

SECTION THRU THREAD PROFILE

OPTIONAL SHAPE OF HEAD

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100	DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100	DASH NUMBER	L	K +.000 -.060	APPROX WEIGHT LBS/100
-06	.500	1/	1.29	-23	1.562	.812	2.50	-41	3.625	2.875	4.85
-07	.562	1/	1.36	-24	1.625	.875	2.57	-42	3.750	3.000	4.99
-08	.625	1/	1.44	-25	1.688	.938	2.64	-43	3.875	3.125	5.13
-09	.688	1/	1.51	-26	1.750	1.000	2.72	-44	4.000	3.250	5.27
-10	.750	1/	1.58	-27	1.875	1.125	2.86	-45	4.125	3.375	5.42
-11	.812	1/	1.65	-28	2.000	1.250	3.00	-46	4.250	3.500	5.56
-12	.875	.125	1.72	-29	2.125	1.375	3.14	-47	4.375	3.625	5.71
-13	.938	.188	1.79	-30	2.250	1.500	3.29	-48	4.500	3.750	5.85
-14	1.000	.250	1.86	-31	2.375	1.625	3.43	-49	4.625	3.875	6.00
-15	1.062	.312	1.93	-32	2.500	1.750	3.57	-50	4.750	4.000	6.14
-16	1.125	.375	2.00	-33	2.625	1.875	3.71	-51	4.875	4.125	6.29
-17	1.188	.438	2.08	-34	2.750	2.000	3.85	-52	5.000	4.250	6.43
-18	1.250	.500	2.15	-35	2.875	2.125	4.00	-53	5.125	4.375	6.56
-19	1.312	.562	2.22	-36	3.000	2.250	4.14	-54	5.250	4.500	6.70
-20	1.375	.625	2.29	-37	3.125	2.375	4.29	-55	5.375	4.625	6.84
-21	1.438	.688	2.36	-38	3.250	2.500	4.43	-56	5.500	4.750	6.99
-22	1.500	.750	2.43	-39	3.375	2.625	4.58	-57	5.625	4.875	7.13
				-40	3.500	2.750	4.72	-58	5.750	5.000	7.28
								-59	5.875	5.125	7.42
								-60	6.000	5.250	7.57

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

INACTIVE FOR DESIGN AFTER  
28 FEB 84  
FOR PARTS WITH MIL-S-8879  
SCREW THREADS SEE MS9924

© DENOTES CHANGES

P. A. NAVY - AS Other Cust AIR FORCE - 11	INTERNATIONAL INTEREST	TITLE © BOLT-MACHINE, DRILLED 12 POINT HEAD, STEEL, .250 - 28 UNF - 3A	MILITARY STANDARD <b>MS 9089</b>
	PROCUREMENT SPECIFICATION AMS 7452	SUPERSEDES:	PAGE 1 OF 2

USER ACTIVITIES

REVIEWER ACTIVITIES

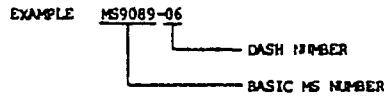
DLA-1S

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APPROVED 25 APR 57 REVISED (B) 25 SEP 86 (C) 12 JUN 87

REQUIREMENTS:

1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6322-80
2. THREADS: THREADS IN ACCORDANCE WITH MIL-5-7742. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. FINISH: CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80. DIMENSIONS SPECIFIED ARE AFTER PLATING.
4. HARDNESS: 26-32 HRC.
5. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
6. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS870-74.
7. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES, EXCEPT UPSET HEAD, IN ACCORDANCE WITH ANSI B46.1.
8. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83.
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. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I



MS9089-06 INDICATES: BOLT, MACHINE, STEEL DRILLED 12 POINT HEAD;  
.250-28 UNF-3A; LENGTH .500

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 NONGOVERNMENT) 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.
7. SUBJECT TERM (KEY WORD) LISTING:  
BOLT, MACHINE, STEEL DRILLED 12 POINT HEAD, CADMIUM PLATE

USER ACTIVITIES.

REVIEWER ACTIVITIES.

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APPROVED 25 APR 57 REVISED © FOR CHANGES SEE PAGES 1 AND 2

P A <b>NAVY - AS</b> <small>Other Code</small> <b>AIR FORCE-II</b>	INTERNATIONAL INTEREST	TITLE © BOLT-MACHINE, DRILLED 12 POINT HEAD, STEEL, .250-28 UNF-3A	<b>MILITARY STANDARD</b>
			<b>MS 9089</b>
PROCUREMENT SPECIFICATION <b>AMS 7452</b>	SUPERSEDES:	PAGE 2 OF 2	