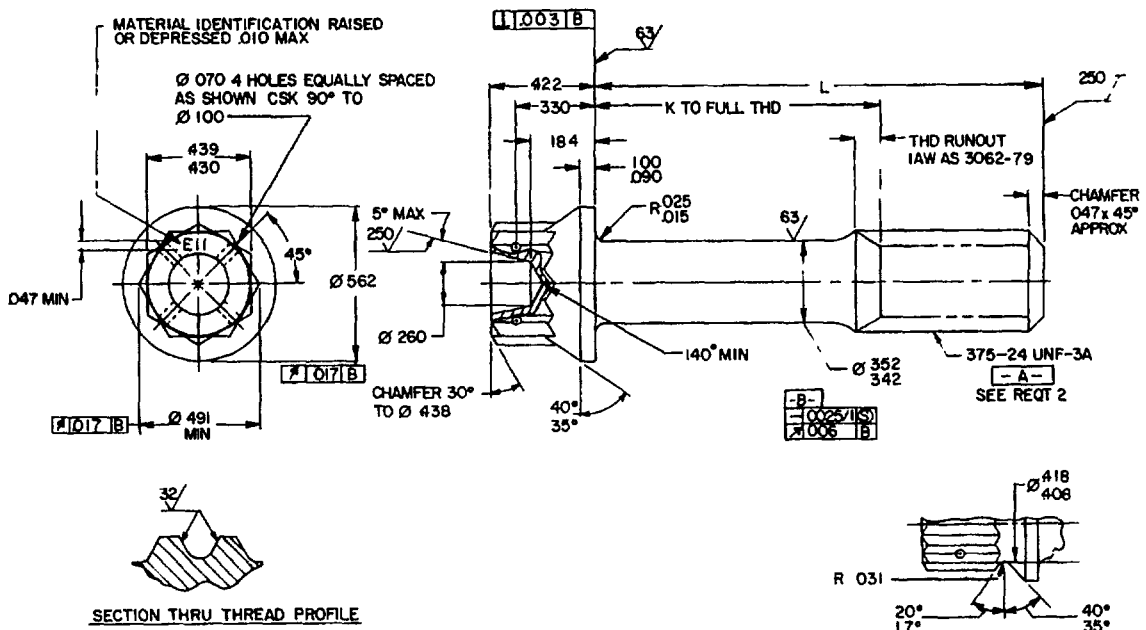


USER ACTIVITIES



REVISER ACTIVITIES:
ARMY - MI
DLA - IS

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100	DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100	DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100
-06	.750	1/	3.74	-23	1.875	.875	6.77	-40	4.000	3.000	12.47
-07	.812	1/	3.90	-24	2.000	1.000	7.11	-41	4.125	3.125	12.80
-08	.875	1/	4.07	-25	2.125	1.125	7.44	-42	4.250	3.250	13.13
-09	.938	1/	4.24	-26	2.250	1.250	7.78	-43	4.375	3.375	13.46
-10	1.000	1/	4.41	-27	2.375	1.375	8.11	-44	4.500	3.500	13.89
-11	1.062	1/	4.58	-28	2.500	1.500	8.44	-45	4.625	3.625	14.23
-12	1.125	.125	4.75	-29	2.625	1.625	8.78	-46	4.750	3.750	14.56
-13	1.188	.188	4.91	-30	2.750	1.750	9.12	-47	4.875	3.875	14.89
-14	1.250	.250	5.08	-31	2.875	1.875	9.46	-48	5.000	4.000	15.23
-15	1.312	.312	5.25	-32	3.000	2.000	9.80	-49	5.125	4.125	15.57
-16	1.375	.375	5.43	-33	3.125	2.125	10.13	-50	5.250	4.250	15.90
-17	1.438	.438	5.60	-34	3.250	2.250	10.47	-51	5.375	4.375	16.23
-18	1.500	.500	5.76	-35	3.375	2.375	10.80	-52	5.500	4.500	16.56
-19	1.562	.562	5.93	-36	3.500	2.500	11.14	-53	5.625	4.625	16.89
-20	1.625	.625	6.10	-37	3.625	2.625	11.47	-54	5.750	4.750	17.23
-21	1.688	.688	6.27	-38	3.750	2.750	11.80	-55	5.875	4.875	17.57
-22	1.750	.750	6.44	-39	3.875	2.875	12.14	-56	6.000	5.000	17.91

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

INACTIVE FOR DESIGN AFTER
28 FEB 84
FOR PARTS WITH MIL-S-8879
SCREW THREADS SEE MS9926

© DENOTES CHANGES

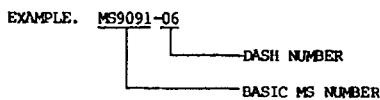
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P A NAVY - AS Other Code AIR FORCE - II	INTERNATIONAL INTEREST	TITLE © BOLT-MACHINE, DRILLED 12 POINT HEAD, STEEL, .375-24 UNF-3A	MILITARY STANDARD
			MS 9091
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 1 OF 2	DD FORM 1 MAY 73 672-1 (COORDINATED)

APPROVED 25 APR 57 REVISED (B) 25 SEP 86 (C) 12 JUN 87

REQUIREMENTS -

- 1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6322-80
- 2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-7742 INCOMPLETE THREADS NOT TO ENTER FILLET.
- 3. FINISH: CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80 DIMENSIONS SPECIFIED ARE AFTER PLATING.
- 4. HARDNESS: 26-32 HRC.
- 5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14 5M
- 6. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS870-74
- 7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES, EXCEPT UPSET HEAD, IN ACCORDANCE WITH ANSI B46.1.
- 8. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83.
- 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



MS9091-06 INDICATES BOLT, MACHINE, STEEL DRILLED 12 POINT HEAD;
375-24 UNF-3A, LENGTH 750

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.
- 7. SUBJECT TERM (KEY WORD) LISTING

BOLT, MACHINE, STEEL DRILLED 12 POINT HEAD, CADMIUM PLATE

USER ACTIVITIES

REVIEWER ACTIVITIES
ARMY-MI
DLA-IS

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.

APPROVED 25 APR 57 REVISED © FOR CHANGES SEE PAGES 1 AND 2

P A NAVY-AS Other Cust AIR FORCE-II	INTERNATIONAL INTEREST	TITLE © BOLT-MACHINE, DRILLED 12 POINT HEAD, STEEL, .375-24 UNF-3A	MILITARY STANDARD
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PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2 OF 2	