

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE -82
DLA-IS

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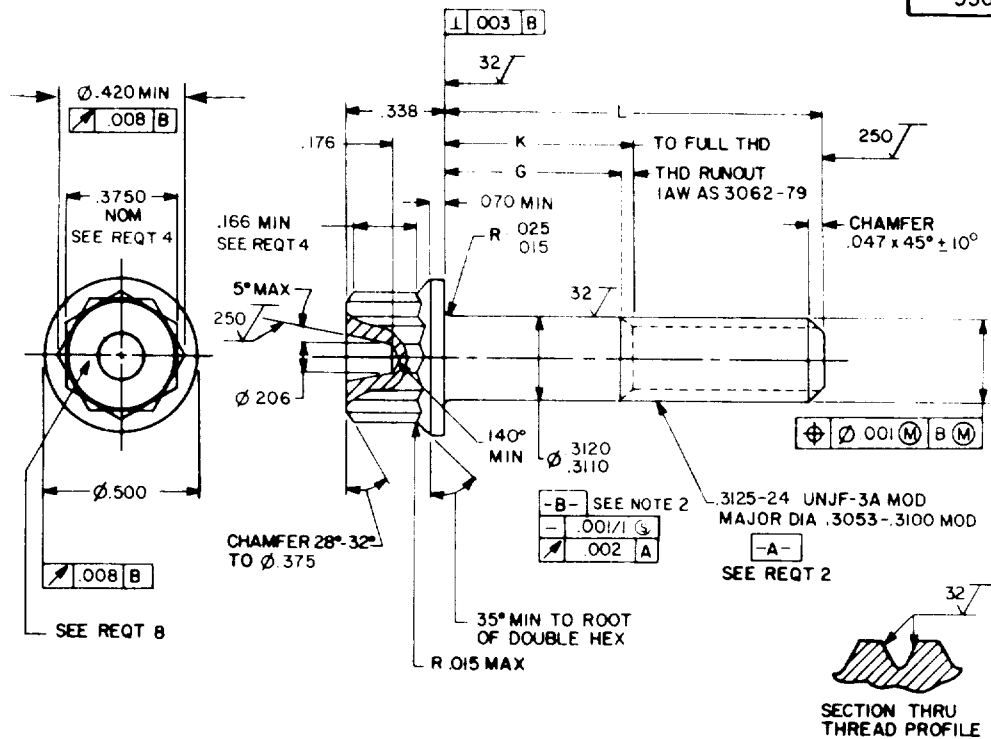


TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-03	.751	.105	.198	2.69	-31	2.501	1.855	1.948	6.64
-04	.813	.167	.260	2.83	-32	2.563	1.917	2.010	6.78
-05	.875	.229	.322	2.97	-33	2.625	1.979	2.072	6.92
-06	.938	.292	.385	3.11	-34	2.688	2.042	2.135	7.06
-07	1.001	.355	.448	3.25	-35	2.751	2.105	2.198	7.20
-08	1.063	.417	.510	3.40	-36	2.813	2.167	2.260	7.34
-09	1.125	.479	.572	3.53	-37	2.875	2.229	2.322	7.48
-10	1.188	.542	.635	3.68	-38	2.938	2.292	2.385	7.62
-11	1.251	.605	.698	3.82	-39	3.001	2.355	2.448	7.76
-12	1.313	.667	.760	3.96	-40	3.063	2.417	2.510	7.91
-13	1.375	.729	.822	4.10	-41	3.125	2.479	2.572	8.04
-14	1.438	.792	.885	4.24	-42	3.188	2.542	2.635	8.19
-15	1.501	.855	.948	4.38	-43	3.251	2.605	2.698	8.33
-16	1.563	.917	1.010	4.52	-44	3.313	2.667	2.760	8.47
-17	1.625	.979	1.072	4.66	-45	3.375	2.729	2.822	8.61
-18	1.688	1.042	1.135	4.80	-46	3.438	2.792	2.885	8.75
-19	1.751	1.105	1.198	4.95	-47	3.501	2.855	2.948	8.89
-20	1.813	1.167	1.260	5.08	-48	3.563	2.917	3.010	9.03
-21	1.875	1.229	1.322	5.22	-49	3.625	2.979	3.072	9.17
-22	1.938	1.292	1.385	5.37	-50	3.688	3.042	3.135	9.32
-23	2.001	1.355	1.448	5.51	-51	3.751	3.105	3.198	9.46
-24	2.063	1.417	1.510	5.65	-52	3.813	3.167	3.260	9.60
-25	2.125	1.479	1.572	5.79	-53	3.875	3.229	3.322	9.74
-26	2.188	1.542	1.635	5.93	-54	3.938	3.292	3.385	9.88
-27	2.251	1.605	1.698	6.07	-55	4.001	3.355	3.448	10.02
-28	2.313	1.667	1.760	6.21	-56	4.063	3.417	3.510	10.16
-29	2.375	1.729	1.822	6.35	-57	4.125	3.479	3.572	10.30
-30	2.438	1.792	1.885	6.49	-58	4.188	3.542	3.635	10.44

©ENTIRE STANDARD REVISED

P. A. NAVY-AS Other Cost ARMY-AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE - DOUBLE HEXAGON, EXTENDED WASHER HEAD, CLOSE TOLERANCE SHANK, CORROSION AND HEAT RESISTANT STEEL, .3125-24 UNJF-3A	MILITARY STANDARD MS9725
PROCUREMENT SPECIFICATION AMS 7471	SUPERSEDES:		PAGE 1 OF 2

FED SUP CLASS
5306

TABLE 1. DASH NUMBERS AND DIMENSIONS - (CONTINUED)

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-59	4.251	3.605	3.698	10.58	-71	5.001	4.355	4.448	12.28
-60	4.313	3.667	3.760	10.72	-72	5.063	4.417	4.510	12.42
-61	4.375	3.729	3.822	10.86	-73	5.125	4.479	4.572	12.56
-62	4.438	3.792	3.885	11.00	-74	5.188	4.542	4.635	12.70
-63	4.501	3.855	3.948	11.15	-75	5.251	4.605	4.698	12.84
-64	4.563	3.917	4.010	11.29	-76	5.313	4.667	4.760	12.98
-65	4.625	3.979	4.072	11.43	-77	5.375	4.729	4.822	13.12
-66	4.688	4.042	4.135	11.57	-78	5.438	4.792	4.885	13.26
-67	4.751	4.105	4.198	11.71	-79	5.501	4.855	4.948	13.40
-68	4.813	4.167	4.260	11.85	-80	5.563	4.917	5.010	13.54
-69	4.875	4.229	4.322	11.99	-81	5.625	4.979	5.072	13.68
-70	4.938	4.292	4.385	12.13	-82	5.688	5.042	5.135	13.83

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. FLOUORESCENT PENETRANT INSPECTION: FLOUORESCENT 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 THAT DISTORTIONS AT A IN FIGURE 2 OF THE PROCUREMENT SPECIFICATION SHALL NOT BE PERMITTED ON THE HEAD BEARING AREA AND SHALL BE PERMITTED ON THE SHANK DIAMETER ONLY IF THE DISTORTION DOES NOT CAUSE THE SHANK DIAMETER TO EXCEED .3125 DIAMETER EXCEPT DASH NUMBER SIZES -08 AND SMALLER.
8. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478-79, CLASS A.
9. TOLERANCES: 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 1.

EXAMPLE: MS9725-03

└── DASH NUMBER
└── BASIC MS NUMBER

MS9725-03 INDICATES: BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, CLOSE TOLERANCE SHANK, .3125-24 UNJF-3A, LENGTH .751

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. FOR PART NUMBERS -03 THRU -08 THE THREAD PD SHALL REPLACE DATUM B.
3. DO NOT USE UNASSIGNED PART NUMBERS.
4. 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.
5. 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.
6. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
7. AS AND AMS ARE SAE PUBLICATIONS.

P. A. NAVY-AS Other Cust ARMY - AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CLOSE TOLER- ANCE SHANK, CORROSION AND HEAT RESISTANT STEEL, .3125-24 UNJF-3A	MILITARY STANDARD MS9725
PROCUREMENT SPECIFICATION AMS 7471	SUPERSEDES:	PAGE 2	OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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