

MS9209 (ASG)

MARK MS9209 AND MANUFACTURER'S IDENTIFICATION PER AS 478 CLASS A

32  
110  
168  
K  
.070  
.060  
MAXIMUM 2 INCOMPLETE THREADS (SEE NOTE 4)  
CHAMFER .031 x 45° APPROX  
5° MAX  
.150 DIA  
140° MIN  
232 DIA  
250-28 UNJF-3A PER MIL-S-8879  
THIS SURFACE MUST BE SQUARE WITH SHANK WITHIN .003 FIR.  
CHAMFER 30° TO .312 DIA  
40°  
35°  
SECTION THRU THREAD PROFILE

FED SUP CLASS 8304

PART NO	L	K	APPROX WEIGHT LB/100	PART NO	L	K	APPROX WEIGHT LB/100	PART NO	L	K	APPROX WEIGHT LB/100
MS9209-04	.375	.079-.089	1.14	MS9209-22	1.500	.690-.750	2.43	MS9209-40	3.500	2.690-2.750	4.72
MS9209-05	.438	.079-.089	1.21	MS9209-23	1.562	.752-.812	2.50	MS9209-41	3.625	2.815-2.875	4.85
MS9209-06	.500	.079-.089	1.29	MS9209-24	1.625	.815-.875	2.57	MS9209-42	3.750	2.940-3.000	4.99
MS9209-07	.562	.079-.089	1.38	MS9209-25	1.688	.878-.938	2.64	MS9209-43	3.875	3.065-3.125	5.13
MS9209-08	.625	.079-.089	1.44	MS9209-26	1.750	.940-1.000	2.72	MS9209-44	4.000	3.190-3.250	5.27
MS9209-09	.688	.079-.089	1.51	MS9209-27	1.875	1.065-1.125	2.86	MS9209-45	4.125	3.315-3.375	5.42
MS9209-10	.750	.079-.089	1.58	MS9209-28	2.000	1.190-1.250	3.00	MS9209-46	4.250	3.440-3.500	5.56
MS9209-11	.812	.079-.089	1.65	MS9209-29	2.125	1.315-1.375	3.14	MS9209-47	4.375	3.565-3.625	5.71
MS9209-12	.875	.125-.145	1.72	MS9209-30	2.250	1.440-1.500	3.29	MS9209-48	4.500	3.690-3.750	5.85
MS9209-13	.938	.128-.188	1.79	MS9209-31	2.375	1.565-1.625	3.43	MS9209-49	4.625	3.815-3.875	6.00
MS9209-14	1.000	.190-.250	1.86	MS9209-32	2.500	1.690-1.750	3.57	MS9209-50	4.750	3.940-4.000	6.14
MS9209-15	1.062	.252-.312	1.93	MS9209-33	2.625	1.815-1.875	3.71	MS9209-51	4.875	4.065-4.125	6.29
MS9209-16	1.125	.315-.375	2.00	MS9209-34	2.750	1.940-2.000	3.85	MS9209-52	5.000	4.190-4.250	6.43
MS9209-17	1.188	.378-.438	2.08	MS9209-35	2.875	2.065-2.125	4.00	MS9209-53	5.125	4.315-4.375	6.56
MS9209-18	1.250	.440-.500	2.15	MS9209-36	3.000	2.190-2.250	4.14	MS9209-54	5.250	4.440-4.500	6.70
MS9209-19	1.312	.502-.562	2.22	MS9209-37	3.125	2.315-2.375	4.29	MS9209-55	5.375	4.565-4.625	6.84
MS9209-20	1.375	.565-.625	2.29	MS9209-38	3.250	2.440-2.500	4.43	MS9209-56	5.500	4.690-4.750	6.99
MS9209-21	1.438	.628-.688	2.36	MS9209-39	3.375	2.565-2.625	4.58	MS9209-57	5.625	4.815-4.875	7.13
								MS9209-58	5.750	4.940-5.000	7.28
								MS9209-59	5.875	5.065-5.125	7.42
								MS9209-60	6.000	5.190-5.250	7.57

- SHANK SHALL BE STRAIGHT WITHIN .003 FIR. PER INCH OF INLT LENGTH.
- THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .013 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- MATERIAL: STEEL AMS 6304.
- HARDNESS: ROCKWELL C42-46.
- FINISH: DIFFUSED NICKEL-CADMIUM PLATE AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
- MANUFACTURING SPECIFICATION: AMS 7459. PARTS SUBJECT TO MAGNETIC PARTICLE INSPECTION PER AMS 2640 BEFORE PLATING.
- SURFACE ROUGHNESS: AS 291 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES RIPEPT UPST HEAD.
- BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES; LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
- DO NOT USE UNASSIGNED PART NUMBERS.

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P.A	USAF - ASD	TITLE	MILITARY STANDARD
Other Cust	Navy - Mops	BOLT, MACHINE - STEEL AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, .250-28 UNJF-3A	MS9209 (ASG)
PROCUREMENT SPECIFICATION	NONE	SUPERSEDES.	SHEET 1 OF 1

USAF - ASD  
Navy - Mops

REVIEWERS AND USERS:

USAF (Department of the Air Force) and the Department of the Navy, and is mandatory for use by their activity all other military activities are required to comply this standard where applicable

REVISION

APPROVED 10 Dec 63