

TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NO	L	K	APPROX WEIGHT LB/100
-02	1.812	1.002-1.062	3.51
-03	1.938	1.128-1.188	3.68
-04	.375	.079-.099	1.54
-05	.438	.079-.099	1.62
-06	.500	.079-.099	1.71
-07	.562	.079-.099	1.79
-08	.625	.079-.099	1.88
-09	.688	.079-.099	1.97
-10	.750	.079-.099	2.05
-11	.812	.079-.099	2.14
-12	.875	.079-.125	2.22
-13	.938	.128-.188	2.31
-14	1.000	.190-.250	2.40
-15	1.062	.252-.312	2.48
-16	1.125	.315-.375	2.57
-17	1.188	.378-.438	2.65
-18	1.250	.440-.500	2.74
-19	1.312	.502-.562	2.82
-20	1.375	.565-.625	2.91
-21	1.438	.628-.688	3.00
-22	1.500	.690-.750	3.08
-23	1.562	.752-.812	3.17
-24	1.625	.815-.875	3.26
-25	1.688	.878-.938	3.34
-26	1.750	.940-1.000	3.43
-27	1.875	1.065-1.125	3.60
-28	2.000	1.190-1.250	3.77
-29	2.125	1.315-1.375	3.94
-30	2.250	1.440-1.500	4.11
-31	2.375	1.565-1.625	4.29
-32	2.500	1.690-1.750	4.46
-33	2.625	1.815-1.875	4.63
-34	2.750	1.940-2.000	4.80
-35	2.875	2.065-2.125	4.98
-36	3.000	2.190-2.250	5.15
-37	3.125	2.315-2.375	5.33
-38	3.250	2.440-2.500	5.49
-39	3.375	2.565-2.625	5.66
-40	3.500	2.690-2.750	5.84
-41	3.625	2.815-2.875	6.01
-42	3.750	2.940-3.000	6.18
-43	3.875	3.065-3.125	6.35
-44	4.000	3.190-3.250	6.52
-45	4.125	3.315-3.375	6.70
-46	4.250	3.440-3.500	6.87
-47	4.375	3.565-3.625	7.04
-48	4.500	3.690-3.750	7.21
-49	4.625	3.815-3.875	7.38
-50	4.750	3.940-4.000	7.56
-51	4.875	4.065-4.125	7.73
-52	5.000	4.190-4.250	7.90
-53	5.125	4.315-4.375	8.07
-54	5.250	4.440-4.500	8.24
-55	5.375	4.565-4.625	8.42
-56	5.500	4.690-4.750	8.59
-57	5.625	4.815-4.875	8.76
-58	5.750	4.940-5.000	8.90
-59	5.875	5.065-5.125	9.07
-60	6.000	5.190-5.250	9.24

ⓑ ENTIRE STANDARD REVISED

P.A. NAVY - AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE - HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .250-28 UNJF-3A	MILITARY STANDARD MS9584
AIR FORCE-99			
PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES.		PAGE 1 OF 2

APPROVED 5 MAY 1965 REVISED (B) 30 SEPT 87

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USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE - 82
ARMY - MI
DLA - IS

AMSC N/A

DD FORM 672-1 (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1179

REQUIREMENTS:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5731 (UNS S66286).
2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. FLUORESCENT PENETRANT INSPECTION: FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645.
4. SURFACE TEXTURE: SURFACE TEXTURE IN ACCORDANCE WITH ANSI B46.1. UNLESS OTHERWISE SPECIFIED, SURFACE TO BE 125 MICROINCHES EXCEPT UPSET BEAD.
5. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS478 CLASS A.
6. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
7. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
8. EDGES: BREAK SHARP EDGES .001-.015 UNLESS OTHERWISE SPECIFIED.
9. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9584-02

_____ DASH NUMBER
 _____ BASIC MS NUMBER

MS9584-02 INDICATES - BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK AMS 5731, .250-28 UNJF-3A x 1.812

NOTES:

1. ALL DIMENSIONS ARE 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 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.

USER ACTIVITIES:

REVIEWER ACTIVITIES:
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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 repetitive use shall be made from this document when applicable.

APPROVED 5 MAY 1965 REVISED (B) FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY - AS Other Code	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .250-28 UNJF-3A	MILITARY STANDARD MS9584
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