

FED SUP CLASS
5 3 0 6

USER ACTIVITIES

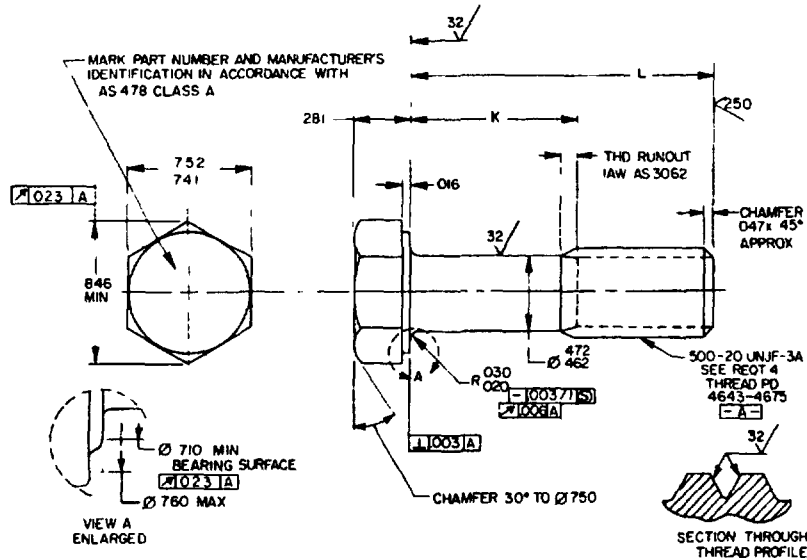


TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	812	105-125	7.77	-31	3.250	1.940-2.000	19.55
-05	875	105-125	8.07	-32	3.375	2.065-2.125	20.16
-06	938	105-125	8.37	-33	3.500	2.190-2.250	20.76
-07	1.000	105-125	8.67	-34	3.625	2.315-2.375	21.36
-08	1.062	105-125	8.98	-35	3.750	2.440-2.500	21.97
-09	1.125	105-125	9.28	-36	3.875	2.565-2.625	22.57
-10	1.188	105-125	9.58	-37	4.000	2.690-2.750	23.18
-11	1.250	105-125	9.88	-38	4.125	2.815-2.875	23.78
-12	1.312	105-125	10.19	-39	4.250	2.940-3.000	24.38
-13	1.375	105-125	10.49	-40	4.375	3.065-3.125	24.99
-14	1.438	128-188	10.79	-41	4.500	3.190-3.250	25.59
-15	1.500	190-250	11.09	-42	4.625	3.315-3.375	26.20
-16	1.562	252-312	11.39	-43	4.750	3.440-3.500	26.80
-17	1.625	315-375	11.70	-44	4.875	3.565-3.625	27.41
-18	1.688	378-438	12.00	-45	5.000	3.690-3.750	28.01
-19	1.750	440-500	12.30	-46	5.125	3.815-3.875	28.61
-20	1.875	565-625	12.90	-47	5.250	3.940-4.000	29.22
-21	2.000	690-750	13.51	-48	5.375	4.065-4.125	29.82
-22	2.125	815-875	14.11	-49	5.500	4.190-4.250	30.43
-23	2.250	940-1.000	14.72	-50	5.625	4.315-4.375	31.03
-24	2.375	1.065-1.125	15.32	-51	5.750	4.440-4.500	31.64
-25	2.500	1.190-1.250	15.93	-52	5.875	4.565-4.625	32.24
-26	2.625	1.315-1.375	16.53	-53	6.000	4.690-4.750	32.84
-27	2.750	1.440-1.500	17.13				
-28	2.875	1.565-1.625	17.74				
-29	3.000	1.690-1.750	18.34				
-30	3.125	1.815-1.875	18.95				

Ⓐ ENTIRE STANDARD REVISED

P A NAVY-AS Other Cust ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .500-20UNJF-3A	MILITARY STANDARD
			MS9523
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE 1 OF 2

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0987

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REVIEWER ACTIVITIES
AIR FORCE-82
DLA-IS

APPROVED 2 FEB 68 REVISED Ⓐ 22 MAY 86

AMSC N//A

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 -.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: MS9523-04

DASH NUMBER

BASIC MS NUMBER

MS9523-04 INDICATES - BOLT, MACHINE, HEXAGON HEAD, 500-20
UNJF-3A, LENGTH .812.

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, .500-20 UNJF-3A	MILITARY STANDARD
			MS9523
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE	2 OF 2

DD FORM 672-1 (COORDINATED)
1 MAY 73

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REVIEWER ACTIVITIES.
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