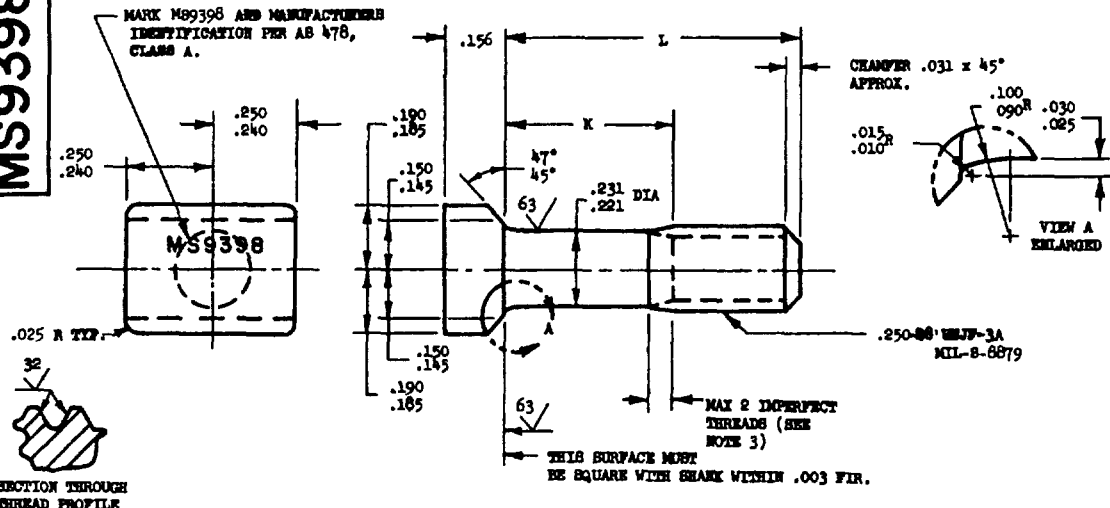


NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever, and the fact that the Government may have furnished, 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 favoring 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 BuAmp (Department of the Navy) and the Department of the USN and is mandatory for use by the Navy. All other military activities are required to employ this standard where suitable.

MS9398 (ASG)

FED SUP CLASS
5306



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	1.812	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 ±.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 MS9398 (ASG)
Other Cust Navy - Wep	BOLT, THE HEAD - AMS 6322, CHAMFERED, .250-28-UNJF-3A, CADMIUM PLATE	
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1

APPROVED 9 MAY 62 REVISED