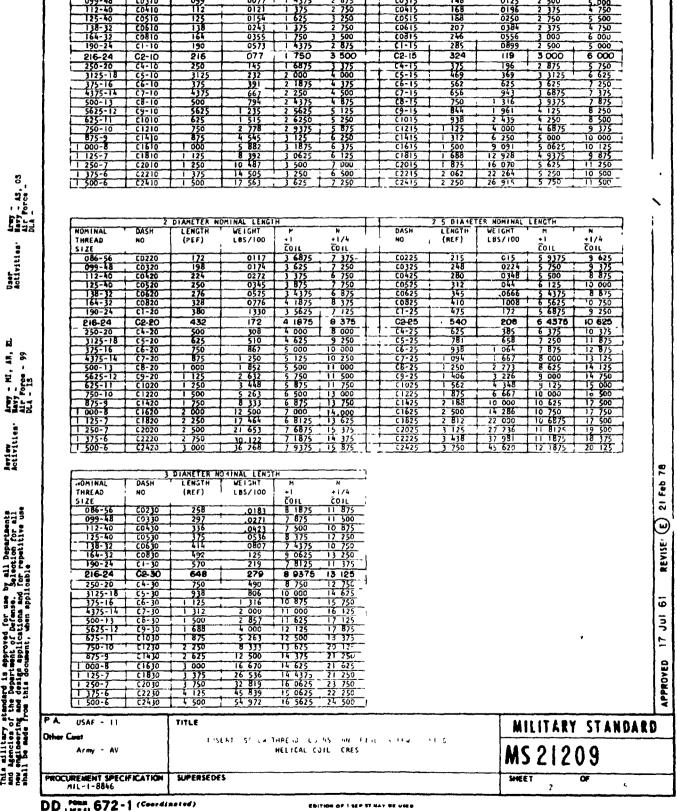


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a silitary standard is approved for use by all Departments Agencies of the Department of Defanes. Selection for all employering and design applications and for repetitive use it be made from this document, when applicable



COARSE THREAD SERIES

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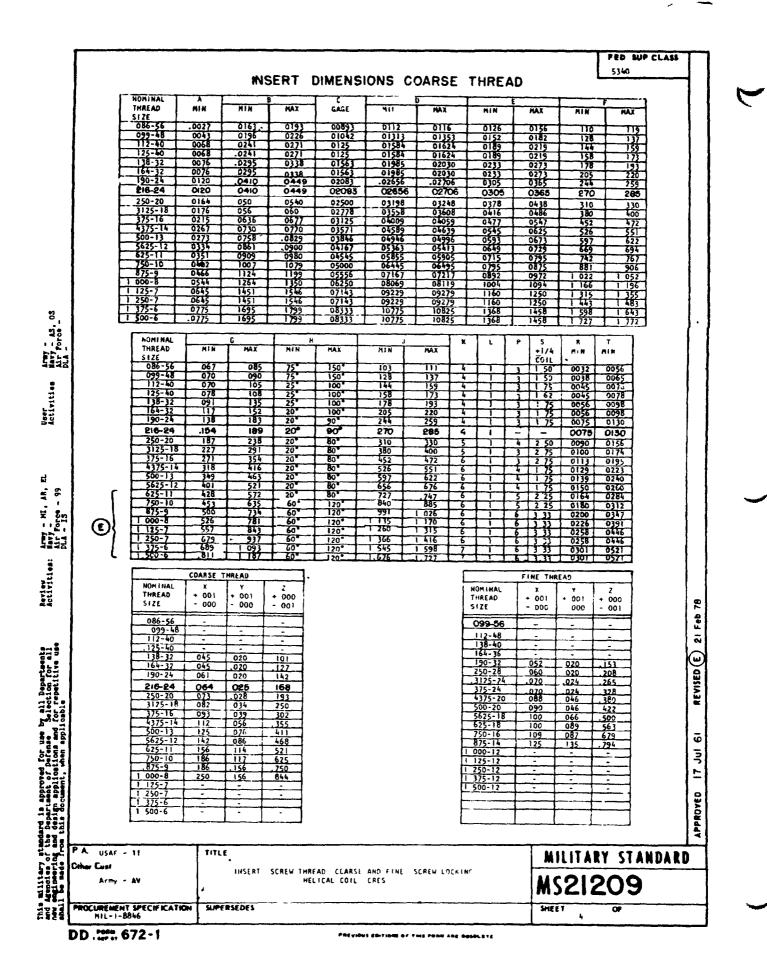
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1	5625-18	FB-30 F9-30	1 500	1 857	17 4375	25 875							
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FED SUP CLASS \$340 INSERT DIMENSIONS FINE THREAD NOMINAL MAX THREAD MAX MAX HIN NIN 118 MAX GAGE MIN MIN 099-56 -0|12 01313 01584 01764 00893 0116 01353 01624 0126 002 0163 0193 0156 146 衻 0196 0043 0226 173 138-40 193 0271 01250 0219 164-36 0059 026 0301 01389 01804 020 024 236 306 380 023 025 030 030 0295 0338 0156 256 190-32 00 76 01985 02030 027 326 02270 02656 02656 02320 031 250-28 0085 3125-24 375-24 4375-20 500-20 02083 0120 DLIO 0449 02706 02706 **448** 468 0120 0410 0449 0540 0540 0600 0365 0438 0438 03198 03198 03558 03558 03558 04009 524 592 666 0164 500 02500 03248 0378 0378 0416 0416 0477 0545 0649 0649 0649 617 500 0560 0560 02500 03248 0164 5625-18 0176 0486 691 03608 04059 04059 05413 05413 05413 05413 0486 0547 0625 0729 0729 0729 625-18 750-16 875-14 0176 0600 02778 733 0215 0636 0730 04589 05363 05363 05363 05363 05363 0770 03571 0267 021 051 1 000-12 1 125-12 1 250-12 0334 0334 0334 1 169 1 304 1 439 1 575 1 199 1 334 1 469 0000 0000 0900 0900 04167 0861 04167 1 375-12 0334 1980 04167 064 0729 1 610 0861 04167 0649 0729 1 745 8 Arey - AS, (Mary - AS, (Air Force -DLA -NOMINAL HIN ĸ +1/4 THREAD MEN MAX MAX MIN MAX MIN SIZE COL 0056 .0065 0078 0087 0098 0112 .0032 .0038 .0045 146 099-56 07 090 75 150 131 1 User Activities 2.33 112-48 060 095 75 150 147 Т 138-40 130 147 182 100 123 193 2.33 100 117 131 178 209 240 287 1 25 204 236 306 380 448 224 ī 2.11 0050 190-32 250-28 3125-24 256 326 400 468 19 90 1 0056 0064 0075 244 10 291 2 <u>3 25</u> 5 25 0130 13 375-24 15 10 0075 0130 <u> 357</u> 0090 524 592 666 4 0 15 15 15 549 2 318 354 386 464 500-20 617 691 5 24 0156 479 TO 0174 2 541 588 2 10 625-18 750-16 15 733 876 758 901 1 051 10 0100 0174 Ž 2 75 75 75 75 75 70 70 đ 0195 0223 0260 15* <u>557</u> 604 12 0113 495 526 557 0129 0150 .0150 0150 875-14 021 12 6 25 15 Å, 6 1 000-12 728 B19 2 14 1 169 1.199 4 Force -15 0260 10* 1.304 1.344 1.469 |-<u>]</u>]4 |-<u>3</u>]4 |-504 16 1 250-12 1 375-12 1 500-12 679 941 10 R 0150 70 10 0260 14 81 1 123 10 70 1 594 1 629 \mathbf{T} 0150 0260 14 Review Activities NOMINAL LENGTH NOMINAL LENGTH EQUALS NINIMUM THROUCH HOLE LENGTH WITHOUT COUNTERSINK AND WITH INSERT LOCATED 1/4 TO 1/2 THREAD FITCH BELOW TOP SURFACE THE NUMBER OF FREE COLLS OF THE INSERT ARE COUNTED 90° FROM TANG FOR ALL SIZES STEEL, CORROSION RESISTANT, SEE PROCUREMENT SPECIFICATION INSERT, WHEN ASSEMBLED IN BASIC TAPPED HOLE AS SPECIFICED ON STANDARD MS33537, SHALL PRODUCE A FINISHED FREE COILS MATERIAL (E) THREAD THREAD MEETING THE REQUIREMENTS OF HANDBOOK H-28 AND SHALL ACCEPT EXTERNAL THREADED PARTS WHICH ARE THREADED TO MIL-S-7742 OR MIL-S-8879 SURPACE ROUGHNESS: ANSI B46 1-1962 by all Departments Selection for all d for repetitive use licable Ξ DIMENSIONS IN INCHES, APPLY BEFORE PLATING UNLESS OTHERWISE SPECIFIED, TOLERANCES LINEAR DIMENSIONS 2 010 DIMENSIONS 2 50 ANGULAR REVISED COLOR IDENTIFICATION (a) BARE INSERTS - DYED RED (b) DRY FILM LUBRICATED - DARK GREY (c) CADMIUM PLATED - OLIVE DRAB DRY FILM LUBRICANT SHALL BE IN ACCORDANCE WITH MIL-L-8937 LUBRICANT LUBRICANT DRI FILM LUBRICANT SHALL BE IN ACCORDANCE WITH MIL-L-893/ PLATING CADMIUM PLATING SHALL BE IN ACCORDANCE WITH QQ-P-416, TYPE II, EXCEPT THE THICKNESS SHALL BE A MAXIMUM OF Q OO ADD THE LETTER "L" AFTER THE PART NUMBER TO DESIGNATE A DRI FILM LUBRICANT COATED INSERT ADD THE LETTER "P" AFTER THE PART NUMBER TO DESIGNATE A CADMIUM PLATED INSERT THE MS PART NUMBER CONSISTS OF THE BASIC MS NUMBER PLUS THE DASH NUMBER ò r standard is approved for use b of the Department of Defense ing and design applications and a from this document, when appli EXAMPLE OF PART NUMBER MS21209C0415 = A SCREW LOCKING HELICAL COIL INSERT (MS21209), COARSE THREAD (C), NUMBER 4 THREAD DIAMETER (04), 1 5 DIA NOMINAL LENGTH (15) MS21209FA-20L = A SCREW LOCKING HELICAL COIL INSERT (MS21209), FIWE THREAD (F), 0 0250-28 THREAD DIAMETER (4), WITH A DRY FILM LUBRICANT (L) MS21209F1225P * A SCREW LOCKING HELICAL COIL INSERT (MS21209), FINE THREAD (F), O 0750-16 THREAD DIAMETER (12), 2 5 DIAMETER NOMINAL LENGTH (25), WITH CADMIUM PLATING (P) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID PA USAF - II INTERNATIONAL TITLE MILITARY STANDARD Agencies of Agencies of engineering er Cust INSERT, SCREW THREAD, COARSE AND FINE, SCREW LOCKING HELICAL COIL CRES MS21209 Army - Av PROCUREMENT SPECIFICATION OF SUPERSEDES SHEET 5 MIL- 1 - 8646

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