

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO.	L	K +.000 -.060	APPROX WEIGHT LB/100	DASH NO.	L	K +.000 -.060	APPROX WEIGHT LB/100
-02	.250	1/	.297	-17	1.188	.625	.627
-03	.312	1/	.318	-18	1.250	.688	.649
-04	.375	1/	.340	-19	1.312	.750	.671
-05	.438	1/	.363	-20	1.375	.812	.693
-06	.500	1/	.386	-21	1.438	.875	.715
-07	.562	1/	.406	-22	1.500	.938	.737
-08	.625	1/	.429				
-09	.688	.125	.451				
-10	.750	.188	.473				
-11	.812	.250	.495				
-12	.875	.312	.517				
-13	.938	.375	.539				
-14	1.000	.438	.561				
-15	1.062	.500	.583				
-16	1.125	.562	.605				

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

REQUIREMENTS:

- MATERIAL:** STEEL AMS 6322 (UNS G87400).
- HARDNESS:** 26-32 HRC
- FINISH:** CADMIUM PLATE PER AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
- THREADS:** THREADS IN ACCORDANCE WITH MIL-S-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
- DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
- WRENCHING CONFIGURATION:** WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
- SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD.
- MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION PER AMS 2640.
- TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
- EDGES:** BREAK SHARP EDGES .003 - .015 UNLESS OTHERWISE SPECIFIED.

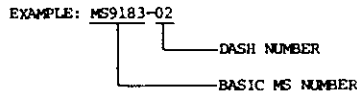
ⓑ ENTIRE STANDARD REVISED

P.A. NAVY-AS Other Cont	INTERNATIONAL INTEREST	TITLE SCREW-MACHINE, STEEL, DRILLED 12 POINT HEAD, .138(NO. 6)-40, CADMIUM PLATE	MILITARY STANDARD MS9183
AIR FORCE-11	PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 1 OF 2

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 AMSC N/A

APPROVED 31 MAR 58  
 REVISED ⓑ 13 JUL 87

11. PART NUMBER: THE PART SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.



MS9183-02 INDICATES: SCREW, MACHINE, STEEL, DRILLED 12 POINT HEAD, .138-40, CADMIUM PLATE, .250 LONG.

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 NON-GOVERNMENT) 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.

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APPROVED 31 MAR 58 REVISED (B) FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY-AS Other Cust	INTERNATIONAL INTEREST	TITLE SCREW-MACHINE, STEEL, DRILLED 12 POINT HEAD, .138(NO. 6)-40, CADMIUM PLATE	MILITARY STANDARD	
			MS9183	
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