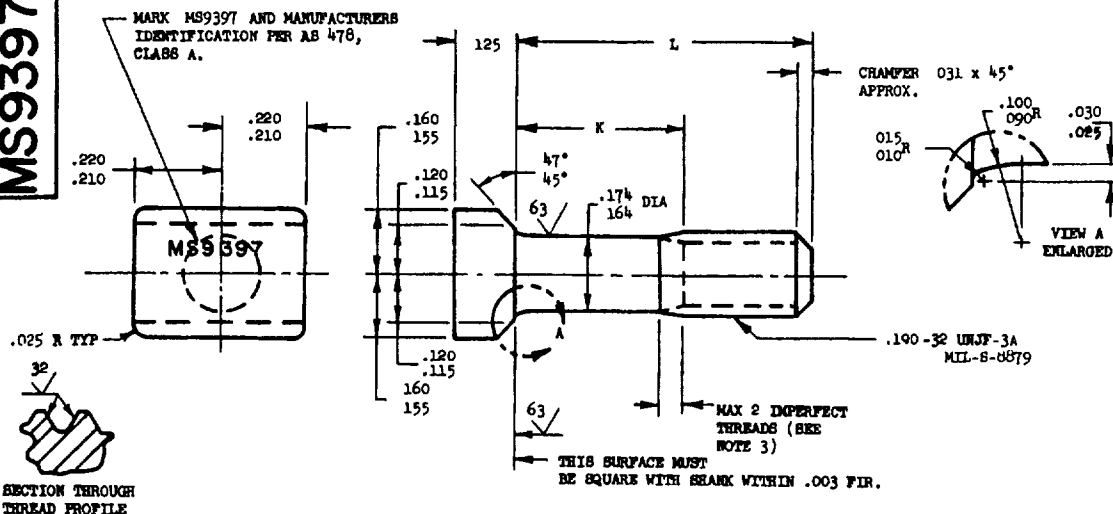


NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever, and the fact that the Government may have furnished, furnished or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner endorsing the holder or any other person or corporation or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

This standard has been approved by the Bufilep (Department of the Navy) and the Department of the USAF and is mandatory for use by both activities. All other military activities are required to employ this standard where suitable.

MS9397 (ASG)



PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9397-04	.375	.114-.134	.62	MS9397-21	1.438	.742-.806	1.31
MS9397-05	.438	.114-.134	.66	MS9397-22	1.500	.810-.870	1.35
MS9397-06	.500	.114-.134	.70	MS9397-23	1.562	.872-.932	1.39
MS9397-07	.562	.114-.134	.74	MS9397-24	1.625	.935-.995	1.43
MS9397-08	.625	.114-.134	.78	MS9397-25	1.688	.998-1.058	1.47
MS9397-09	.688	.114-.134	.82	MS9397-26	1.750	1.060-1.120	1.51
MS9397-10	.750	.114-.134	.86	MS9397-27	1.875	1.185-1.245	1.59
MS9397-11	.812	.122-.182	.90	MS9397-28	2.000	1.310-1.370	1.67
MS9397-12	.875	.185-.245	.94	MS9397-29	2.125	1.435-1.495	1.75
MS9397-13	.938	.248-.308	.98	MS9397-30	2.250	1.560-1.620	1.83
MS9397-14	1.000	.310-.370	1.03	MS9397-31	2.375	1.685-1.745	1.91
MS9397-15	1.062	.372-.432	1.07	MS9397-32	2.500	1.810-1.870	1.99
MS9397-16	1.125	.435-.495	1.11	MS9397-33	2.625	1.935-1.995	2.07
MS9397-17	1.188	.498-.558	1.15	MS9397-34	2.750	2.060-2.120	2.16
MS9397-18	1.250	.560-.620	1.19	MS9397-35	2.875	2.185-2.245	2.24
MS9397-19	1.312	.622-.682	1.23	MS9397-36	3.000	2.310-2.370	2.32
MS9397-20	1.375	.685-.745	1.27				

1. SHANK SHALL BE STRAIGHT WITHIN .003 FIR PER INCH OF BOLT LENGTH.
 2. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
 3. INCOMPLETE THREADS NOT TO ENTER THE FILLET AREA.
 4. HEAD TO SHANK FILLET SHALL BE COLD ROLLED.
 5. MATERIAL STEEL AMS 6322 HARDNESS ROCKWELL C26-32
 6. FINISH CADMIUM PLATE AMS 2400 DIMENSIONS SPECIFIED ARE AFTER PLATING
 7. SURFACE ROUGHNESS AS R91 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT UPSET .FAD.
 8. MANUFACTURING SPECIFICATION AMS 7452 EXCEPT HEAD MUST BE UPSET.
 9. PART SUBJECT TO MAGNETIC PARTICLE INSPECTION PER AMS 2640
 10. BREAK SHARP EDGES .003 - .015 UNLESS OTHERWISE SPECIFIED
 11. DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED. TOLERANCES LINEAR DIMENSIONS ± .010,
 12. DO NOT USE UNASSIGNED PART NUMBERS.
- AS, AND AMS ARE SAE PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER UTILITY PARTS COMMITTEE OF THE SAE

P.A. USAF - AFSC	TITLE	MILITARY STANDARD
Other Cust Navy - Wep	BOLT, TEE HEAD - AMS 6322, CHAMFERED, .190-32 UNJF-3A, CADMIUM PLATE	MS9397 (ASG)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1