



TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO	L	K	APPROX WEIGHT LB/100
-06	1.250	.129-.149	27.12
-07	1.312	.129-.149	27.76
-08	1.375	.129-.149	28.55
-09	1.438	.129-.149	29.33
-10	1.500	.129-.149	30.11
-11	1.562	.129-.149	30.89
-12	1.625	.129-.149	31.68
-13	1.688	.129-.149	32.46
-14	1.750	.129-.149	33.24
-15	1.812	.129-.149	34.03
-16	1.875	.129-.149	34.81
-17	1.938	.129-.188	35.59
-18	2.000	.190-.250	36.37
-19	2.125	.315-.375	37.94
-20	2.250	.440-.500	39.50
-21	2.375	.565-.625	41.17
-22	2.500	.690-.750	42.63
-23	2.625	.815-.875	44.20
-24	2.750	.940-1.000	45.86
-25	2.875	1.065-1.125	47.33
-26	3.000	1.190-1.250	48.89
-27	3.125	1.315-1.375	50.57
-28	3.250	1.440-1.500	52.02
-29	3.375	1.565-1.625	53.58
-30	3.500	1.690-1.750	55.15

DASH NO	L	K	APPROX WEIGHT LB/100
-31	3.625	1.815-1.875	56.71
-32	3.750	1.940-2.000	58.28
-33	3.875	2.065-2.125	59.84
-34	4.000	2.190-2.250	61.41
-35	4.125	2.315-2.375	62.97
-36	4.250	2.440-2.500	64.54
-37	4.375	2.565-2.625	66.10
-38	4.500	2.690-2.750	67.67
-39	4.625	2.815-2.875	69.23
-40	4.750	2.940-3.000	70.80
-41	4.875	3.065-3.125	72.36
-42	5.000	3.190-3.250	73.93
-43	5.125	3.315-3.375	75.49
-44	5.250	3.440-3.500	77.06
-45	5.375	3.565-3.625	78.62
-46	5.500	3.690-3.750	80.19
-47	5.625	3.815-3.875	81.75
-48	5.750	3.940-4.000	83.31
-49	5.875	4.065-4.125	84.88
-50	6.000	4.190-4.250	86.44

⑧ ENTIRE STANDARD REVISED

P.A. NAVY - AS Other Cust	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, 750-16 UNJF-3A	MILITARY STANDARD
AIR FORCE-99			MS9591
PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES:		PAGE 1 OF 2

APPROVED 5 MAY 1965 REVISED (B) 30 SEPT 87

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AMSC N/A

DD FORM 672-1 (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-1186

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 1.

EXAMPLE: MS9591-06

DASH NUMBER

BASIC MS NUMBER

MS9591-06 INDICATES - BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK AMS 5731, .750-16 UNJF-3A x 1.250 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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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, .750-16 UNJF-3A	MILITARY STANDARD MS9591
PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES:	PAGE 2 OF 2	