

USER ACTIVITIES:

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

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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.

AMSC N/A

12514

FED SUP CLASS
5306

TABLE 1. DASH NUMBERS AND DIMENSIONS

| DASH NO | L | K | APPROX WEIGHT LB/100 |
|---------|-------|-------------|----------------------|
| -04 | .500 | .088-.108 | 2.59 |
| -05 | .562 | .088-.108 | 2.73 |
| -06 | .625 | .088-.108 | 2.86 |
| -07 | .688 | .088-.108 | 3.00 |
| -08 | .750 | .088-.108 | 3.14 |
| -09 | .812 | .088-.108 | 3.27 |
| -10 | .875 | .088-.108 | 3.41 |
| -11 | .938 | .088-.108 | 3.54 |
| -12 | 1.000 | .088-.125 | 3.68 |
| -13 | 1.062 | .128-.188 | 3.81 |
| -14 | 1.125 | .190-.250 | 3.95 |
| -15 | 1.188 | .252-.312 | 4.08 |
| -16 | 1.250 | .315-.375 | 4.22 |
| -17 | 1.312 | .378-.438 | 4.35 |
| -18 | 1.375 | .440-.500 | 4.49 |
| -19 | 1.438 | .502-.562 | 4.62 |
| -20 | 1.500 | .565-.625 | 4.76 |
| -21 | 1.562 | .628-.688 | 4.89 |
| -22 | 1.625 | .690-.750 | 5.03 |
| -23 | 1.688 | .752-.812 | 5.17 |
| -24 | 1.750 | .812-.875 | 5.30 |
| -25 | 1.875 | .940-1.000 | 5.57 |
| -26 | 2.000 | 1.065-1.125 | 5.84 |
| -27 | 2.125 | 1.190-1.250 | 6.11 |
| -28 | 2.250 | 1.315-1.375 | 6.38 |
| -29 | 2.375 | 1.440-1.500 | 6.65 |
| -30 | 2.500 | 1.565-1.625 | 6.92 |
| -31 | 2.625 | 1.690-1.750 | 7.19 |
| -32 | 2.750 | 1.815-1.875 | 7.47 |
| -33 | 2.875 | 1.940-2.000 | 7.74 |
| -34 | 3.000 | 2.065-2.125 | 8.01 |
| -35 | 3.125 | 2.190-2.250 | 8.28 |
| -36 | 3.250 | 2.315-2.375 | 8.55 |
| -37 | 3.375 | 2.440-2.500 | 8.82 |
| -38 | 3.500 | 2.565-2.625 | 9.09 |
| -39 | 3.625 | 2.690-2.750 | 9.36 |
| -40 | 3.750 | 2.815-2.875 | 9.63 |
| -41 | 3.875 | 2.940-3.000 | 9.90 |
| -42 | 4.000 | 3.065-3.125 | 10.17 |
| -43 | 4.125 | 3.190-3.250 | 10.44 |
| -44 | 4.250 | 3.315-3.375 | 10.71 |
| -45 | 4.375 | 3.440-3.500 | 10.98 |
| -46 | 4.500 | 3.565-3.625 | 11.25 |
| -47 | 4.625 | 3.690-3.750 | 11.52 |
| -48 | 4.750 | 3.815-3.875 | 11.80 |
| -49 | 4.875 | 3.940-4.000 | 12.07 |
| -50 | 5.000 | 4.065-4.125 | 12.34 |
| -51 | 5.125 | 4.190-4.250 | 12.61 |
| -52 | 5.250 | 4.315-4.375 | 12.88 |
| -53 | 5.375 | 4.440-4.500 | 13.15 |
| -54 | 5.500 | 4.565-4.625 | 13.42 |
| -55 | 5.625 | 4.690-4.750 | 13.69 |
| -56 | 5.750 | 4.815-4.875 | 13.96 |
| -57 | 5.875 | 4.940-5.000 | 14.22 |
| -58 | 6.000 | 5.065-5.125 | 14.50 |
| -59 | 1.812 | .878-.938 | 5.44 |
| -60 | 1.938 | 1.002-1.062 | 5.71 |

(B) ENTIRE STANDARD REVISED

P.A. NAVY-AS
Other Cust
AIR FORCE-99

INTERNATIONAL INTEREST

TITLE
BOLT, MACHINE HEXAGON HEAD, DRILLED,
6 HOLES, FULL SHANK, .3125-24 UNJF-3A

MILITARY STANDARD
MS9585

PROCUREMENT SPECIFICATION
AMS7477

SUPERSEDES:

PAGE 1 OF 2

DD FORM 1 MAY 72 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1180

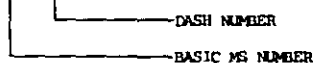
APPROVED 5 MAY 1965 REVISED (B) 30 SEPT 87

FED. SUP CLASS
5306

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 HEAD.
5. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478 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 .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 I.

EXAMPLE: MS9585-04



MS9585-04 INDICATES - BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK AMS 5731, .3125-24 UNJF-3A x .500 LONG

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:

AIR FORCE-82

ARMY-MI

DLA-IS

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 Cust AIR FORCE-99 | INTERNATIONAL INTEREST | TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .3125-24 UNJF-3A | MILITARY STANDARD MS9585 |
| PROCUREMENT SPECIFICATION AMS7477 | SUPERSEDES. | PAGE 2 OF 2 | |