

TABLE 1 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	✓	.297	-17	1.180	.625	.627
-03	.312	✓	.318	-18	1.250	.680	.649
-04	.375	✓	.340	-19	1.312	.750	.671
-05	.438	✓	.363	-20	1.375	.812	.693
-06	.500	✓	.386	-21	1.438	.875	.715
-07	.562	✓	.406	-22	1.500	.938	.737
-08	.625	✓	.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				

✓/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

REQUIREMENTS:

- MATERIAL:** STEEL, AIG 6122 (USC C87400).
- HARDNESS:** 26-32 HRC
- FINISH:** CADMIUM PLATE PER AIG 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
- THREADS:** THREADS IN ACCORDANCE WITH MIL-G-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
- DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH AIG 174.5A.
- WRENCHING CONFIGURATION:** WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
- SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED SHALL BE 125 MICRONS EXCEPT UPSET HEAD.
- MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION PER AIG 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, 12 POINT HEAD, .138(NO. 6)-40, CADMIUM PLATE	MILITARY STANDARD MS9185
AIR FORCE - 82			
PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE - OF 1 2

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 AMSC N/A

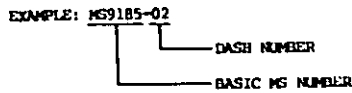
USER ACTIVITIES:

 REVIEWER ACTIVITIES:
 DLA-15

INACTIVE FOR NEW DESIGN AFTER 17 MAR 72

APPROVED 31 MAR 58 REVISED C13 JUL 87

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



MS9185-02 INDICATES: SCREW, MACHINE, STEEL, 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 © FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY-AS <small>Other Cust</small>	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, STEEL, 12 POINT HEAD, .138(NO. 6)-40, CADMIUM PLATE	MILITARY STANDARD	
			MS9185	
AIR FORCE-82 PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:		PAGE 2 OF 2	

DD FORM 1 MAY 72 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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