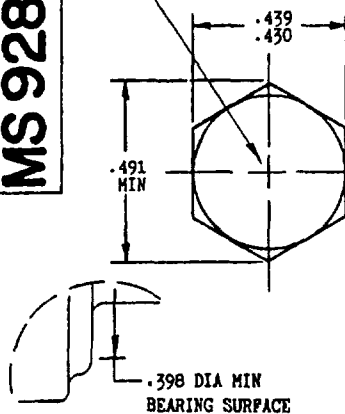
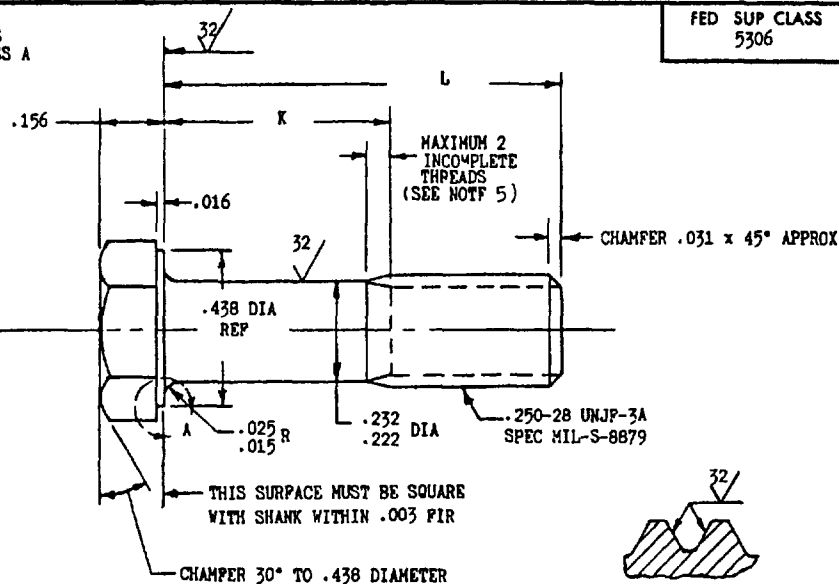


MS 9284 (ASG)MARK MS9284 AND MANUFACTURERS
IDENTIFICATION PER AS478 CLASS AVIEW A
ENLARGED

SECTION THROUGH THREAD PROFILE

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9284-04	.375	.079-.099	1.16	MS9284-31	2.375	1.565-1.625	3.45
MS9284-05	.438	.079-.099	1.23	MS9284-32	2.500	1.690-1.750	3.59
MS9284-06	.500	.079-.099	1.30	MS9284-33	2.625	1.815-1.875	3.73
MS9284-07	.562	.079-.099	1.37	MS9284-34	2.750	1.940-2.000	3.88
MS9284-08	.625	.079-.099	1.44	MS9284-35	2.875	2.065-2.125	4.02
MS9284-09	.688	.079-.099	1.51	MS9284-36	3.000	2.190-2.250	4.16
MS9284-10	.750	.079-.099	1.58	MS9284-37	3.125	2.315-2.375	4.31
MS9284-11	.812	.079-.099	1.66	MS9284-38	3.250	2.440-2.500	4.45
MS9284-12	.875	.079-.125	1.73	MS9284-39	3.375	2.565-2.625	4.60
MS9284-13	.938	.128-.188	1.80	MS9284-40	3.500	2.690-2.750	4.74
MS9284-14	1.000	.190-.250	1.87	MS9284-41	3.625	2.815-2.875	4.88
MS9284-15	1.062	.252-.312	1.94	MS9284-42	3.750	2.940-3.000	5.03
MS9284-16	1.125	.315-.375	2.01	MS9284-43	3.875	3.065-3.125	5.17
MS9284-17	1.188	.378-.438	2.09	MS9284-44	4.000	3.190-3.250	5.31
MS9284-18	1.250	.440-.500	2.16	MS9284-45	4.125	3.315-3.375	5.46
MS9284-19	1.312	.502-.562	2.23	MS9284-46	4.250	3.440-3.500	5.60
MS9284-20	1.375	.565-.625	2.30	MS9284-47	4.375	3.565-3.625	5.74
MS9284-21	1.438	.628-.688	2.37	MS9284-48	4.500	3.690-3.750	5.89
MS9284-22	1.500	.690-.750	2.44	MS9284-49	4.625	3.815-3.875	6.03
MS9284-23	1.562	.752-.812	2.52	MS9284-50	4.750	3.940-4.000	6.17
MS9284-24	1.625	.815-.875	2.59	MS9284-51	4.875	4.065-4.125	6.32
MS9284-25	1.688	.878-.938	2.66	MS9284-52	5.000	4.190-4.250	6.46
MS9284-26	1.750	.940-1.000	2.73	MS9284-53	5.125	4.315-4.375	6.60
MS9284-27	1.875	1.065-1.125	2.87	MS9284-54	5.250	4.440-4.500	6.75
MS9284-28	2.000	1.190-1.250	3.02	MS9284-55	5.375	4.565-4.625	6.89
MS9284-29	2.125	1.315-1.375	3.16	MS9284-56	5.500	4.690-4.750	7.03
MS9284-30	2.250	1.440-1.500	3.30	MS9284-57	5.625	4.815-4.875	7.18
				MS9284-58	5.750	4.940-5.000	7.32
				MS9284-59	5.875	5.065-5.125	7.46
				MS9284-60	6.000	5.190-5.250	7.61

- HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
- SHANK SHALL BE STRAIGHT WITHIN .003 PER INCH OF BOLT 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 HEXAGON SHALL BE WITHIN .013 FIR
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- MATERIAL: STEEL AMS 6322.
- HARDNESS: ROCKWELL C26-32.
- FINISH: BLACK OXIDE TREATMENT AMS 2485.
- MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD MUST BE UPSET
- MAGNETIC PARTICLE INSPECTION PER AMS 2540.
- SURFACE ROUGHNESS: AS 291 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON.
- 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

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER UTILITY PARTS COMMITTEE OF THE SAE.

P.A. USAF - 11	TITLE	MILITARY STANDARD
Other Cust Navy - WP	BOLT, MACHINE-STEEL AMS 6322, BLACK OXIDE, HEXAGON HEAD, .250-28 UNJF-3A	MS9284 (ASG)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1

Review activities:
USAF - 11
Navy - WP

This standard has been approved by the Department of the Air Force (11) and the Department of the Navy and is mandatory for use by that activity. All other military activities are required to employ this standard where suitable.

REVISED
APPROVED 24 Sep 65