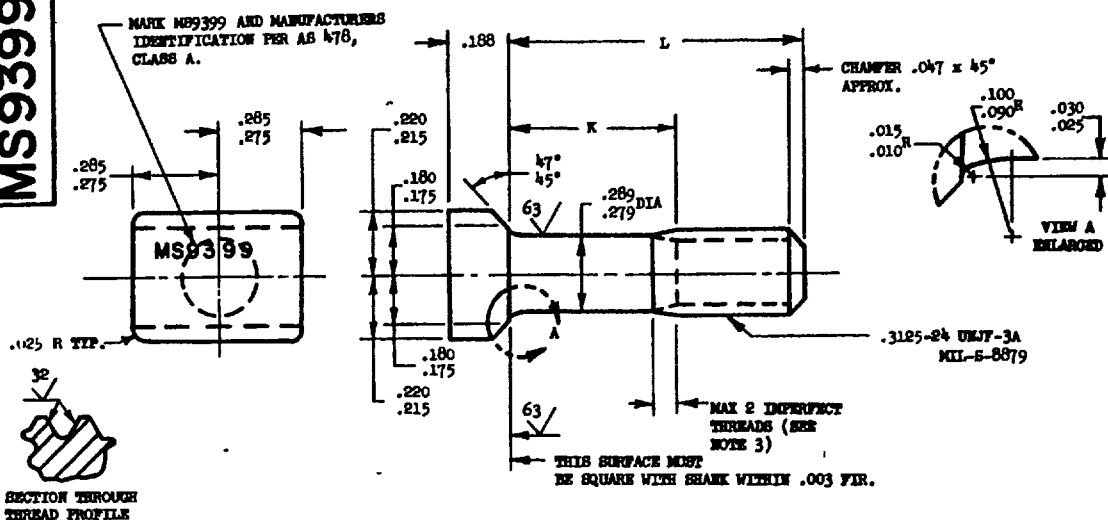


NOTES.—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government hereby incurs no responsibility, nor any obligation whatsoever, and the fact that the Government may 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 licensing 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 Bureau (Department of the Navy) and the Department of the USAF and is mandatory for use by that activity. All other military activities are requested to employ this standard where suitable.

# MS9399 (ASG)

FED. SUP CLASS  
5306



SECTION THROUGH  
THREAD PROFILE

PART NUMBER	L	K	APPROX. WEIGHT LB/100	PART NUMBER	L	K	APPROX. WEIGHT LB/100
MB9399-04	.500	.130-.150	2.17	MB9399-31	2.625	1.690-1.750	6.00
MB9399-05	.562	.130-.150	2.28	MB9399-32	2.750	1.815-1.875	6.22
MB9399-06	.625	.130-.150	2.39	MB9399-33	2.875	1.940-2.000	6.45
MB9399-07	.688	.130-.150	2.50	MB9399-34	3.000	2.065-2.125	6.67
MB9399-08	.750	.130-.150	2.61	MB9399-35	3.125	2.190-2.250	6.90
MB9399-09	.812	.130-.150	2.72	MB9399-36	3.250	2.315-2.375	7.13
MB9399-10	.875	.130-.150	2.84	MB9399-37	3.375	2.440-2.500	7.35
MB9399-11	.938	.130-.150	2.95	MB9399-38	3.500	2.565-2.625	7.58
MB9399-12	1.000	.130-.150	3.06	MB9399-39	3.625	2.690-2.750	7.80
MB9399-13	1.062	.130-.150	3.18	MB9399-40	3.750	2.815-2.875	8.03
MB9399-14	1.125	.190-.250	3.29	MB9399-41	3.875	2.940-3.000	8.25
MB9399-15	1.188	.252-.312	3.40	MB9399-42	4.000	3.065-3.125	8.48
MB9399-16	1.250	.315-.375	3.51	MB9399-43	4.125	3.190-3.250	8.71
MB9399-17	1.312	.378-.438	3.63	MB9399-44	4.250	3.315-3.375	8.93
MB9399-18	1.375	.440-.500	3.74	MB9399-45	4.375	3.440-3.500	9.16
MB9399-19	1.438	.502-.562	3.85	MB9399-46	4.500	3.565-3.625	9.38
MB9399-20	1.500	.565-.625	3.97	MB9399-47	4.625	3.690-3.750	9.61
MB9399-21	1.562	.628-.688	4.08	MB9399-48	4.750	3.815-3.875	9.83
MB9399-22	1.625	.690-.750	4.19	MB9399-49	4.875	3.940-4.000	10.06
MB9399-23	1.688	.752-.812	4.30	MB9399-50	5.000	4.065-4.125	10.29
MB9399-24	1.750	.815-.875	4.42	MB9399-51	5.125	4.190-4.250	10.51
MB9399-25	1.875	.940-1.000	4.54	MB9399-52	5.250	4.315-4.375	10.74
MB9399-26	2.000	1.065-1.125	4.67	MB9399-53	5.375	4.440-4.500	10.96
MB9399-27	2.125	1.190-1.250	5.09	MB9399-54	5.500	4.565-4.625	11.19
MB9399-28	2.250	1.315-1.375	5.32	MB9399-55	5.625	4.690-4.750	11.41
MB9399-29	2.375	1.440-1.500	5.55	MB9399-56	5.750	4.815-4.875	11.64
MB9399-30	2.500	1.565-1.625	5.77	MB9399-57	5.875	4.940-5.000	11.86
				MB9399-58	6.000	5.065-5.125	12.09

- SHANK SHALL BE STRAIGHT WITHIN .003 FIR, PER INCH OF BOLT LENGTH.
  - THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
  - INCOMPLETE THREADS NOT TO ENTER THE FILLET AREA.
  - HEAD TO SHANK FILLET SHALL BE COLD ROLLED.
  - MATERIAL: STEEL AMS 6322 HARDNESS: ROCKWELL C26-32.
  - FINISH: CADMIUM PLATE AMS 2400 DIMENSIONS SPECIFIED ARE AFTER PLATING.
  - SURFACE ROUGHNESS: AS 291 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICRONS EXCEPT UPSET HEAD.
  - MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD MUST BE UPSET.
  - PART SUBJECT TO MAGNETIC PARTICLE INSPECTION PER AMS 2640.
  - BREAK SHARP EDGES .003 - .015 UNLESS OTHERWISE SPECIFIED.
  - DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED. TOLERANCES: LINEAR DIMENSIONS  $\pm .010$ .
  - 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 - Nop	BOLT, THE HEAD - AMS 6322, CHAMFERED, .3125-24 UNJT-3A, CADMIUM PLATE	<b>MS9399 (ASG)</b>
PROCUREMENT SPECIFICATION NOTE	SUPERSEDES:	SHEET 1 OF 1