

FED SUP CLASS  
5306

USER ACTIVITIES

REVISER ACTIVITIES  
AIR FORCE-82  
DLA-15

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MSC N/A

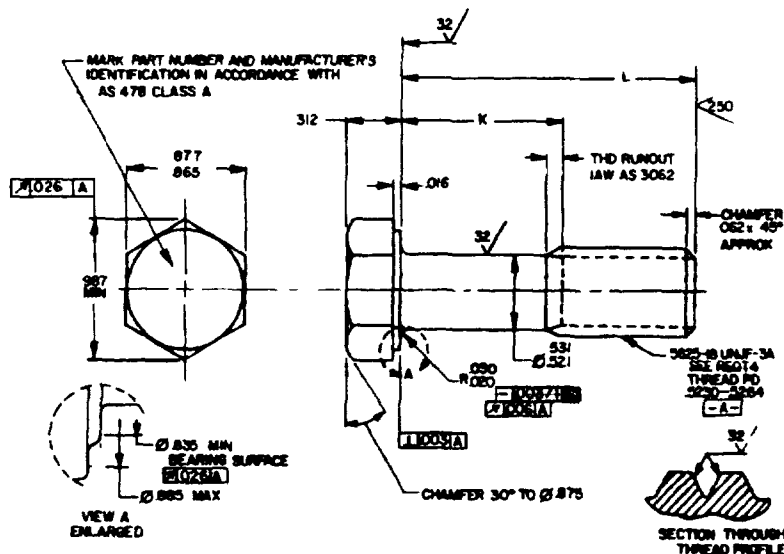


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	.875	.113-.133	11.18	-31	3.250	1.815-1.875	25.73
-05	.938	.113-.133	11.56	-32	3.375	1.940-2.000	26.49
-06	1.000	.113-.133	11.94	-33	3.500	2.065-2.125	27.26
-07	1.062	.113-.133	12.32	-34	3.625	2.190-2.250	28.02
-08	1.125	.113-.133	12.70	-35	3.750	2.315-2.375	28.79
-09	1.188	.113-.133	13.08	-36	3.875	2.440-2.500	29.56
-10	1.250	.113-.133	13.47	-37	4.000	2.565-2.625	30.32
-11	1.312	.113-.133	13.85	-38	4.125	2.690-2.750	31.09
-12	1.375	.113-.133	14.23	-39	4.250	2.815-2.875	31.86
-13	1.438	.113-.133	14.62	-40	4.375	2.940-3.000	32.62
-14	1.500	.113-.133	15.00	-41	4.500	3.065-3.125	33.39
-15	1.562	.128-.188	15.38	-42	4.625	3.190-3.250	34.15
-16	1.625	.190-.250	15.77	-43	4.750	3.315-3.375	34.92
-17	1.688	.253-.313	16.15	-44	4.875	3.440-3.500	35.69
-18	1.750	.315-.375	16.53	-45	5.000	3.565-3.625	36.45
-19	1.812	.377-.437	16.91	-46	5.125	3.690-3.750	37.22
-20	1.875	.440-.500	17.30	-47	5.250	3.815-3.875	37.99
-21	2.000	.565-.625	18.06	-48	5.375	3.940-4.000	38.75
-22	2.125	.690-.750	18.83	-49	5.500	4.065-4.125	39.52
-23	2.250	.815-.875	19.60	-50	5.625	4.190-4.250	40.28
-24	2.375	.940-1.000	20.36	-51	5.750	4.315-4.375	41.05
-25	2.500	1.065-1.125	21.13	-52	5.875	4.440-4.500	41.82
-26	2.625	1.190-1.250	21.90	-53	6.000	4.565-4.625	42.58
-27	2.750	1.315-1.375	22.66				
-28	2.875	1.440-1.500	23.43				
-29	3.000	1.565-1.625	24.19				
-30	3.125	1.690-1.750	24.96				

© ENTIRE STANDARD REVISED

P. A. <b>NAVY-AS</b> Other Code <b>ARMY-AV</b> <b>AIR FORCE-99</b>	INTERNATIONAL INTEREST	TITLE <b>BOLT, MACHINE, HEXAGON HEAD,          STEEL, CADMIUM PLATED,          5625-18 UNJF-3A</b>	<b>MILITARY STANDARD</b> <b>MS9524</b>
PROCUREMENT SPECIFICATION <b>AMS 7452</b>		SUPERSEDES	PAGE 1 OF 2

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0988

APPROVED 2 FEB 68 REVISED 22 MAY 66

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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 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 -16 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: MS9524-04

DASH NUMBER

BASIC MS NUMBER

MS9524-04 INDICATES - BOLT, MACHINE, HEXAGON HEAD, .5625-18  
UNJF-3A, LENGTH .875.

## 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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P A. NAVY-AS Other Code ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .5625-18 UNJF-3A	MILITARY STANDARD
			MS9524
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