



SECTION THRU THREAD PROFILE

PART NO.	L	K +.000 -.060	APPROX. WEIGHT LB/100	PART NO.	L	K +.000 -.060	APPROX. WEIGHT LB/100
MS21277-02	.250	(a)	.30	MS21277-13	.938	.375	.55
MS21277-03	.312	(a)	.32	MS21277-14	1.000	.438	.57
MS21277-04	.375	(a)	.34	MS21277-15	1.062	.500	.59
MS21277-05	.438	(a)	.37	MS21277-16	1.125	.562	.61
MS21277-06	.500	(a)	.39	MS21277-17	1.188	.625	.64
MS21277-07	.562	(a)	.41	MS21277-18	1.250	.688	.66
MS21277-08	.625	(a)	.44	MS21277-19	1.312	.750	.68
MS21277-09	.688	.125	.46	MS21277-20	1.375	.812	.70
MS21277-10	.750	.188	.48	MS21277-21	1.438	.875	.73
MS21277-11	.812	.250	.50	MS21277-22	1.500	.938	.75
MS21277-12	.875	.312	.52				

(a) THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS. EXCEPT INCOMPLETE THREADS NOT TO ENTER FILLET RADIUS.

- NOTE: (1) SHANK SHALL BE STRAIGHT WITHIN .003 FIR. PER INCH OF BOLT 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 .009 FIR.

MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5735
 MANUFACTURING SPECIFICATION: AMS 7478 EXCEPT HEADS TO BE FORMED BY HOT OR COLD UPSETTING.
 PART SUBJECT TO FLUORESCENT PENETRANT INSPECTION PER AMS 2645
 SURFACE ROUGHNESS: MIL-STD-10. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES.
 BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
 DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED; TOLERANCES; LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$
 DO NOT USE UNASSIGNED PART NUMBERS.

This sheet has been approved by the Department of the Navy and the Department of the Air Force and is mandatory for use by other military activities where its use is required to employ this standard where suitable.

P.A. Navy - Wen	TITLE	MILITARY STANDARD MS21277 (ASG)
Other Cust Air Force - ASD	SCREW, MACHINE - STEEL, DOUBLE HEXAGON, EXTENDED WASHER, .138-40 (MIL-S-8879 THREAD)	
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 1
NONE		

APPROVED 1 May 61 REVISED A 23 Oct 61 B 17 Sep 63