

## USER ACTIVITIES

REVIEWER ACTIVITIES  
AIR FORCE - B2  
DLA-15

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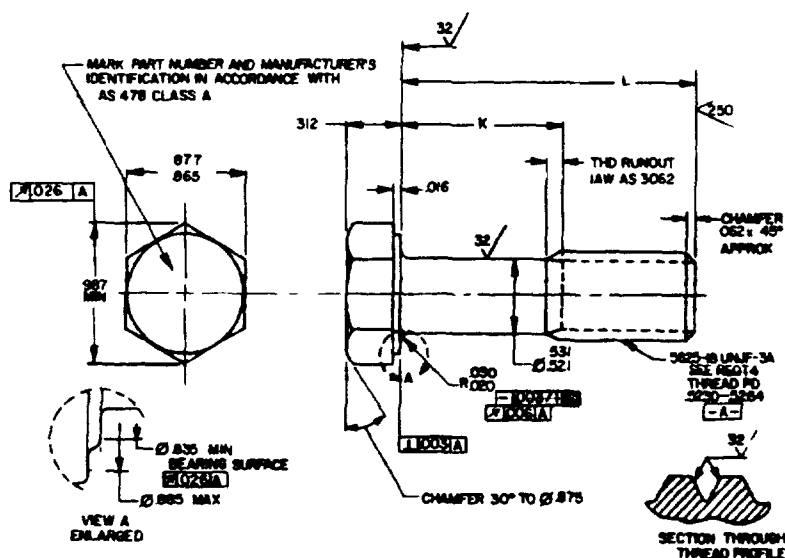


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	.875	.113-.133	11.18
-05	.938	.113-.133	11.56
-06	1.000	.113-.133	11.94
-07	1.062	.113-.133	12.32
-08	1.125	.113-.133	12.70
-09	1.188	.113-.133	13.08
-10	1.250	.113-.133	13.47
-11	1.312	.113-.133	13.85
-12	1.375	.113-.133	14.23
-13	1.438	.113-.133	14.62
-14	1.500	.113-.133	15.00
-15	1.562	.128-.188	15.38
-16	1.625	.190-.250	15.77
-17	1.688	.253-.313	16.15
-18	1.750	.315-.375	16.53
-19	1.812	.377-.437	16.91
-20	1.875	.440-.500	17.30
-21	2.000	.565-.625	18.06
-22	2.125	.690-.750	18.83
-23	2.250	.815-.875	19.60
-24	2.375	.940-1.000	20.36
-25	2.500	1.065-1.125	21.13
-26	2.625	1.190-1.250	21.90
-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

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

AMSC N/A

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

**5306-0988**

APPROVID 2 FEB 68 (C) 22 MAY 66

USER ACTIVITIES

REVIEWER ACTIVITIES  
AIR FORCE-82  
DLA-15This 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 MICROMETERS, 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.

APPROVED 2 FEB 68 REVISED © FOR CHANGES SEE PAGES 1 AND 2

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