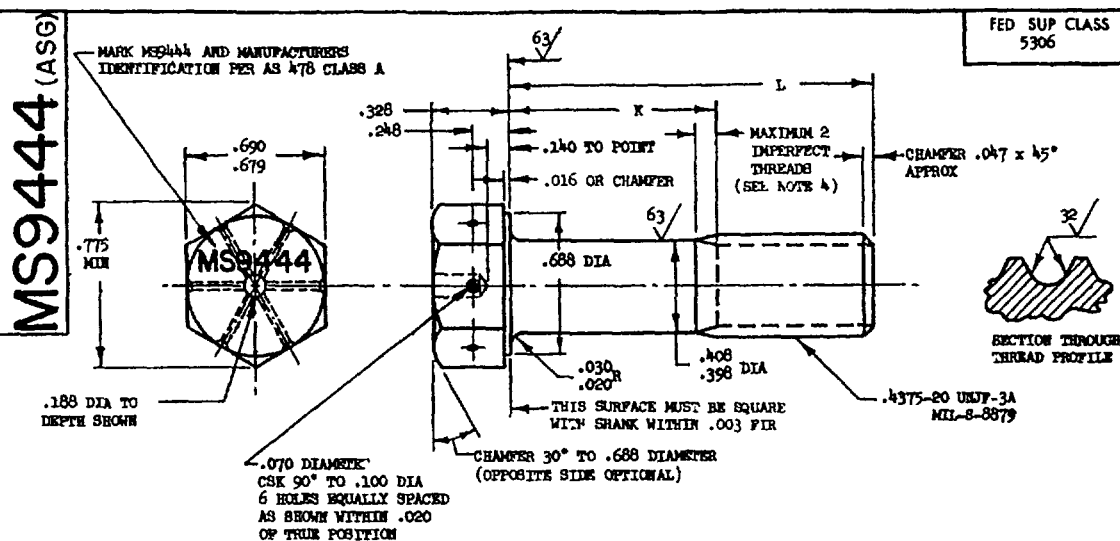


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This standard has been approved by the Department of the Navy and is mandatory for use by the Navy. All other military activities are required to employ this standard where suitable.



PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9444-04	.688	.105-.125	6.43	MS9444-32	3.125	1.940-2.000	15.33
MS9444-05	.750	.105-.125	6.69	MS9444-33	3.250	2.065-2.125	15.78
MS9444-06	.812	.105-.125	6.91	MS9444-34	3.375	2.190-2.250	16.24
MS9444-07	.875	.105-.125	7.14	MS9444-35	3.500	2.315-2.375	16.69
MS9444-08	.938	.105-.125	7.37	MS9444-36	3.625	2.440-2.500	17.15
MS9444-09	1.000	.105-.125	7.60	MS9444-37	3.750	2.565-2.625	17.60
MS9444-10	1.062	.105-.125	7.82	MS9444-38	3.875	2.690-2.750	18.05
MS9444-11	1.125	.105-.125	8.05	MS9444-39	4.000	2.815-2.875	18.51
MS9444-12	1.188	.105-.125	8.28	MS9444-40	4.125	2.940-3.000	18.96
MS9444-13	1.250	.125-.145	8.50	MS9444-41	4.250	3.065-3.125	19.42
MS9444-14	1.312	.125-.168	8.73	MS9444-42	4.375	3.190-3.250	19.87
MS9444-15	1.375	.150-.250	8.96	MS9444-43	4.500	3.315-3.375	20.33
MS9444-16	1.438	.252-.312	9.19	MS9444-44	4.625	3.440-3.500	20.78
MS9444-17	1.500	.315-.375	9.41	MS9444-45	4.750	3.565-3.625	21.24
MS9444-18	1.562	.378-.438	9.64	MS9444-46	4.875	3.690-3.750	21.69
MS9444-19	1.625	.440-.500	9.87	MS9444-47	5.000	3.815-3.875	22.15
MS9444-20	1.688	.502-.562	10.10	MS9444-48	5.125	3.940-4.000	22.60
MS9444-21	1.750	.565-.625	10.24	MS9444-49	5.250	4.065-4.125	23.06
MS9444-22	1.875	.690-.750	10.70	MS9444-50	5.375	4.190-4.250	23.51
MS9444-23	2.000	.815-.875	11.23	MS9444-51	5.500	4.315-4.375	23.97
MS9444-24	2.125	.940-1.000	11.69	MS9444-52	5.625	4.440-4.500	24.42
MS9444-25	2.250	1.065-1.125	12.14	MS9444-53	5.750	4.565-4.625	24.88
MS9444-26	2.375	1.190-1.250	12.60	MS9444-54	5.875	4.690-4.750	25.33
MS9444-27	2.500	1.315-1.375	13.05	MS9444-55	6.000	4.815-4.875	25.79
MS9444-28	2.625	1.440-1.500	13.51				
MS9444-29	2.750	1.565-1.625	13.96				
MS9444-30	2.875	1.690-1.750	14.42				
MS9444-31	3.000	1.815-1.875	14.87				

- SHANK SHALL BE STRAIGHT WITHIN .0025 FIR PER INCH OF BOLT LENGTH.
- THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND HEXAGON SHALL BE WITHIN .019 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET AREA.
- MATERIAL STEEL AMS 6304.
- HARDNESS ROCKWELL C42-46.
- FINISH DIFFUSED NICKEL-CADMIUM PLATE AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING CONTACT POINTS PERMISSIBLE PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
- MANUFACTURING SPECIFICATION. AMS 7455. PARTS SUBJECT TO MAGNETIC PARTICLE INSPECTION PER AMS 2640 BEFORE PLATING.
- SURFACE ROUGHNESS. AS 291, UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON.
- BREAK SHARP EDGES .003 - .015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED. TOLERANCES; LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
- TRUE POSITION TOLERANCES SPECIFIED ARE FOR MAXIMUM MATERIAL CONDITION.
- DO NOT USE UNASSIGNED PART NUMBERS.

AS & 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, MACHINE - STEEL AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, HEXAGON HEAD, DRILLED, .4375-20 UNF-3A	MS9444 (ASG)
PROCUREMENT SPECIFICATION NAME	SUPERSEDES		SHEET 1 OF 1