

TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NO	L	K	APPROX WEIGHT LB/100	DASH NO	L	K	APPROX WEIGHT LB/100
-02	1.812	1.002-1.062	3.51	-31	2.375	1.565-1.625	4.29
-03	1.938	1.128-1.188	3.68	-32	2.500	1.690-1.750	4.46
-04	.375	.079-.099	1.54	-33	2.625	1.815-1.875	4.63
-05	.438	.079-.099	1.62	-34	2.750	1.940-2.000	4.80
-06	.500	.079-.099	1.71	-35	2.875	2.065-2.125	4.98
-07	.562	.079-.099	1.79	-36	3.000	2.190-2.250	5.15
-08	.625	.079-.099	1.88	-37	3.125	2.315-2.375	5.33
-09	.688	.079-.099	1.97	-38	3.250	2.440-2.500	5.49
-10	.750	.079-.099	2.05	-39	3.375	2.565-2.625	5.66
-11	.812	.079-.099	2.14	-40	3.500	2.690-2.750	5.84
-12	.875	.079-.125	2.22	-41	3.625	2.815-2.875	6.01
-13	.938	.128-.188	2.31	-42	3.750	2.940-3.000	6.18
-14	1.000	.190-.250	2.40	-43	3.875	3.065-3.125	6.35
-15	1.062	.252-.312	2.48	-44	4.000	3.190-3.250	6.52
-16	1.125	.315-.375	2.57	-45	4.125	3.315-3.375	6.70
-17	1.188	.378-.438	2.65	-46	4.250	3.440-3.500	6.87
-18	1.250	.440-.500	2.74	-47	4.375	3.565-3.625	7.04
-19	1.312	.502-.562	2.82	-48	4.500	3.690-3.750	7.21
-20	1.375	.565-.625	2.91	-49	4.625	3.815-3.875	7.38
-21	1.438	.628-.688	3.00	-50	4.750	3.940-4.000	7.56
-22	1.500	.690-.750	3.08	-51	4.875	4.065-4.125	7.73
-23	1.562	.752-.812	3.17	-52	5.000	4.190-4.250	7.90
-24	1.625	.815-.875	3.26	-53	5.125	4.315-4.375	8.07
-25	1.688	.878-.938	3.34	-54	5.250	4.440-4.500	8.24
-26	1.750	.940-1.000	3.43	-55	5.375	4.565-4.625	8.42
-27	1.875	1.065-1.125	3.60	-56	5.500	4.690-4.750	8.59
-28	2.000	1.190-1.250	3.77	-57	5.625	4.815-4.875	8.76
-29	2.125	1.315-1.375	3.94	-58	5.750	4.940-5.000	8.90
-30	2.250	1.440-1.500	4.11	-59	5.875	5.065-5.125	9.07
				-60	6.000	5.190-5.250	9.24

(B) ENTIRE STANDARD REVISED

P.A. NAVY-AS Other Cust AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED 6 HOLES, FULL SHANK, .250-28 UNJF-3A	MILITARY STANDARD MS9584
PROCUREMENT SPECIFICATION AMS7477	SUPERSEDES.	PAGE 1 OF 2	

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE - 82
ARMY - MI
DLA - IS

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AMSC N/A

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

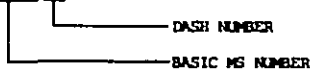
5306-1179

APPROVED 5 MAY 1965 REVISED (B) 30 SEPT 87

REQUIREMENTS:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5731 (UNS S66286).
2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. FLUORESCENT PENETRANT INSPECTION: FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645.
4. SURFACE TEXTURE: SURFACE TEXTURE IN ACCORDANCE WITH ANSI B46.1. UNLESS OTHERWISE SPECIFIED, SURFACE TO BE 125 MICROINCHES EXCEPT UPSET BEAD.
5. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS478 CLASS A.
6. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
7. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
8. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
9. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9584-02



MS9584-02 INDICATES - BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK AMS 5731, .250-28 UNJF-3A x 1.812

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.

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE - 82
ARMY - MI
DLA - IS

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APPROVED 5 MAY 1965 REVISED (B) FOR CHANGES SEE PAGES 1 AND 2

P.A. NAVY - AS Other Curt	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 6 HOLES, FULL SHANK, .250-28 UNJF-3A	MILITARY STANDARD MS9584
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PROCUREMENT SPECIFICATION AMST477	SUPERSEDES:	PAGE 2 OF 2	