

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE-82
DLA-1S

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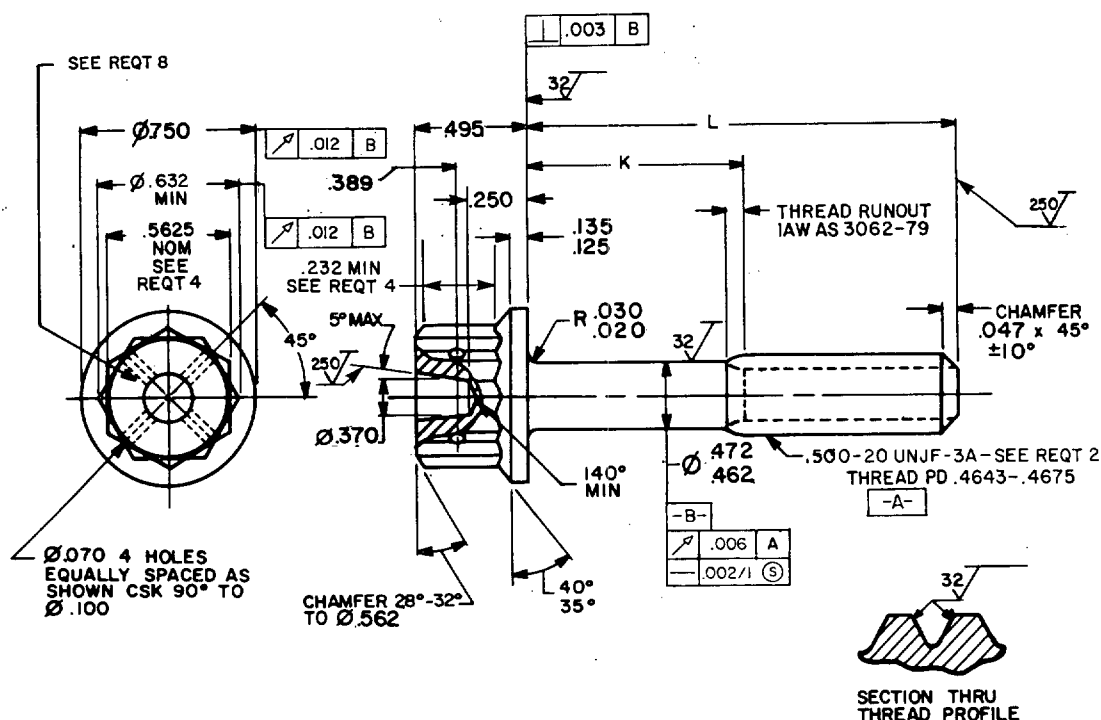


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-04	.812	.105-.125	7.88
-05	.875	.105-.125	8.20
-06	.938	.105-.125	8.52
-07	1.000	.105-.125	8.84
-08	1.062	.105-.125	9.15
-09	1.125	.105-.125	9.47
-10	1.188	.105-.125	9.79
-11	1.250	.105-.125	10.10
-12	1.312	.105-.125	10.42
-13	1.375	.105-.125	10.74
-14	1.438	.128-.188	11.06
-15	1.500	.190-.250	11.37
-16	1.562	.252-.312	11.69
-17	1.625	.315-.375	12.01
-18	1.688	.378-.438	12.32
-19	1.750	.440-.500	12.64
-20	1.812	.502-.562	12.95
-21	1.875	.565-.625	13.27

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-22	2.000	.690-.750	13.91
-23	2.125	.815-.875	14.54
-24	2.250	.940-1.000	15.17
-25	2.375	1.065-1.125	15.81
-26	2.500	1.190-1.250	16.44
-27	2.625	1.315-1.375	17.08
-28	2.750	1.440-1.500	17.71
-29	2.875	1.565-1.625	18.34
-30	3.000	1.690-1.750	18.98
-31	3.125	1.815-1.875	19.61
-32	3.250	1.940-2.000	20.24
-33	3.375	2.065-2.125	20.88
-34	3.500	2.190-2.250	21.51
-35	3.625	2.315-2.375	22.15
-36	3.750	2.440-2.500	22.78
-37	3.875	2.565-2.625	23.41
-38	4.000	2.690-2.750	24.05
-39	4.125	2.815-2.875	24.68

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-40	4.250	2.940-3.000	25.31
-41	4.375	3.065-3.125	25.95
-42	4.500	3.190-3.250	26.58
-43	4.625	3.315-3.375	27.22
-44	4.750	3.440-3.500	27.85
-45	4.875	3.565-3.625	28.48
-46	5.000	3.690-3.750	29.12
-47	5.125	3.815-3.875	29.75
-48	5.250	3.940-4.000	30.38
-49	5.375	4.065-4.125	31.02
-50	5.500	4.190-4.250	31.65
-51	5.625	4.315-4.375	32.29
-52	5.750	4.440-4.500	32.92
-53	5.875	4.565-4.625	33.55
-54	6.000	4.690-4.750	34.19

Ⓐ ENTIRE STANDARD REVISED

P. A. NAVY-AS Other Cust ARMY- AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD,DRILLED, CORROSION AND HEAT RESISTANT STEEL. .500-20 UNJF-3A	MILITARY STANDARD
			MS9710
PROCUREMENT SPECIFICATION AMS 7471	SUPERSEDES:		PAGE 1 OF 2

AMSC N/A **DD FORM 672-1** (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

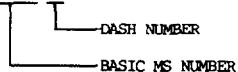
5306-0944
E25-187-2

APPROVED 27 AUG 71 REVISED (A) 24 FEB 86

FED. SUP CLASS
5 3 0 6**REQUIREMENTS:**

1. **MATERIAL:** CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5708.
2. **THREADS:** THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
4. **WRENCHING CONFIGURATION:** WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
5. **SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI B46.1.
6. **FLUORESCENT PENETRANT INSPECTION:** FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645-83.
7. **HEAD TO SHANK FILLET:** HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS EXCEPT DASH NUMBER SIZES -15 AND SMALLER.
8. **MARKING:** MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478-79, CLASS A.
9. **TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
10. **EDGES:** BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9710-04



MS9710-04 INDICATES: BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED,
.500-20 UNJF-3A, LENGTH .812

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 NONGOVERNMENT) 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
DLA - 15

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APPROVED 27 AUG 71 REVISED ① FOR CHANGES SEE PAGE 1 AND 2

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