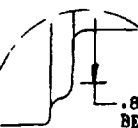
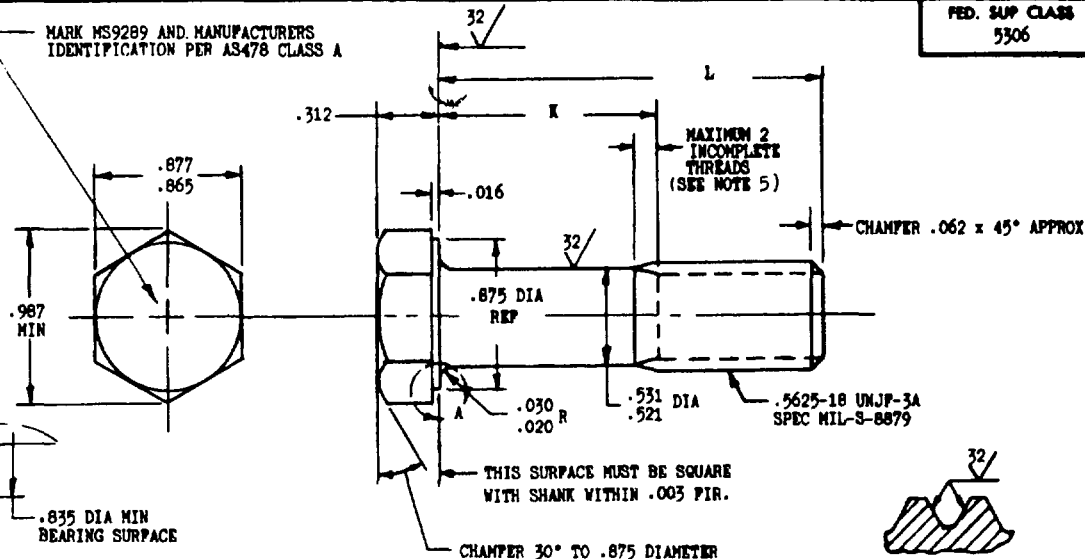


MS9289MARK MS9289 AND MANUFACTURERS
IDENTIFICATION PER AS478 CLASS AFED. SUP CLASS
5306VIEW A
ENLARGED

SECTION THROUGH THREAD PROFILE

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9289-04	.875	.113-.133	11.18	MS9289-31	3.250	1.815-1.875	25.73
MS9289-05	.938	.113-.133	11.56	MS9289-32	3.375	1.940-2.000	26.49
MS9289-06	1.000	.113-.133	11.94	MS9289-33	3.500	2.065-2.125	27.26
MS9289-07	1.062	.113-.133	12.32	MS9289-34	3.625	2.190-2.250	28.02
MS9289-08	1.125	.113-.133	12.70	MS9289-35	3.750	2.315-2.375	28.79
MS9289-09	1.188	.113-.133	13.08	MS9289-36	3.875	2.440-2.500	29.56
MS9289-10	1.250	.113-.133	13.47	MS9289-37	4.000	2.565-2.625	30.32
MS9289-11	1.312	.113-.133	13.85	MS9289-38	4.125	2.690-2.750	31.09
MS9289-12	1.375	.113-.133	14.23	MS9289-39	4.250	2.815-2.875	31.86
MS9289-13	1.438	.113-.133	14.62	MS9289-40	4.375	2.940-3.000	32.62
MS9289-14	1.500	.113-.133	15.00	MS9289-41	4.500	3.065-3.125	33.39
MS9289-15	1.562	.128-.188	15.38	MS9289-42	4.625	3.190-3.250	34.15
MS9289-16	1.625	.190-.250	15.77	MS9289-43	4.750	3.315-3.375	34.92
MS9289-17	1.688	.252-.312	16.15	MS9289-44	4.875	3.440-3.500	35.69
MS9289-18	1.750	.314-.375	16.53	MS9289-45	5.000	3.565-3.625	36.45
MS9289-19	1.812	.378-.438	16.91	MS9289-46	5.125	3.690-3.750	37.22
MS9289-20	1.875	.440-.500	17.30	MS9289-47	5.250	3.815-3.875	37.99
MS9289-21	2.000	.565-.625	18.06	MS9289-48	5.375	3.940-4.000	38.75
MS9289-22	2.125	.690-.750	18.83	MS9289-49	5.500	4.065-4.125	39.52
MS9289-23	2.250	.815-.875	19.60	MS9289-50	5.625	4.190-4.250	40.28
MS9289-24	2.375	.940-1.000	20.36	MS9289-51	5.750	4.315-4.375	41.05
MS9289-25	2.500	1.065-1.125	21.13	MS9289-52	5.875	4.440-4.500	41.82
MS9289-26	2.625	1.190-1.250	21.90	MS9289-53	6.000	4.565-4.625	42.58
MS9289-27	2.750	1.315-1.375	22.66				
MS9289-28	2.875	1.440-1.500	23.43				
MS9289-29	3.000	1.565-1.625	24.19				
MS9289-30	3.125	1.690-1.750	24.96				

(A) INACTIVE FOR DESIGN AFTER 26 OCTOBER 1972.
NO SUPERSEDING STANDARD.

- 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 .002 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 .026 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 2640.
- 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 - AS	BOLT, MACHINE-STEEL AMS 6322, BLACK OXIDE, HEXAGON HEAD, .5625-18 UNJF-3A	MS9289
PROCUREMENT SPECIFICATION NONE	SUPERSEDES,	SHEET 1 OF 1

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 the activity. All other military activities are required to employ this standard where suitable.

Review activities:
USAF - 11
Navy - AS

APPROVED 24 Sept 65
REVISED (A) 26 Oct 72