

TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NO	L	K	APPROX WEIGHT LB/100	DASH NO	L	K	APPROX WEIGHT LB/100
-03	.938	.118-.138	15.95	-28	3.125	1.565-1.625	34.96
-04	1.000	.118-.138	16.49	-29	3.250	1.690-1.750	36.04
-05	1.062	.118-.138	17.03	-30	3.375	1.815-1.875	37.13
-06	1.125	.118-.138	17.57	-31	3.500	1.940-2.000	38.22
-07	1.188	.118-.138	18.12	-32	3.625	2.065-2.125	39.30
-08	1.250	.118-.138	18.66	-33	3.750	2.190-2.250	40.39
-09	1.312	.118-.138	19.20	-34	3.875	2.315-2.375	41.48
-10	1.375	.118-.138	19.75	-35	4.000	2.440-2.500	42.56
-11	1.438	.118-.138	20.29	-36	4.125	2.565-2.625	43.65
-12	1.500	.118-.138	20.93	-37	4.250	2.690-2.750	44.73
-13	1.562	.118-.138	21.37	-38	4.375	2.815-2.875	45.82
-14	1.625	.118-.138	21.92	-39	4.500	2.940-3.000	46.91
-15	1.688	.128-.188	22.47	-40	4.625	3.065-3.125	47.99
-16	1.750	.190-.250	23.01	-41	4.750	3.190-3.250	49.08
-17	1.812	.252-.312	23.55	-42	4.875	3.315-3.375	50.17
-18	1.875	.315-.375	24.09	-43	5.000	3.440-3.500	51.25
-19	2.000	.440-.500	25.16	-44	5.125	3.565-3.625	52.34
-20	2.125	.565-.625	26.26	-45	5.250	3.690-3.750	53.43
-21	2.250	.690-.750	27.35	-46	5.375	3.815-3.875	54.51
-22	2.375	.815-.875	28.44	-47	5.500	3.940-4.000	55.60
-23	2.500	.940-1.000	29.52	-48	5.625	4.065-4.125	56.69
-24	2.625	1.065-1.125	30.61	-49	5.750	4.190-4.250	57.77
-25	2.750	1.190-1.250	31.70	-50	5.875	4.315-4.375	58.86
-26	2.875	1.315-1.375	32.78	-51	6.000	4.440-4.500	59.95
-27	3.000	1.440-1.500	33.87	-52	1.938	.378-.438	24.62

④ ENTIRE STANDARD REVISED

PA	INTERNATIONAL	TITLE
NAVY - AS	INTEREST	BOLT, MACHINE-HEXAGON HEAD, DRILLED,
Other Cust		6 HOLES, FULL SHANK, 625-18 UNJF-3A
AIR FORCE-99		
PROCUREMENT SPECIFICATION	SUPERSEDES	
AMS7477		

**MILITARY STANDARD**  
**MS9590**

PAGE 1 OF 2

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**AIR FORCE - 82**  
**ARMY - MI**  
**DLA - 15**

## USER ACTIVITIES

APPROVED 5 MAY 1965 REVISED 30 SEPT 87

APPROVED  
5 MAY 1965

AMSC N/A

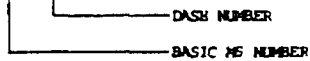
DD FORM 672-1 (COORDINATED)

**5306-1185**

## 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 AMS 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 AMS Y14.5M.
7. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 2^\circ$ .
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 1.

EXAMPLE: MS9590-03



MS9590-03 INDICATES - BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK AMS 5731, .625-18 UNJF-3A x .938 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  
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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 ① FOR CHANGES SEE PAGES 1 AND 2

PA NAVY - AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .625-18 UNJF-3A	MILITARY STANDARD MS9590
AIR FORCE-99	PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES	PAGE 2 OF 2