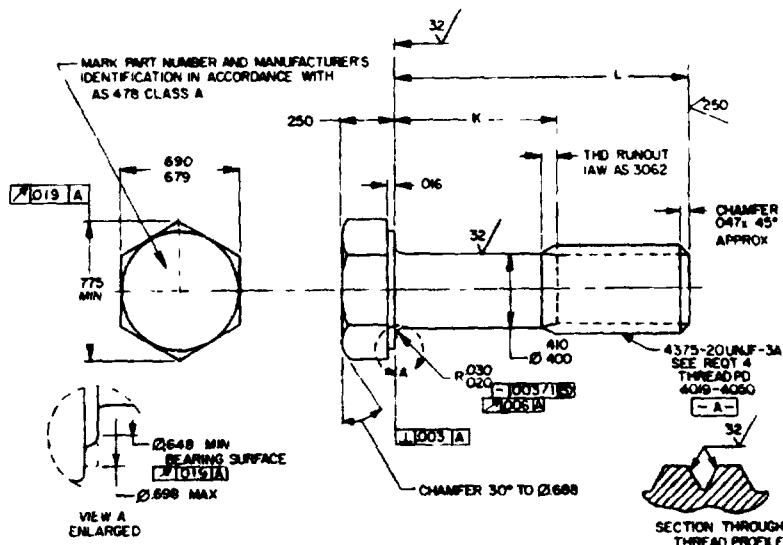


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	688	.105- .125	5.78	-31	3.000	1.815-1.875	14.20
-05	750	.105- .125	6.01	-32	3.125	1.940-2.000	14.65
-06	.812	.105- .125	6.24	-33	3.250	2.065-2.125	15.11
-07	.875	.105- .125	6.47	-34	3.375	2.190-2.250	15.56
-08	.938	.105- .125	6.69	-35	3.500	2.315-2.375	16.02
-09	1.000	.105- .125	6.92	-36	3.625	2.440-2.500	16.47
-10	1.062	.105- .125	7.15	-37	3.750	2.565-2.625	16.93
-11	1.125	.105- .125	7.37	-38	3.875	2.690-2.750	17.38
-12	1.188	.105- .125	7.60	-39	4.000	2.815-2.875	17.84
-13	1.250	.105- .125	7.83	-40	4.125	2.940-3.000	18.29
-14	1.312	.128- .188	8.06	-41	4.250	3.065-3.125	18.74
-15	1.375	.190- .250	8.28	-42	4.375	3.190-3.250	19.20
-16	1.438	.253- .313	8.51	-43	4.500	3.315-3.375	19.65
-17	1.500	.315- .375	8.74	-44	4.625	3.440-3.500	20.11
-18	1.562	.377- .437	8.97	-45	4.750	3.565-3.625	20.56
-19	1.625	.440- .500	9.19	-46	4.875	3.690-3.750	21.02
-20	1.688	.503- .563	9.42	-47	5.000	3.815-3.875	21.47
-21	1.750	.565- .625	9.65	-48	5.125	3.940-4.000	21.93
-22	1.875	.690- .750	10.10	-49	5.250	4.065-4.125	22.38
-23	2.000	.815- .875	10.56	-50	5.375	4.190-4.250	22.84
-24	2.125	.940-1.000	11.01	-51	5.500	4.315-4.375	23.29
-25	2.250	1.065-1.125	11.47	-52	5.625	4.440-4.500	23.75
-26	2.375	1.190-1.250	11.92	-53	5.750	4.565-4.625	24.20
-27	2.500	1.315-1.375	12.38	-54	5.875	4.690-4.750	24.66
-28	2.625	1.440-1.500	12.83	-55	6.000	4.815-4.875	25.11
-29	2.750	1.565-1.625	13.29				
-30	2.875	1.690-1.750	13.74				

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P. A. NAVY-AS ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .4375-20 UNF-3A	MILITARY STANDARD
			MS9522
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES		PAGE 1 OF 2

DD FORM 672-1 (COORDINATED)  
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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## 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 -15 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

EXAMPLE: MS9522-04

DASH NUMBER

BASIC MS NUMBER

MS9522-04 INDICATES - BOLT, MACHINE, HEXAGON HEAD, 4375-20  
UNJF-3A, LENGTH .688.

## 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 (DDOISS) 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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P A NAVY-AS Other Code ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, 4375-20UNJF-3A	MILITARY STANDARD
			MS9522
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2 OF 2	

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