



MS122156  
THRU  
MS122195

User: Army - EL, ME, MI, MU  
Navy - MC, OS  
Air Force -

Review activities: Army - WC  
Navy -  
Air Force - 82

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THREAD SIZE	J		P		Q	R MIN	S MIN	APPROX WEIGHT LB/100	PART NUMBERS	
	MIN	MAX	MIN	MAX					NOTCHED	UNNOTCHED (a)
.046 -56	.103	.111	.062	.080	75°-150°	.0032	.0056	.0117	MS122175	<del>MS122176 MS122177 MS122178 MS122179 MS122180 MS122181 MS122182 MS122183 MS122184 MS122185 MS122186 MS122187 MS122188 MS122189</del>
.099 -48	.120	.131	.070	.090	75°-150°	.0038	.0065	.0174	MS122195	
.112 -40			.070	.095	25°-100°	.0045	.0078	.0272	MS122156	
.125 -40			.078	.108	25°-100°	.0045	.0078	.0345	MS122157	
.138 -32			.091	.121	25°-100°	.0056	.0098	.0525	MS122158	
.164 -32			.118	.153	20°-100°	.0056	.0098	.0776	MS122159	
.190 -24			.141	.176	15°-90°	.0075	.0130	.1330	MS122160	
.250 -20			.182	.233	20°-80°	.0090	.0156	.308	MS122161	
.3125-18	.375	.390	.214	.286	20°-80°	.0100	.0174	.510	MS122162	
.375 -16	.445	.462	.269	.348	20°-80°	.0113	.0195	.862	MS122163	
.4375-14	.518	.536	.313	.411	20°-80°	.0129	.0223	1.250	MS122164	
.500 -13	.586	.606	.348	.458	20°-80°	.0139	.0240	1.852	MS122165	
.5625-12	.656	.676	.390	.520	20°-80°	.0150	.0260	2.632	MS122166	
.625 -11	.727	.747	.421	.567	20°-80°	.0164	.0284	3.448	MS122167	
.750 -10	.840	.885	.453	.640	60°-120°	.0180	.0312	5.263	MS122168	
.875 -9	.991	1.026	.500	.734	60°-120°	.0200	.0347	8.333	MS122169	
1.000 -8	1.135	1.170	.526	.761	60°-120°	.0226	.0391	12.500	MS122170	
1.125 -7	1.260	1.315	.557	.843	60°-120°	.0258	.0446	17.464	MS122171	
1.250 -7	1.366	1.416	.679	.937	60°-120°	.0258	.0446	21.653	MS122172	
1.375 -6	1.545	1.598	.689	1.093	60°-120°	.0301	.0521	30.122	MS122173	
1.500 -6	1.676	1.727	.811	1.187	60°-120°	.0301	.0521	36.268	MS122174	

- 1. NOMINAL LENGTH EQUALS BASIC THICKNESS OF PLATE FOR INSERT ASSEMBLY.
- 2. ASSEMBLED LENGTH OF INSERT TO BE AS SPECIFIED ON MS33537.
- 3. NUMBER OF FREE COILS TO BE COUNTED AND ASSEMBLED LENGTH OF INSERT TO BE MEASURED 90° FROM TANG.
- 4. MATERIAL: STEEL, CORROSION RESISTANT, AMS 7245 (MATERIAL AND MPG).
- 5. SURFACE TEXTURE: ANSI B46.1-1962.
- 6. INSERT, WHEN ASSEMBLED IN TAPPED HOLE AS SPECIFIED IN MS33537, SHALL PRODUCE A FINISHED THD MEETING ALL REQUIREMENTS OF MIL-S-7742 AND SHALL ACCEPT EXTERNAL MIL-S-8879 THREADS
- 7. DIMENSIONS IN INCHES.
- 8. IDENTIFICATION: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION ON CONTAINER.
- 9. DO NOT USE UNASSIGNED PART NUMBERS.
- (a) UNNOTCHED INSERTS INACTIVE FOR DESIGN AFTER 15 OCT 1969. USE NOTCHED INSERTS. NOTCHED INSERTS CAN UNIVERSALLY REPLACE THE INACTIVATED INSERTS, BUT THE INACTIVATED INSERTS CANNOT REPLACE THE SUPERSEDING NOTCHED INSERTS.

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P.A. Other Cont	USAP - 11	TITLE	<b>MILITARY STANDARD</b> <b>MS 122156</b> THRU <b>MS 122195</b>
	Army - AV Navy - AS	INSERT, JRES HELICAL COIL COARSE THREAD, 2 DIA NOMINAL LENGTH	
PROCUREMENT SPECIFICATION MIL-I-PR46	SUPERSEDES	MS21208 IN PART	SHEET 2 OF 2

APPROVED 29 May 53  
REVISED A 26 May 59  
R 24 Oct 66  
D FOR CHANGES SEE SHEETS 1 AND 2.