

MIL-S-1222 IS MODIFIED AS FOLLOWS:

ADD NEW PARAGRAPH 3.1.1.1

"TITANIUM ALLOY BARSTOCK USED TO MAKE
TITANIUM FASTENERS SHALL BE UT INSPECTED
AS REQUIRED BY MIL-T-9047"

PARAGRAPH 3.2

DELETE "HEAT TREATMENT SHOULD BE
CONTROLLED IN ACCORDANCE WITH AMS-2750."

PARAGRAPH 3.7 BETWEEN "COATING OR" AND
TREATMENT" ADD "SURFACE".

DELETE PARAGRAPH 3.7.1.3 IN ITS ENTIRETY AND
REPLACE WITH "3.7.1.3 NOT USED."

PARAGRAPH 3.5

TABLE II, UNDER 'ROCKWELL HARDNESS' FOR GRADE
500 NICKEL ALLOYS:
DELETE 'C24 MIN' AND SUBSTITUTE 'C24-35' FOR ALL SIZES.

TABLE III, UNDER 'ROCKWELL HARDNESS' FOR
GRADE 500:
DELETE 'C24 MIN' AND SUBSTITUTE 'C24-35' FOR ALL SIZES.

TABLE IV, UNDER 'ROCKWELL HARDNESS' FOR GRADE
500 NICKEL ALLOYS:
DELETE 'C24 MIN' AND SUBSTITUTE 'C24-35' FOR ALL SIZES.

ADD NEW PARAGRAPH 3.7.4

"3.7.4 HYDROGEN EMBRITTLEMENT RELIEF
AFTER PLATING OR PICKLING.
EXTERNALLY THREADED FASTENERS OF GRADES 410,
416, AND 431, IN THE H CONDITION, AND GRADES
8, 630, A574 AND 4340, IN THE FINAL HEAT
TREATED CONDITION, WHICH ARE ELECTROPLATED OR
EXPOSED TO PICKLING ACIDS OR ANY OTHER

PROCESS THAT MAY INTRODUCE HYDROGEN, SHALL RECEIVE A HYDROGEN EMBRITTLEMENT RELIEF TREATMENT IN ACCORDANCE WITH ASTM B633."

PARAGRAPH 3.9, LINE 5: CHANGE "1/4-INCH" TO "1/2-INCH" IN TWO PLACES.

ADD NEW PARAGRAPH 4.3.1

"4.3.1 ALL TITANIUM FASTENERS SHALL BE 100% PT INSPECTED PER 4.4.5."

PARAGRAPH 4.4.4.1

AT THE END OF THE LAST SENTENCE ADD:

"EXCEPT THE FOLLOWING WEDGE TEST ANGLES SHALL BE USED FOR TITANIUM SOCKET HEAD CAPSCREWS:

1/4 TO 3/8 DIAMETER	-6 DEGREES
1/2 TO 1-3/8 DIAMETER	-4 DEGREES"

TABLE XIV

DELETE "GRADE B16 EXTERNALLY THREADED FASTENERS USED WITH GRADE 4 OR 7 NUT" AND SUBSTITUTE "GRADE B16 EXTERNALLY THREADED FASTENERS USED WITH GRADE 7 NUT."