

SECTION THRU THREAD PROFILE

OPTIONAL BLANK OF HEAD

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	✓	.30	-19	1.312	.750	.68
-03	.312	✓	.32	-20	1.375	.812	.70
-04	.375	✓	.34	-21	1.438	.875	.73
-05	.438	✓	.37	-22	1.500	.938	.75
-06	.500	✓	.39				
-07	.562	✓	.41				
-08	.625	✓	.44				
-09	.688	.125	.46				
-10	.750	.188	.48				
-11	.812	.250	.50				
-12	.875	.312	.52				
-13	.938	.375	.55				
-14	1.000	.438	.57				
-15	1.062	.500	.59				
-16	1.125	.562	.61				
-17	1.188	.625	.64				
-18	1.250	.688	.66				

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

REQUIREMENTS:

- MATERIAL:** CORROSION AND HEAT RESISTANT STEEL AMS 5732 (UNS S66286).
- THREADS:** THREADS IN ACCORDANCE WITH MIL-8-7742. 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 070.
- SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED SHALL BE 125 MICRONS EXCEPT UPSET HEAD.
- FLOUORESCENT PENETRANT INSPECTION:** FLOUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2545.
- TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
- EDGES:** BREAK SHARP EDGES .003 - .015 UNLESS OTHERWISE SPECIFIED.

INACTIVE FOR NEW DESIGN AFTER 6 APR 67

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P.A. NAVY-AS Drawn Out	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE-CRES, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, .138-40	MILITARY STANDARD MS9187
AIR FORCE -11	PROCUREMENT SPECIFICATION AMS 7478	SUPERSEDES:	PAGE 1 OF 2

USER ACTIVITIES:

REVIEWER ACTIVITIES:
DLA -IS

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AMSC N/A

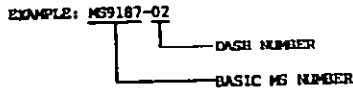
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5305-1710

APPROVED 15 AUG 60 REVISED © 13 JUL 67

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



MS9187-02 INDICATES: SCREW, MACHINE-CRES, AMS 5735 DOUBLE HEXAGON EXTENDED WASHER DRILLED, .138-40, .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 (DoD-ISS) 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.

USER ACTIVITIES:

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APPROVED 15 AUG 60 REVISED (C) FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY-AS Other Cont		INTERNATIONAL INTEREST	TITLE SCREW, MACHINE-CRES, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, .138-40	MILITARY STANDARD MS9187	
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