

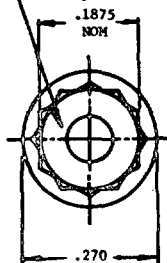
MS9912 (ASG)

FED. SUP CLASS

5305

MAKE MS9912
AND MANUFACTURER'S IDENT
PER AS 478 CLASS A

WRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE



5° MAX
.076
MAX DIA
HOLE
OPTIONAL
.015R
MAX

CHAMFER
28°-32°
TO .188 DIA

.101
MIN

.205

.030
MIN

.068
MIN

.020
MIN

.010
MIN

MAXIMUM 2
INCOMPLETE
THREADS
(SEE NOTE 4)

CHAMFER
.025 x 45°
APPROX

THIS SURFACE MUST BE
SQUARE WITH CHAMFER
WITHIN .003 FIR.

140°
MIN

.127 DIA
.117 DIA

35° MIN TO ROOT OF
DOUBLE HEXAGON

.138-40 UNJF-3A
BIL-S-0879



SECTION THRU
THREAD PROFILE

PART NO.	L	K	APPROX WEIGHT LB/100
MS9912-02	.250	.058-.078	.283
MS9912-03	.312	.058-.078	.304
MS9912-04	.375	.058-.078	.325
MS9912-05	.438	.058-.078	.346
MS9912-06	.500	.058-.078	.367
MS9912-07	.562	.058-.078	.387
MS9912-08	.625	.058-.099	.408
MS9912-09	.688	.102-.162	.429
MS9912-10	.750	.164-.224	.449
MS9912-11	.812	.226-.286	.478
MS9912-12	.875	.289-.349	.490
MS9912-13	.938	.352-.412	.511
MS9912-14	1.000	.414-.474	.532
MS9912-15	1.062	.476-.536	.552

PART NO.	L	K	APPROX WEIGHT LB/100
MS9912-16	1.125	.539-.599	.573
MS9912-17	1.188	.602-.662	.601
MS9912-18	1.250	.664-.724	.615
MS9912-19	1.312	.726-.786	.635
MS9912-20	1.375	.789-.849	.656
MS9912-21	1.438	.852-.912	.677
MS9912-22	1.500	.914-.974	.697
MS9912-23	1.562	.976-1.036	.717
MS9912-24	1.625	1.039-1.099	.737
MS9912-25	1.688	1.102-1.162	.758
MS9912-26	1.750	1.164-1.224	.778
MS9912-27	1.812	1.226-1.286	.799
MS9912-28	1.875	1.289-1.349	.820
MS9912-29	1.938	1.352-1.412	.840
MS9912-30	2.000	1.414-1.474	.861

Review activities:
USAF - 02, 85

This military standard is approved by the Department of the Air Force and the Department of the Navy. It is mandatory for use by these activities. All other military activities are required to employ this standard through outboard.

1. SHANK SHALL BE STRAIGHT WITHIN .003 PER INCH OF SCREW LENGTH.
2. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
3. THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .004 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: STEEL AMS 6322.
6. HARDNESS: ROCKWELL C26-32.
7. FINISH: CADMIUM PLATE AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
8. MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE UPSET.
9. HEAD TO SHANK FILLET SHALL BE COLD WORKED.
10. MAGNETIC PARTICLE INSPECTION PER AMS 2640 AFTER PLATING.
11. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
12. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
13. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
14. DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

P.A. USAF - 11	TITLE SCREW, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, PD SHANK, STEEL AMS 6322, CADMIUM PLATED, .138-40 UNJF-3A	MILITARY STANDARD MS9912 (ASG)
Other Govt Navy - AS		
APPROVED SPECIFICATION NO.	SUPPLEMENTAL	DATE 1 67 1

DD FORM 672-1 (limited circulation)
AS use only

PROCESSED BY THE AIR FORCE AND NAVY

U.S. GOVERNMENT PRINTING OFFICE: 1969-393-065/S1749

REVISION
15 Aug 69
APPROVED