

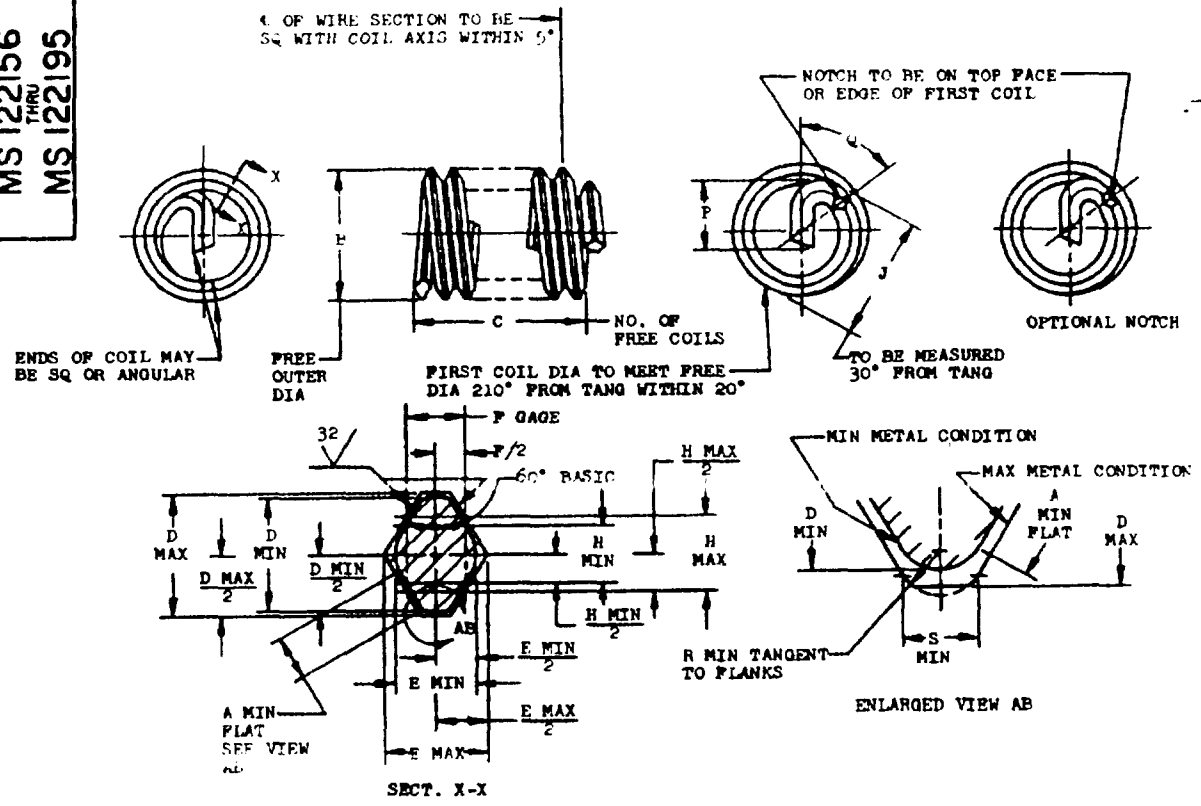
MS 122156
THRU
MS 122195

User: Army - EL, ME, MI, MU
Navy - MC, OS
Air Force -

Army - WC
Navy -
Air Force - 82

Review activity:

This 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.



THREAD SIZE	NOMI-NAL LENGTH	A MIN	B		C* ±.250 COIL	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.086 -56	.172	.0027	.110	.119	7.375	.0163	.0193	.0126	.0146	.00893	.0112	.0116
.099 -48	.198	.0043	.128	.139	7.250	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.112 -40	.224	.0068	.144	.159	6.750	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.125 -40	.250	.0068	.158	.173	7.750	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.138 -32	.276	.0076	.178	.193	6.875	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.164 -32	.328	.0076	.205	.220	8.375	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.190 -24	.380	.0120	.244	.259	7.125	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.250 -20	.500	.0164	.310	.330	8.000	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.3125 -18	.625	.0176	.380	.400	9.250	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.375 -16	.750	.0215	.452	.472	10.000	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.4375 -14	.875	.0267	.526	.551	10.250	.0730	.0770	.0545	.0625	.03571	.04589	.04639
.500 -13	1.000	.0273	.597	.622	11.000	.0758	.0829	.0593	.0673	.03846	.04946	.04996
.5625 -12	1.125	.0334	.669	.694	11.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413
.625 -11	1.250	.0351	.742	.767	11.750	.0909	.0980	.0715	.0795	.04585	.05855	.05905
.750 -10	1.500	.0402	.861	.906	13.000	.1007	.1079	.0795	.0875	.05000	.06445	.06495
.875 -8	1.750	.0466	1.022	1.052	13.750	.1124	.1199	.0892	.0972	.05556	.07167	.07217
1.000 -8	2.000	.0544	1.166	1.196	14.000	.1264	.1350	.1004	.1094	.06250	.08064	.08114
1.125 -7	2.250	.0645	1.315	1.355	13.625	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.250 -7	2.500	.0645	1.443	1.483	15.375	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.375 -6	2.750	.0775	1.598	1.643	1.4375	.1695	.1799	.1368	.1458	.08333	.10775	.10825
1.500 -6	3.000	.0775	1.727	1.772	15.875	.1695	.1799	.1368	.1458	.08333	.10775	.10825

(D) FOR CHANGE SEE SHEETS 1 AND 2

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.

P.A.	USAF - 11	TITLE	MILITARY STANDARD
Other Cont	Army - AV Navy - AS	INSERT, CRES HELICAL COIL COARSE THREAD, 2 DIA NOMINAL LENGTH	
PROCURMENT SPECIFICATION	MIL-T-8846	SUPERSEDES:	MS 122156 THRU MS 122195
		MS21208 IN PART	SHEET 1 OF 2

APPROVED 20 May 53
REVISED (A) 26 May 59 (B) 24 Oct 66 (C) 5 Oct 69 (D) 24 Feb 76

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THREAD SIZE	J		P		Q	R MIN	S MIN	APPROX WEIGHT LB/100	PART NUMBERS	
	MIN	MAX	MIN	MAX					NOTCHED	UNNOTCHED (a)
.046 -56	.103	.111	.062	.080	75° -150°	.0032	.0056	.0117	MS122175	MS122176 MS122177 MS122178 MS122179 MS122180 MS122181 MS122182 MS122183 MS122184 MS122185 MS122186 MS122187 MS122188 MS122189
.099 -48	.120	.131	.070	.090	75° -150°	.0038	.0065	.0174	MS122195	
.112 -40			.070	.095	25° -100°	.0045	.0078	.0272	MS122156	
.125 -40			.078	.108	25° -100°	.0045	.0078	.0345	MS122157	
.138 -32			.091	.121	25° -100°	.0056	.0098	.0525	MS122158	
.164 -32			.118	.153	20° -100°	.0056	.0098	.0776	MS122159	
.190 -24			.141	.176	15° -90°	.0075	.0130	.1330	MS122160	
.250 -20			.182	.233	20° -80°	.0090	.0156	.308	MS122161	
.3125 -18	.375	.390	.214	.286	20° -80°	.0100	.0174	.510	MS122162	
.375 -16	.445	.462	.269	.348	20° -80°	.0113	.0195	.862	MS122163	
.4375 -14	.518	.536	.313	.411	20° -80°	.0129	.0223	1.250	MS122164	
.500 -13	.586	.606	.348	.458	20° -80°	.0139	.0240	1.852	MS122165	
.5625 -12	.656	.676	.390	.520	20° -80°	.0150	.0260	2.632	MS122166	
.625 -11	.727	.747	.421	.567	20° -80°	.0164	.0284	3.448	MS122167	
.750 -10	.840	.885	.453	.640	60° -120°	.0180	.0312	5.263	MS122168	
.875 -9	.991	1.026	.500	.734	60° -120°	.0200	.0347	8.333	MS122169	
1.000 -8	1.135	1.170	.526	.761	60° -120°	.0226	.0391	12.500	MS122170	
1.125 -7	1.260	1.315	.557	.843	60° -120°	.0258	.0446	17.464	MS122171	
1.250 -7	1.366	1.416	.679	.937	60° -120°	.0258	.0446	21.653	MS122172	
1.375 -6	1.545	1.598	.689	1.093	60° -120°	.0301	.0521	30.122	MS122173	
1.500 -6	1.676	1.727	.811	1.187	60° -120°	.0301	.0521	36.268	MS122174	

- 1. NOMINAL LENGTH EQUALS BASIC THICKNESS OF PLATE FOR INSERT ASSEMBLY.
- 2. ASSEMBLED LENGTH OF INSERT TO BE AS SPECIFIED ON MS33537.
- 3. NUMBER OF FREE COILS TO BE COUNTED AND ASSEMBLED LENGTH OF INSERT TO BE MEASURED 90° FROM TANG.
- 4. MATERIAL: STEEL, CORROSION RESISTANT, AMS 7245 (MATERIAL AND MPG).
- 5. SURFACE TEXTURE: ANSI B46.1-1962.
- 6. INSERT, WHEN ASSEMBLED IN TAPPED HOLE AS SPECIFIED IN MS33537, SHALL PRODUCE A FINISHED THD MEETING ALL REQUIREMENTS OF MIL-S-7742 AND SHALL ACCEPT EXTERNAL MIL-S-8879 THREADS
- 7. DIMENSIONS IN INCHES.
- 8. IDENTIFICATION: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION ON CONTAINER.
- 9. DO NOT USE UNASSIGNED PART NUMBERS.
- (a) UNNOTCHED INSERTS INACTIVE FOR DESIGN AFTER 15 OCT 1969. USE NOTCHED INSERTS. NOTCHED INSERTS CAN UNIVERSALLY REPLACE THE INACTIVATED INSERTS, BUT THE INACTIVATED INSERTS CANNOT REPLACE THE SUPERSEDING NOTCHED INSERTS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERING, INC., PUBLICATIONS.
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	Army - AV Navy - AS	INSERT, JRES HELICAL COIL COARSE THREAD, 2 DIA NOMINAL LENGTH	
PROCUREMENT SPECIFICATION MIL-I-PR46	SUPERSEDES	MS21208 IN PART	SHEET 2 OF 2

APPROVED 29 May 53 REVISED A 26 May 59 R 24 Oct 66 D FOR CHANGES SEE SHEETS 1 AND 2.