

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODDS SPECIFIED IN THE SOLICITATION: AS7477

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

PREPARING ACTIVITY: DLA-IS				MILITARY SPECIFICATION SHEET		SPECIFICATION SHEET NUMBER	
CUSTODIANS: ARMY- AR NAVY- SH				TITLE		MS9554 2 SEP 93	
AIR FORCE- 99 DLA-				SCREW, MACHINE-DOUBLE HEXAGON EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, .138-40 UNJF-3A		REV D	
REVIEW: 82				SUPERSEDING		MS9554 C 20 APR 93	
USER:				AMSC- N/A		FSC 5305	
PROJECT NUMBER: 5305-1955				DISTRIBUTION STATEMENT		Page 1 of 2	
A. Approved for public release, distribution is unlimited.				DD Form 672, MAY 88		PREVIOUS EDITIONS ARE OBSOLETE	

Form Approved
 OMB No. 0704-0188

WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870 FOR THIS DISTANCE

MARK PART NO. AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478 CLASS A EXCEPT FOR EDGE DISTANCE REQUIREMENT

138-40UNJF-3A
SEE REPT 2
THREAD PD
.1198-.1218

SECTION THRU
THREAD PROFILE

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-02	.250	.058-.078	.297
-03	.312	.058-.078	.318
-04	.375	.058-.078	.340
-05	.438	.058-.078	.363
-06	.500	.058-.078	.386
-07	.562	.058-.078	.406
-08	.625	.058-.099	.429
-09	.688	.102-.162	.451
-10	.750	.184-.224	.473
-11	.812	.226-.286	.495
-12	.875	.289-.349	.517
-13	.938	.352-.412	.539
-14	1.000	.414-.474	.561
-15	1.062	.476-.536	.583

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-16	1.125	.539-.599	.605
-17	1.188	.602-.662	.627
-18	1.250	.664-.724	.649
-19	1.312	.726-.786	.671
-20	1.375	.789-.849	.693
-21	1.438	.852-.912	.715
-22	1.500	.914-.974	.737
-23	1.562	.976-1.036	.759
-24	1.625	1.039-1.099	.781
-25	1.688	1.102-1.162	.803
-26	1.750	1.164-1.224	.825
-27	1.812	1.226-1.286	.847
-28	1.875	1.289-1.349	.869
-29	1.938	1.352-1.412	.891
-30	2.000	1.414-1.474	.913

(D) DENOTES CHANGE(S)

INCH-POUND

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(D)

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REQUIREMENTS:

1. **MATERIAL:** CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5731.
2. **THREADS:** THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
4. **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 -10 AND SMALLER.
5. **FLUORESCENT PENETRANT INSPECTION:** FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645.
6. **SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICRONCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI/ASME B46.1.
7. **TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
8. **EDGES:** BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
9. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE.

EXAMPLE: MS9554-02

DASH NUMBER

BASIC MS NUMBER

MS9554-02 INDICATES: SCREW, MACHINE-DOUBLE HEXAGON EXTENDED WASHER HEAD, .138-40 UNJF-3A, LENGTH .250.

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 NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF THE 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.

PREPARING ACTIVITY: DLA-IS CUSTODIANS: ARMY- AR NAVY- SH AIR FORCE- 99 DLA- REVIEW: 82 USER: PROJECT NUMBER: 5305-1855	MILITARY SPECIFICATION SHEET TITLE SCREW, MACHINE-DOUBLE HEXAGON EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL .138-40 UNJF-3A	SPECIFICATION SHEET NUMBER MS9554 2 SEP 93 REV D SUPERSEDING MS9554 C 20 APR 93 AMSC- N/A FSC 5305
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