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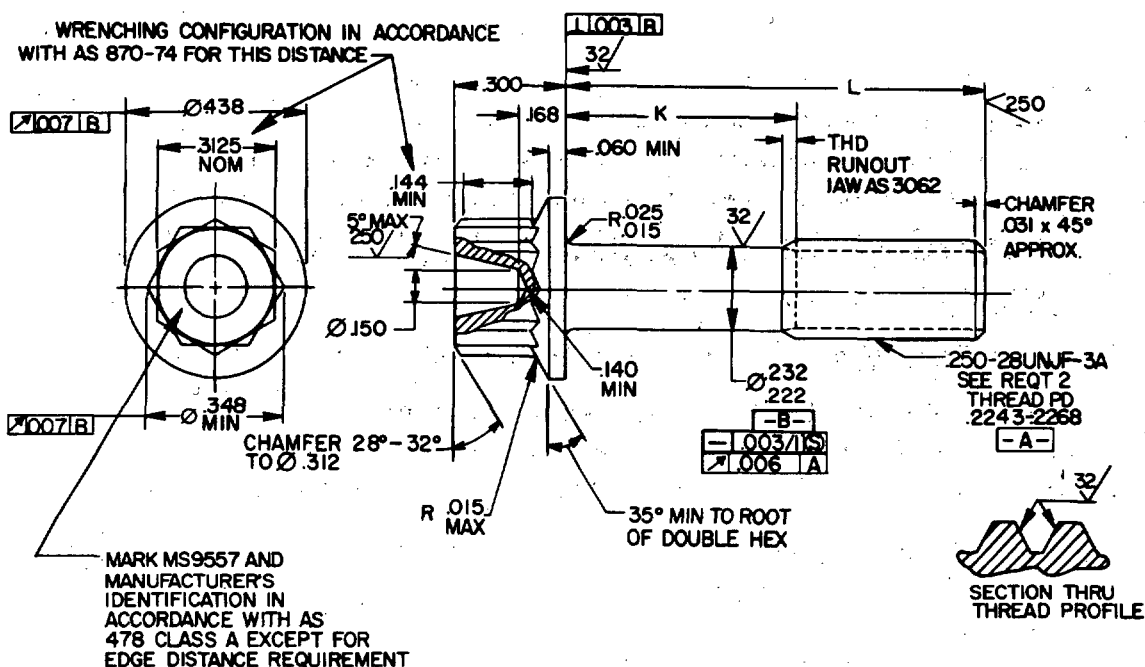


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	.375	.079-.099	1.14	-25	1.688	.878-.938	2.64	-46	4.250	3.440-3.500	5.56
-05	.438	.079-.099	1.21	-26	1.750	.940-1.000	2.72	-47	4.375	3.565-3.625	5.71
-06	.500	.079-.099	1.29	-27	1.875	1.065-1.125	2.86	-48	4.500	3.690-3.750	5.85
-07	.562	.079-.099	1.36	-28	2.000	1.190-1.250	3.00	-49	4.625	3.815-3.875	6.00
-08	.625	.079-.099	1.44	-29	2.125	1.315-1.375	3.14	-50	4.750	3.940-4.000	6.14
-09	.688	.079-.099	1.51	-30	2.250	1.440-1.500	3.29	-51	4.875	4.065-4.125	6.29
-10	.750	.079-.099	1.58	-31	2.375	1.565-1.625	3.43	-52	5.000	4.190-4.250	6.43
-11	.812	.079-.099	1.65	-32	2.500	1.690-1.750	3.57	-53	5.125	4.315-4.375	6.56
-12	.875	.079-.125	1.72	-33	2.625	1.815-1.875	3.71	-54	5.250	4.440-4.500	6.70
-13	.938	.128-.188	1.79	-34	2.750	1.940-2.000	3.85	-55	5.375	4.565-4.625	6.84
-14	1.000	.190-.250	1.86	-35	2.875	2.065-2.125	4.00	-56	5.500	4.690-4.750	6.99
-15	1.062	.252-.312	1.93	-36	3.000	2.190-2.250	4.14	-57	5.625	4.815-4.875	7.13
-16	1.125	.315-.375	2.00	-37	3.125	2.315-2.375	4.29	-58	5.750	4.940-5.000	7.28
-17	1.188	.378-.438	2.08	-38	3.250	2.440-2.500	4.43	-59	5.875	5.065-5.125	7.42
-18	1.250	.440-.500	2.15	-39	3.375	2.565-2.625	4.58	-60	6.000	5.190-5.250	7.57
-19	1.312	.502-.562	2.22	-40	3.500	2.690-2.750	4.72	-61	1.812	1.002-1.062	2.79
-20	1.375	.565-.625	2.29	-41	3.625	2.815-2.875	4.85	-62	1.938	1.128-1.188	2.93
-21	1.438	.628-.688	2.36	-42	3.750	2.940-3.000	4.99				
-22	1.500	.690-.750	2.43	-43	3.875	3.065-3.125	5.13				
-23	1.562	.752-.812	2.50	-44	4.000	3.190-3.250	5.27				
-24	1.625	.815-.875	2.57	-45	4.125	3.315-3.375	5.42				

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P.A.	NAVY-AS	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cust	ARMY-AV		BOLT, MACHINE-DOUBLE HEXAGON EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, 250-28 UNJF-3A	MS9557
	AIR FORCE-99			
PROCUREMENT SPECIFICATION	AMS-7477	SUPERSEDES:		PAGE 1 OF 2

FED. SUP CLASS
5306

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 -14 AND SMALLER.
5. FLOUORESCENT PENETRANT INSPECTION: FLOUORESCENT 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: MS9557-04

DASH NUMBER

BASIC MS NUMBER

MS9557-04 INDICATES: BOLT, MACHINE-DOUBLE HEXAGON EXTENDED WASHER
HEAD, .250-28 UNJF-3A, LENGTH .375.

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 Cast ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, .250-28 UNJF-3A	MILITARY STANDARD MS9557
PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES:		PAGE 2 OF 2