

TABLE I. DASH NUMBERS AND DIMENSIONS

| DASH NO. | L     | K         | APPROX WEIGHT LB/100 |
|----------|-------|-----------|----------------------|
| -03      | .312  | .062-.082 | .451                 |
| -04      | .375  | .062-.082 | .482                 |
| -05      | .438  | .062-.082 | .513                 |
| -06      | .500  | .062-.082 | .543                 |
| -07      | .562  | .062-.082 | .573                 |
| -08      | .625  | .062-.082 | .604                 |
| -09      | .688  | .062-.082 | .634                 |
| -10      | .750  | .112-.172 | .664                 |
| -11      | .812  | .174-.234 | .695                 |
| -12      | .875  | .237-.397 | .725                 |
| -13      | .938  | .300-.360 | .756                 |
| -14      | 1.000 | .362-.422 | .786                 |
| -15      | 1.062 | .424-.484 | .816                 |

| DASH NO. | L     | K           | APPROX WEIGHT LB/100 |
|----------|-------|-------------|----------------------|
| -16      | 1.125 | .487-.547   | .847                 |
| -17      | 1.188 | .550-.610   | .878                 |
| -18      | 1.250 | .612-.672   | .908                 |
| -19      | 1.312 | .674-.734   | .938                 |
| -20      | 1.375 | .737-.797   | .969                 |
| -21      | 1.438 | .800-.860   | .999                 |
| -22      | 1.500 | .862-.922   | 1.029                |
| -23      | 1.562 | .924-.984   | 1.060                |
| -24      | 1.625 | .987-1.047  | 1.090                |
| -25      | 1.688 | 1.050-1.110 | 1.121                |
| -26      | 1.750 | 1.112-1.172 | 1.151                |
| -27      | 1.875 | 1.237-1.297 | 1.212                |
| -28      | 2.000 | 1.362-1.422 | 1.273                |

(A) ENTIRE STANDARD REVISED

|                                       |                           |  |                   |
|---------------------------------------|---------------------------|--|-------------------|
| P A<br>NAVY - AS<br>Other Cust        | INTERNATIONAL<br>INTEREST | TITLE<br>SCREW, MACHINE-STEEL, DIFFUSED NICKEL-<br>CADMIUM PLATED, DOUBLE HEXAGON EXTEND-<br>ED WASHER HEAD, .164 - 36 UNJF - 3A | MILITARY STANDARD |
|                                       |                           |  | MS9207            |
| PROCUREMENT SPECIFICATION<br>AMS 7459 | SUPERSEDES                | PAGE 1 OF 2  |                   |

DISTRIBUTION STATEMENT A: Approved for public release; distribution is unlimited.  
 This military standard is approved for use by all Departments and Agencies of the Department of Defense.  
 Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

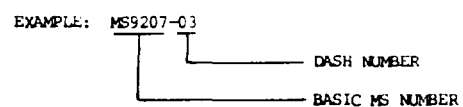
USER ACTIVITIES:  
  
 REVIEWER ACTIVITIES:  
 DLA - IS

APPROVED 10 DEC 63 REVISED (A) 27 MAY 86

USER ACTIVITIES:  
  
REVIEWER ACTIVITIES:  
DLA - IS

REQUIREMENTS:

1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6304 (UNS K14675).
2. HARDNESS: ROCKWELL C42-46.
3. FINISH: DIFFUSED NICKEL-CADMIUM PLATE IN ACCORDANCE WITH AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAX BEFORE PLATING.
4. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640 BEFORE PLATING.
5. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
6. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
7. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478, CLASS A.
8. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
9. SURFACE TEXTURE: SURFACE TEXTURE IN ACCORDANCE WITH ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACE TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
10. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSION  $\pm 5^\circ$ .
11. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.



MS9207-03 INDICATES - SCREW, MACHINE - STEEL AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, .164-36 UNJF-3A x .312 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.

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

APPROVED 10 DEC 63 REVISED (A) FOR CHANGES SEE PAGES 1 AND 2

|                                       |                           |  |                   |
|---------------------------------------|---------------------------|--|-------------------|
| PA<br>NAVY - AS<br>Other Cust         | INTERNATIONAL<br>INTEREST | TITLE  | MILITARY STANDARD |
|                                       |                           | SCREW, MACHINE - STEEL, DIFFUSED NICKEL-CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, .164-36 UNJF-3A | MS9207            |
| PROCUREMENT SPECIFICATION<br>AMS 7459 | SUPERSEDES                | PAGE<br>2  | OF<br>2           |