

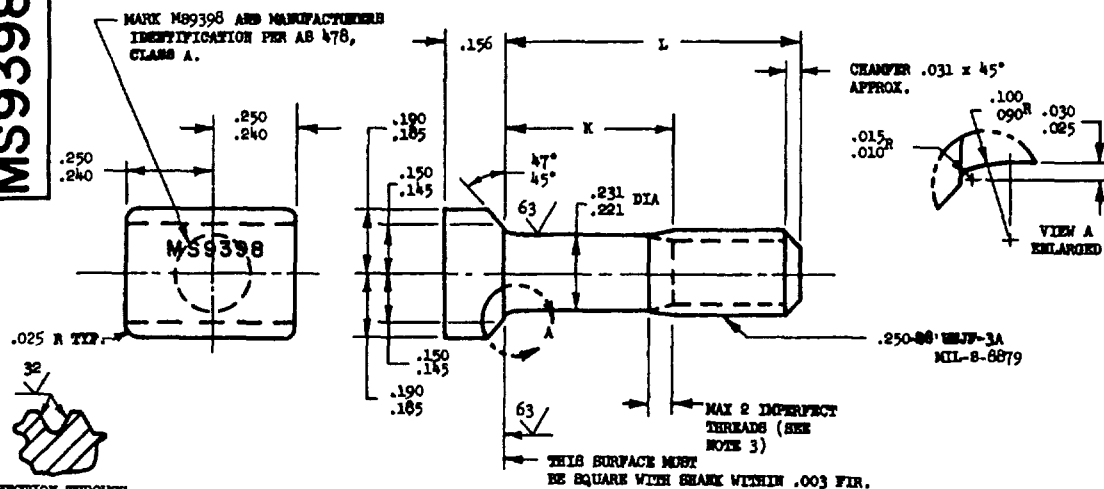
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This standard has been approved by the BuAmp (Department of the Navy) and the Department of the USAF and is mandatory for use by all military activities are required to employ this standard where suitable.

MS9398 (ASG)



SECTION THROUGH
THREAD PROFILE



PART NUMBER	L	K	APPROX. WEIGHT LB/100	PART NUMBER	L	K	APPROX. WEIGHT LB/100
MS9398-05	.438	.121-.141	1.25	MS9398-31	2.375	1.565-1.625	3.47
MS9398-06	.500	.121-.141	1.32	MS9398-32	2.500	1.690-1.750	3.61
MS9398-07	.562	.121-.141	1.39	MS9398-33	2.625	1.815-1.875	3.75
MS9398-08	.625	.121-.141	1.46	MS9398-34	2.750	1.940-2.000	3.90
MS9398-09	.688	.121-.141	1.53	MS9398-35	2.875	2.065-2.125	4.04
MS9398-10	.750	.121-.141	1.60	MS9398-36	3.000	2.190-2.250	4.18
MS9398-11	.812	.121-.141	1.68	MS9398-37	3.125	2.315-2.375	4.32
MS9398-12	.875	.121-.141	1.75	MS9398-38	3.250	2.440-2.500	4.47
MS9398-13	.938	.128-.188	1.82	MS9398-39	3.375	2.565-2.625	4.62
MS9398-14	1.000	.190-.250	1.89	MS9398-40	3.500	2.690-2.750	4.76
MS9398-15	1.062	.252-.312	1.96	MS9398-41	3.625	2.815-2.875	4.90
MS9398-16	1.125	.315-.375	2.03	MS9398-42	3.750	2.940-3.000	5.05
MS9398-17	1.188	.378-.438	2.11	MS9398-43	3.875	3.065-3.125	5.19
MS9398-18	1.250	.440-.500	2.18	MS9398-44	4.000	3.190-3.250	5.33
MS9398-19	1.312	.502-.562	2.25	MS9398-45	4.125	3.315-3.375	5.48
MS9398-20	1.375	.565-.625	2.32	MS9398-46	4.250	3.440-3.500	5.62
MS9398-21	1.438	.628-.688	2.39	MS9398-47	4.375	3.565-3.625	5.76
MS9398-22	1.500	.690-.750	2.46	MS9398-48	4.500	3.690-3.750	5.91
MS9398-23	1.562	.752-.812	2.54	MS9398-49	4.625	3.815-3.875	6.05
MS9398-24	1.625	.815-.875	2.61	MS9398-50	4.750	3.940-4.000	6.19
MS9398-25	1.688	.878-.938	2.68	MS9398-51	4.875	4.065-4.125	6.34
MS9398-26	1.750	.940-1.000	2.75	MS9398-52	5.000	4.190-4.250	6.48
MS9398-27	1.875	1.065-1.125	2.89	MS9398-53	5.125	4.315-4.375	6.62
MS9398-28	2.000	1.190-1.250	3.04	MS9398-54	5.250	4.440-4.500	6.77
MS9398-29	2.125	1.315-1.375	3.18	MS9398-55	5.375	4.565-4.625	6.91
MS9398-30	2.250	1.440-1.500	3.32	MS9398-56	5.500	4.690-4.750	7.05

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 291 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
 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 $\pm .010$
 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	BOLT, THE HEAD - AMS 6322, CHAMFERED, .250-28 UNJF-3A, CADMIUM PLATE	MS9398 (ASG)
Naval - Wep		
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1