

WRENCHING CONFIGURATION IN ACCORDANCE WITH
AS 870-74 FOR THIS DISTANCE

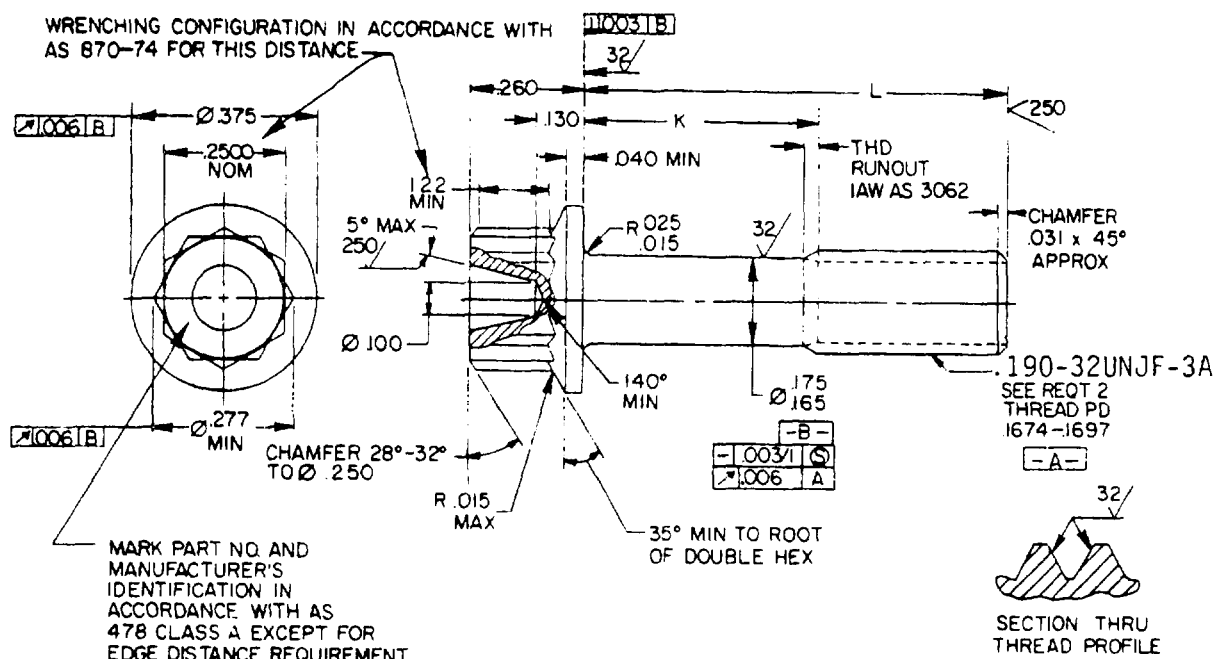


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	F	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-03	.312	.072-.092	.87	-18	1.250	.560-.620	1.47	-33	2.625	1.935-1.995	2.35
-04	.375	.072-.092	.91	-19	1.312	.622-.682	1.51	-34	2.750	2.060-2.120	2.43
-05	.438	.072-.092	.95	-20	1.375	.685-.745	1.55	-35	2.875	2.185-2.245	2.51
-06	.500	.072-.092	.99	-21	1.438	.748-.808	1.59	-36	3.000	2.310-2.370	2.59
-07	.562	.072-.092	1.03	-22	1.500	.810-.870	1.63	-37	3.125	2.435-2.495	2.67
-08	.625	.072-.092	1.07	-23	1.562	.872-.932	1.67	-38	3.250	2.560-2.620	2.75
-09	.688	.072-.092	1.11	-24	1.625	.935-.995	1.71	-39	3.375	2.685-2.745	2.83
-10	.750	.072-.120	1.15	-25	1.688	.998-1.058	1.75	-40	3.500	2.810-2.870	2.91
-11	.812	.122-.182	1.19	-26	1.750	1.060-1.120	1.79	-41	3.625	2.935-2.995	2.99
-12	.875	.185-.245	1.23	-27	1.875	1.185-1.245	1.87	-42	3.750	3.060-3.120	3.07
-13	.938	.248-.308	1.27	-28	2.000	1.310-1.370	1.95	-43	3.875	3.185-3.245	3.15
-14	1.000	.310-.370	1.31	-29	2.125	1.435-1.495	2.03	-44	1.812	1.122-1.182	1.83
-15	1.062	.372-.432	1.35	-30	2.250	1.560-1.620	2.11	-45	1.938	1.248-1.308	1.91
-16	1.125	.435-.495	1.39	-31	2.375	1.685-1.745	2.19				
-17	1.188	.498-.558	1.43	-32	2.500	1.810-1.870	2.27				

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PA	NAVY-AS	INTERNATIONAL INTEREST	TITLE
Other Cust	ARMY-AV		BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, .190-32 UNJF - 3A
	AIRFORCE-99		
	PROCUREMENT SPECIFICATION	SUPERSEDES	
	AMS-7477		

MILITARY STANDARD
MS9556

PAGE 1 OF 2

APPROVED: 16 DEC 65
REVISED (B) 22 MAY 86 (C) 6 NOV 86

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AMSC N/A

DD FORM 672-1 COORDINATED

5306-1151

REQUIREMENTS:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5731-85.
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 -12 AND SMALLER.
5. FLOURESCENT PENETRANT INSPECTION: FLOURESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645-83.
6. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI 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: MS9556-03

DASH NUMBER

BASIC MS NUMBER

MS9556-03 INDICATES: BOLT, MACHINE-DOUBLE HEXAGON EXTENDED WASHER
HEAD, .190-32 UNJF-3A, LENGTH .317.

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.

P. A. NAVY-AS Other Cust ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, .190-32 UNJF-3A	MILITARY STANDARD MS9556
PROCUREMENT SPECIFICATION AMS 7477	SUPERSEDES:	PAGE 2 OF 2	

USOR ACTIVITIES

RELEVANT ACTIVITIES

AIR FORCE-82
DLA-15

This 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 replacement use shall be made from this document.

APPROVED 16 DEC 65 REVISED (C) FOR CHANGES SEE PAGE(S) 1