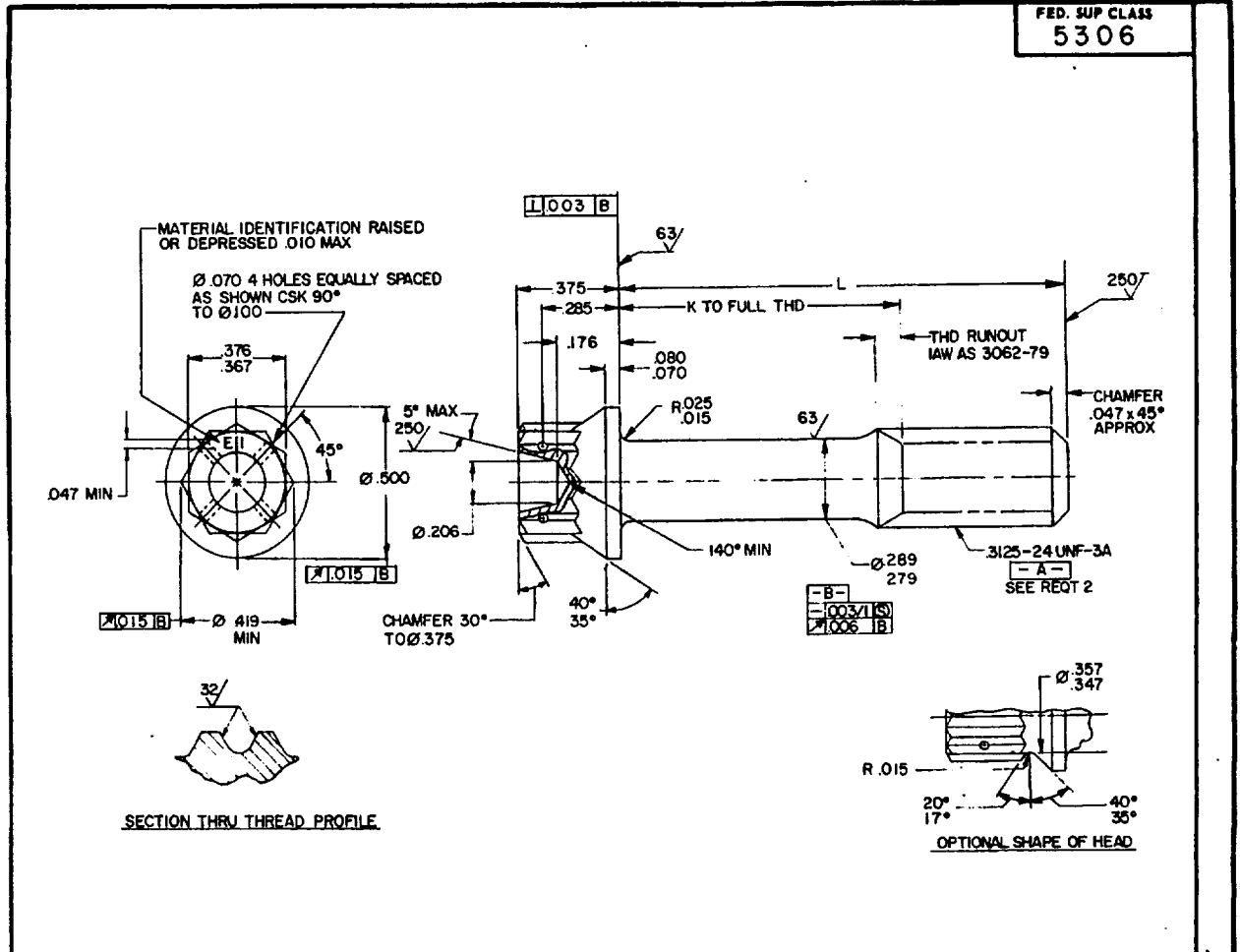


USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA-1S

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SECTION THRU THREAD PROFILE

OPTIONAL SHAPE OF HEAD

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
-05	.562	✓	2.21	-23	1.688	.812	4.22	-41	3.875	3.000	8.17
-06	.625	✓	2.28	-24	1.750	.875	4.33	-42	4.000	3.125	8.40
-07	.688	✓	2.39	-25	1.875	1.000	4.55	-43	4.125	3.250	8.63
-08	.750	✓	2.51	-26	2.000	1.125	4.77	-44	4.250	3.375	8.86
-09	.812	✓	2.62	-27	2.125	1.250	5.00	-45	4.375	3.500	9.08
-10	.875	✓	2.73	-28	2.250	1.375	5.23	-46	4.500	3.625	9.30
-11	.938	✓	2.85	-29	2.375	1.500	5.45	-47	4.625	3.750	9.52
-12	1.000	.125	2.96	-30	2.500	1.625	5.67	-48	4.750	3.875	9.74
-13	1.062	.188	3.07	-31	2.625	1.750	5.90	-49	4.875	4.000	9.95
-14	1.125	.250	3.19	-32	2.750	1.875	6.13	-50	5.000	4.125	10.17
-15	1.188	.312	3.30	-33	2.875	2.000	6.36	-51	5.125	4.250	10.40
-16	1.250	.375	3.41	-34	3.000	2.125	6.58	-52	5.250	4.375	10.63
-17	1.312	.438	3.52	-35	3.125	2.250	6.80	-53	5.375	4.500	10.86
-18	1.375	.500	3.64	-36	3.250	2.375	7.03	-54	5.500	4.625	11.10
-19	1.438	.562	3.75	-37	3.375	2.500	7.27	-55	5.625	4.750	11.33
-20	1.500	.625	3.87	-38	3.500	2.625	7.50	-56	5.750	4.875	11.56
-21	1.562	.688	3.98	-39	3.625	2.750	7.73	-57	5.875	5.000	11.78
-22	1.625	.750	4.10	-40	3.750	2.875	7.95	-58	6.000	5.125	12.00

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

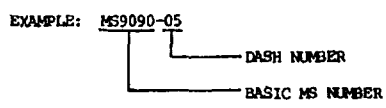
INACTIVE FOR DESIGN AFTER
28 FEB 84
FOR PARTS WITH MIL-S-8879
SCREW THREADS SEE MS9925

Ⓢ DENOTES CHANGES

P. A. NAVY-AS Other Cost	INTERNATIONAL INTEREST	TITLE Ⓢ BOLT-MACHINE, DRILLED 12 POINT HEAD, STEEL, .3125-18 UNF-3A	MILITARY STANDARD
			MS 9090
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE 1 OF 2

REQUIREMENTS:

- (C) 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.



MS9090-05 INDICATES: BOLT, MACHINE, STEEL DRILLED 12 POINT HEAD;
.3125-24 UNF-3A; LENGTH .562.

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
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APPROVED 25 APR 57 REVISED (C) FOR CHANGES SEE PAGES 1 AND 2

P. A. NAVY-AS <small>Other Cust</small> AIR FORCE-11	INTERNATIONAL INTEREST	TITLE BOLT-MACHINE, © DRILLED 12 POINT HEAD, STEEL, .3125-18 UNF-3A	MILITARY STANDARD
			MS 9090
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 2 OF 2	