

TABLE 1. DASH NUMBERS AND DIMENSIONS

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

(B) ENTIRE STANDARD REVISED

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

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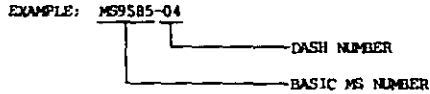
AMSC N/A

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|---|------------------------|---|-----------------------------|
| 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 | |

APPROVED 5 MAY 1965 REVISED (B) 30 SEPT 87

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.



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 - B2
ARMY - M1
DLA - IS

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

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|--|---------------------------|--|-------------------|
| P.A. NAVY - AS <i>Other Cust</i> AIR FORCE-99 | INTERNATIONAL INTEREST | TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .3125-24 UNJF-3A | MILITARY STANDARD |
| | | | MS9585 |
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