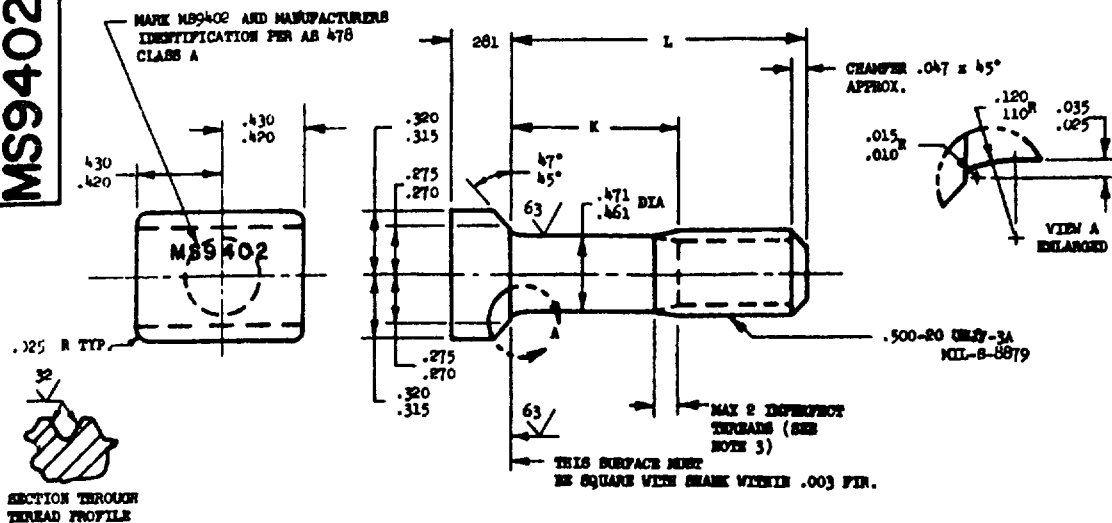


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This standard has been approved by the Board (Department of the Navy) and the Department of the USAF and is mandatory for use by their activity. All other activity is required to comply with standard when variable.

**MS9402 (ASG)**

FED SUP CLASS  
5306



PART NUMBER	L	K	APPROX. WEIGHT LB/100	PART NUMBER	L	K	APPROX. WEIGHT LB/100
MS9402-05	.875	.155-.175	8.41	MS9402-31	3.250	1.940-2.000	19.89
MS9402-06	.938	.155-.175	8.71	MS9402-32	3.375	2.065-2.125	20.50
MS9402-07	1.000	.155-.175	9.01	MS9402-33	3.500	2.190-2.250	21.10
MS9402-08	1.062	.155-.175	9.32	MS9402-34	3.625	2.315-2.375	21.70
MS9402-09	1.125	.155-.175	9.62	MS9402-35	3.750	2.440-2.500	22.31
MS9402-10	1.188	.155-.175	9.92	MS9402-36	3.875	2.565-2.625	22.91
MS9402-11	1.250	.155-.175	10.22	MS9402-37	4.000	2.690-2.750	23.52
MS9402-12	1.312	.155-.175	10.53	MS9402-38	4.125	2.815-2.875	24.12
MS9402-13	1.375	.155-.175	10.83	MS9402-39	4.250	2.940-3.000	24.72
MS9402-14	1.438	.155-.175	11.13	MS9402-40	4.375	3.065-3.125	25.33
MS9402-15	1.500	.190-.250	11.43	MS9402-41	4.500	3.190-3.250	25.93
MS9402-16	1.562	.252-.312	11.73	MS9402-42	4.625	3.315-3.375	26.54
MS9402-17	1.625	.315-.375	12.04	MS9402-43	4.750	3.440-3.500	27.14
MS9402-18	1.688	.378-.438	12.34	MS9402-44	4.875	3.565-3.625	27.75
MS9402-19	1.750	.440-.500	12.64	MS9402-45	5.000	3.690-3.750	28.35
MS9402-20	1.875	.565-.625	13.24	MS9402-46	5.125	3.815-3.875	28.95
MS9402-21	2.000	.690-.750	13.85	MS9402-47	5.250	3.940-4.000	29.56
MS9402-22	2.125	.815-.875	14.45	MS9402-48	5.375	4.065-4.125	30.16
MS9402-23	2.250	.940-1.000	15.06	MS9402-49	5.500	4.190-4.250	30.77
MS9402-24	2.375	1.065-1.125	15.66	MS9402-50	5.625	4.315-4.375	31.37
MS9402-25	2.500	1.190-1.250	16.27	MS9402-51	5.750	4.440-4.500	31.98
MS9402-26	2.625	1.315-1.375	16.87	MS9402-52	5.875	4.565-4.625	32.58
MS9402-27	2.750	1.440-1.500	17.47	MS9402-53	6.000	4.690-4.750	33.18
MS9402-28	2.875	1.565-1.625	18.08				
MS9402-29	3.000	1.690-1.750	18.68				
MS9402-30	3.125	1.815-1.875	19.29				

1. SHANK SHALL BE STRAIGHT WITHIN .003 FIR PER INCH OF BOLT LENGTH.
  2. THE CONCENTRICITY OF THREAD ID 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.

PA USAF - AFSC	TITLE	MILITARY STANDARD
Other Cust	BOLT, THE HEAD - AMS 6322, CHAMFERED, .500-20 UNF-3A,	MS9402 (ASG)
Navy - Me.	CADMIUM PLATE	
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 1