

USER ACTIVITIES:

REVIEWER ACTIVITIES:

AIR FORCE-82

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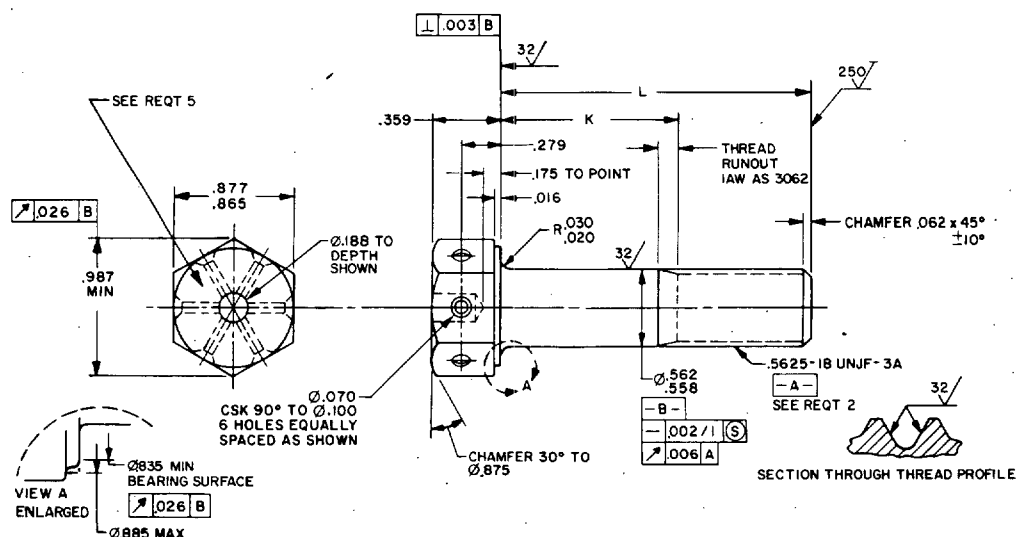


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO	L	K	APPROX WEIGHT LB/100	DASH NO	L	K	APPROX WEIGHT LB/100
-04	.875	.113-.133	12.08	-29	3.000	1.565-1.625	27.05
-05	.938	.113-.133	12.52	-30	3.125	1.690-1.750	27.93
-06	1.000	.113-.133	12.96	-31	3.250	1.815-1.875	28.81
-07	1.062	.113-.133	13.40	-32	3.375	1.940-2.000	29.69
-08	1.125	.113-.133	13.81	-33	3.500	2.065-2.125	30.57
-09	1.188	.113-.133	14.28	-34	3.625	2.190-2.250	31.45
-10	1.250	.113-.133	14.72	-35	3.750	2.315-2.375	32.34
-11	1.312	.113-.133	15.16	-36	3.875	2.440-2.500	33.22
-12	1.375	.113-.133	15.61	-37	4.000	2.565-2.625	34.10
-13	1.438	.113-.133	16.05	-38	4.125	2.690-2.750	34.98
-14	1.500	.113-.133	16.49	-39	4.250	2.815-2.875	35.86
-15	1.562	.128-.188	16.93	-40	4.375	2.940-3.000	36.74
-16	1.625	.190-.250	17.27	-41	4.500	3.065-3.125	37.62
-17	1.688	.252-.312	17.81	-42	4.625	3.190-3.250	38.50
-18	1.750	.315-.375	18.25	-43	4.750	3.315-3.375	39.38
-19	1.812	.378-.438	18.69	-44	4.875	3.440-3.500	40.26
-20	1.875	.440-.500	19.13	-45	5.000	3.565-3.625	41.14
-21	2.000	.565-.625	20.01	-46	5.125	3.690-3.750	42.02
-22	2.125	.690-.750	20.89	-47	5.250	3.815-3.875	42.90
-23	2.250	.815-.875	21.77	-48	5.375	3.940-4.000	43.78
-24	2.375	.940-1.000	22.65	-49	5.500	4.065-4.125	44.66
-25	2.500	1.065-1.125	23.53	-50	5.625	4.190-4.250	45.54
-26	2.625	1.190-1.250	24.41	-51	5.750	4.315-4.375	46.42
-27	2.750	1.315-1.375	25.29	-52	5.875	4.440-4.500	47.30
-28	2.875	1.440-1.500	26.17	-53	6.000	4.565-4.625	48.18
				-54	1.938	.502-.562	19.57

④ ENTIRE STANDARD REVISED

P.A. NAVY - AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .5625-18 UNJF-3A	MILITARY STANDARD	
AIR FORCE-99			MS9589	
PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES:		PAGE 1	OF 2

AMSC N/A

DD FORM 672-1 (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

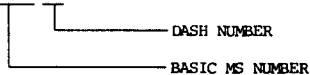
5306-1184

APPROVED 5 MAY 1965 REVISED (D) 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.

EXAMPLE: MS9589-04



MS9589-04 INDICATES - BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK AMS 5731, .5625-18 UNJF-3A x .875 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.

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