

INCH-POUND

MS9317A
 27 OCTOBER 1985
 SUPERSEDING
 MS9317(ASG)
 16 MAY 60

MILITARY SPECIFICATION SHEET

SCREW, MACHINE-STEEL, SLOTTED
 HEXAGON HEAD, 250-28,
 NI-CAD PLATE

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS
 AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST
 OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING DOCUMENT
 LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS
 AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION. (SEE REQT 13)

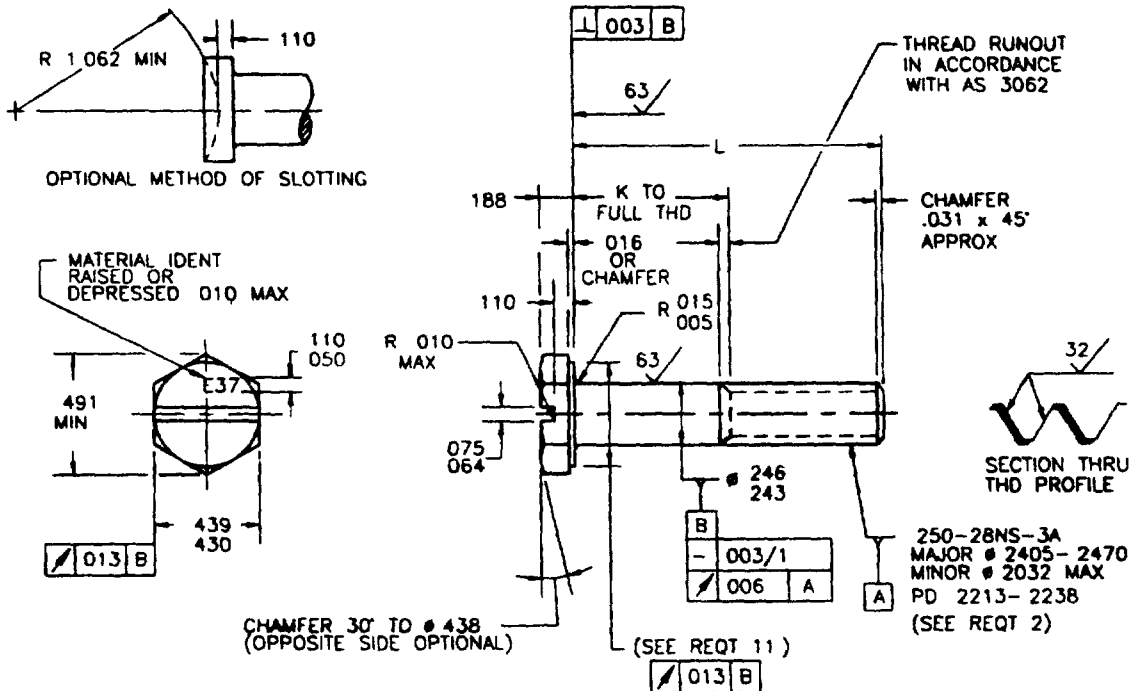


TABLE 1 DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100
-02	.500	(a)	1.50
-03	.562	(a)	1.68
(b) -04	.625	(a)	1.87
-05	.688	(a)	2.06
-06	.750	(a)	2.25
-07	.812	(a)	2.44
(b) -08	.875	.125	2.62
-09	.938	.188	2.81
-10	1.000	.250	3.00
-12	1.125	.375	3.37
-14	1.250	.500	3.75
-16	1.375	.625	4.12
-18	1.500	.750	4.50

- (a) THREAD TO HEAD MAXIMUM TWO IMPERFECT THREADS
- (b) PREFERRED LENGTHS

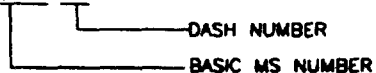
(A) ENTIRE DOCUMENT REVISED

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REQUIREMENTS

- 1 MATERIAL STEEL PER AMS 6304
- 2 THREADS THREADS PER MIL-S-7742
- 3 DIMENSIONING AND TOLERANCING DIMENSIONING AND TOLERANCING SHALL BE PER ASME Y14.5M
- 4 HEAD TO SHANK FILLET HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS
- 5 MAGNETIC PARTICLE INSPECTION MAGNETIC PARTICLE INSPECTION SHALL BE PER AMS 2640
- 6 HARDNESS ROCKWELL C32-36
- 7 FINISH FINISH SHALL BE DIFFUSED NICKEL-CADMIUM PLATE PER AMS 2416 CONTACT POINTS PERMISSIBLE PD MAY BE MODIFIED .0012 MAX BEFORE PLATING DIMENSIONS SPECIFIED ARE AFTER PLATING
- 8 SURFACE TEXTURE SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 250 MICRONS EXCEPT UPSET HEAD PER ANSI/ASME B46.1
- 9 TOLERANCE UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5'$
- 10 EDGES BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED
- 11 BEARING SURFACE BEARING SURFACE SHALL BE FLAT AND WASHER FACED DIAMETER OF BEARING SURFACE SHALL BE EQUAL TO THE MAXIMUM WIDTH ACROSS FLATS WITHIN A TOLERANCE OF MINUS 10% IN ACCORDANCE WITH ANSI B18.2.1
- 12 PART NUMBER THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE MS9317-04



MS9317-04 INDICATES SCREW, MACHINE-STEEL, SLOTTED HEXAGON HEAD, 250-28, NI-CAD PLATE, LENGTH 625

- 13 PROCUREMENT SPECIFICATION, AMS 7452

NOTES.

- 1 ALL DIMENSIONS IN INCHES
- 2 DO NOT USE UNASSIGNED PART NUMBERS
- 3 IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.
- 4 UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION
- 5 THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION
- 6 AS AND AMS ARE SAE PUBLICATIONS

MILITARY INTERESTS
CUSTODIANS
NAVY - AS

PREPARING ACTIVITY
DLA-IS

(PROJECT 5305-2114)