

FED. SUP CLASS  
5306

USER ACTIVITIES:

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AIR FORCE-82  
DLA-IS

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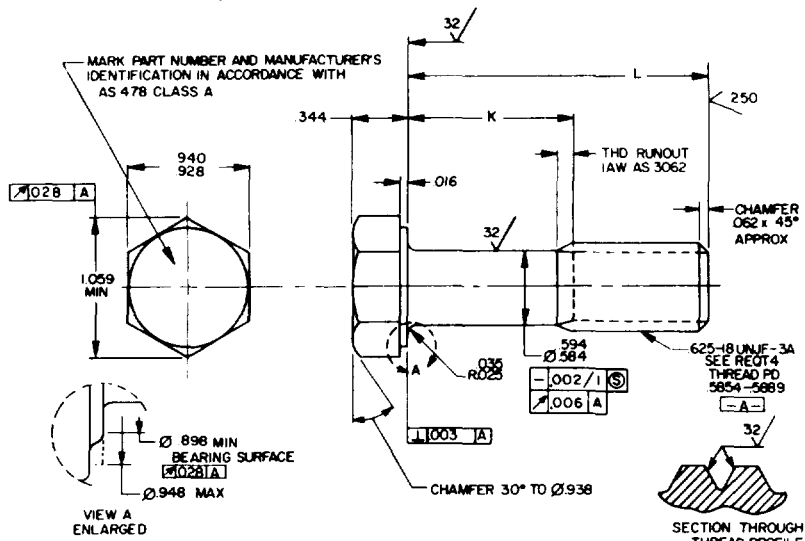


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-03	.938	.118-.138	14.53	-31	3.500	1.940-2.000	34.16
-04	1.000	.118-.138	15.01	-32	3.625	2.065-2.125	35.11
-05	1.062	.118-.138	15.49	-33	3.750	2.190-2.250	36.07
-06	1.125	.118-.138	15.97	-34	3.875	2.315-2.375	37.03
-07	1.188	.118-.138	16.45	-35	4.000	2.440-2.500	37.98
-08	1.250	.118-.138	16.93	-36	4.125	2.565-2.625	38.94
-09	1.312	.118-.138	17.41	-37	4.250	2.690-2.750	39.90
-10	1.375	.118-.138	17.89	-38	4.375	2.815-2.875	40.86
-11	1.438	.118-.138	18.36	-39	4.500	2.940-3.000	41.81
-12	1.500	.118-.138	18.84	-40	4.625	3.065-3.125	42.77
-13	1.562	.118-.138	19.32	-41	4.750	3.190-3.250	43.73
-14	1.625	.118-.138	19.80	-42	4.875	3.315-3.375	44.68
-15	1.688	.128-.188	20.28	-43	5.000	3.440-3.500	45.64
-16	1.750	.190-.250	20.76	-44	5.125	3.565-3.625	46.60
-17	1.812	.252-.312	21.24	-45	5.250	3.690-3.750	47.55
-18	1.875	.315-.375	21.71	-46	5.375	3.815-3.875	48.51
-19	2.000	.440-.500	22.67	-47	5.500	3.940-4.000	49.47
-20	2.125	.565-.625	23.63	-48	5.625	4.065-4.125	50.43
-21	2.250	.690-.750	24.59	-49	5.750	4.190-4.250	51.38
-22	2.375	.815-.875	25.54	-50	5.875	4.315-4.375	52.34
-23	2.500	.940-1.000	26.50	-51	6.000	4.440-4.500	53.30
-24	2.625	1.065-1.125	27.46				
-25	2.750	1.190-1.250	28.41				
-26	2.875	1.315-1.375	29.37				
-27	3.000	1.440-1.500	30.33				
-28	3.125	1.565-1.625	31.28				
-29	3.250	1.690-1.750	32.24				
-30	3.375	1.815-1.875	33.20				

Ⓐ ENTIRE STANDARD REVISED

P. A. NAVY-AS Other Cost ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .625-18UNJF-3A	MILITARY STANDARD MS9525
PROCUREMENT SPECIFICATION AMS 7452		SUPERSEDES:	PAGE 1 OF 2

APPROVED 2 FEB 68 REVISED Ⓐ 22 MAY 86

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DLA-15

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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 -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: MS9525-03

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      |-----DASH NUMBER
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      |-----BASIC MS NUMBER
  
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MS9525-03 INDICATES - BOLT, MACHINE, HEXAGON HEAD, .625-18  
UNJF-3A, LENGTH .938.

## 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	INTERNATIONAL INTEREST	TITLE <b>BOLT, MACHINE, HEXAGON HEAD, STEEL, CADMIUM PLATED, .625-18 UNJF-3A</b>	<b>MILITARY STANDARD</b> <b>MS 9525</b>
AIR FORCE-99		SUPERSEDES:	PAGE 2 OF 2
PROCUREMENT SPECIFICATION AMS 7452			