

INCH-POUND

MS9438B
 27 OCTOBER 1985
 SUPERSEDING
 MS9438A
 13 DECEMBER 1972

MILITARY SPECIFICATION SHEET

SCREW, MACHINE-STEEL, AMS 6304, DIFFUSED
 NICKEL-CADMIUM PLATED HEXAGO HEAD,
 DRILLED, .138-40 UNJF-3A

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS
 AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST
 OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING DOCUMENT
 LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS
 AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION. (SEE REQ. 13)

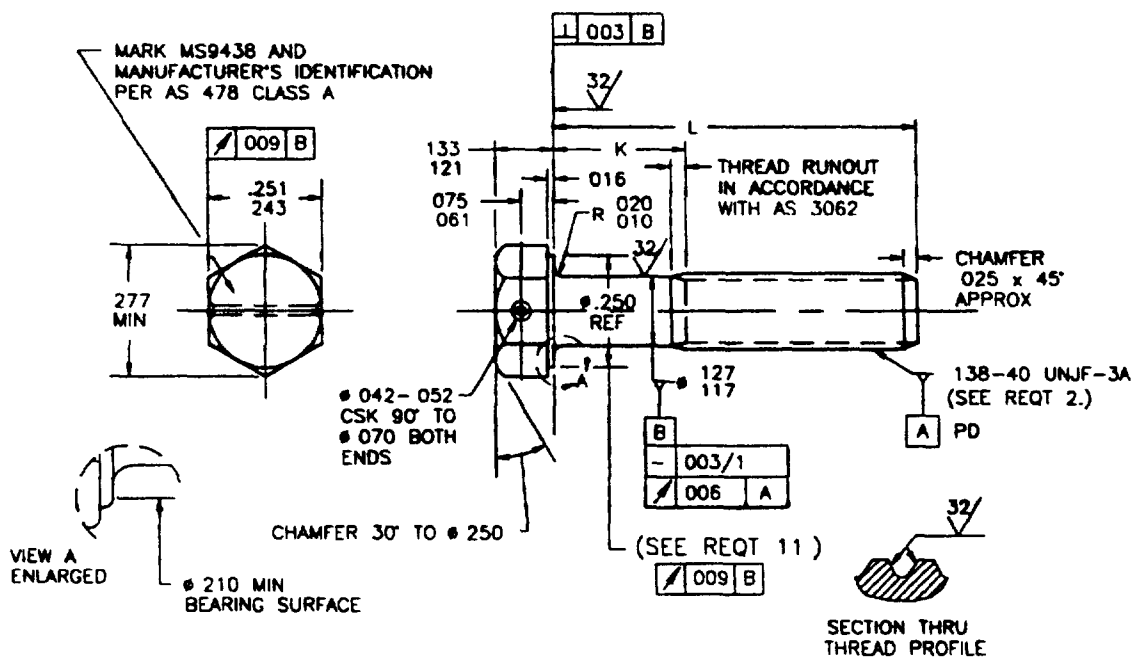


TABLE I DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-02	.250	.058-.078	.26	-13	.938	.352-.412	.50
-03	.312	.058-.078	.28	-14	1.000	.414-.474	.53
-04	.375	.058-.078	.31	-15	1.062	.476-.536	.55
-05	.438	.058-.078	.33	-16	1.125	.539-.599	.57
-06	.500	.058-.078	.35	-17	1.188	.602-.662	.59
-07	.562	.058-.078	.37	-18	1.250	.664-.724	.62
-08	.625	.058-.099	.39	-19	1.312	.726-.786	.64
-09	.688	.102-.162	.42	-20	1.375	.789-.849	.66
-10	.750	.164-.224	.44	-21	1.438	.852-.912	.68
-11	.812	.226-.286	.46	-22	1.500	.914-.974	.70
-12	.875	.289-.349	.48				

(B) ENTIRE DOCUMENT REVISED

REQUIREMENTS

- 1 MATERIAL STEEL IN ACCORDANCE WITH AMS 6304
- 2 THREADS THREADS IN ACCORDANCE WITH MIL-S-8879
- 3 DIMENSIONING AND TOLERANCING DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ASME Y14.5M
- 4 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
- 5 MAGNETIC PARTICLE INSPECTION MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640
- 6 HARDNESS ROCKWELL C42-46
- 7 FINISH FINISH SHALL BE DIFFUSED NICKEL-CADMIUM PLATE IN ACCORDANCE WITH AMS 2416 DIMENSIONS SPECIFIED ARE MET AFTER PLATING CONTACT POINTS PERMISSIBLE
- 8 SURFACE TEXTURE SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICRONS EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI/ASME B46.1
- 9 TOLERANCE UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS ± 0.10 , ANGULAR DIMENSIONS $\pm 5^\circ$
- 10 EDGES BREAK SHARP EDGES 003-015 UNLESS OTHERWISE SPECIFIED
- 11 BEARING SURFACE BEARING SURFACE SHALL BE FLAT AND WASHER FACED DIAMETER OF BEARING SURFACE SHALL BE EQUAL TO THE MAXIMUM WIDTH ACROSS FLATS WITHIN A TOLERANCE OF MINUS 10% IN ACCORDANCE WITH ANSI B18.2.1
- 12 PART NUMBER THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE MS9438-04
 └───┬─── DASH NUMBER
 └───┬─── BASIC MS NUMBER

MS9438-04 INDICATES SCREW, MACHINE - STEEL, AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, HEXAGON HEAD, DRILLED, 138-40 UNJF-3A, LENGTH 375

- 13 PROCUREMENT SPECIFICATION, AMS 7452

NOTES.

- 1 ALL DIMENSIONS IN INCHES
- 2 DO NOT USE UNASSIGNED PART NUMBERS
- 3 IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.
- 4 UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION
- 5 THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
- 6 AS AND AMS ARE SAE PUBLICATIONS
- 7 INACTIVE FOR NEW DESIGN AFTER 13 DECEMBER 1972 NO SUPERSEDING DOCUMENT THE APPLICATION FOR WHICH THE INACTIVE MS9438 PARTS WERE ORIGINALLY DESIGNED NO LONGER EXIST

MILITARY INTERESTS
CUSTODIANS
 NAVY - AS
 AIR FORCE - 82

REVIEWER

AIR FORCE 11

PREPARING ACTIVITY
 DIA-IS

(PROJECT 5305-2113)