

### USER ACTIVITIES:

**REVIEWER ACTIVITIES:**  
**AIR FORCE - 82**  
**DLA-15**

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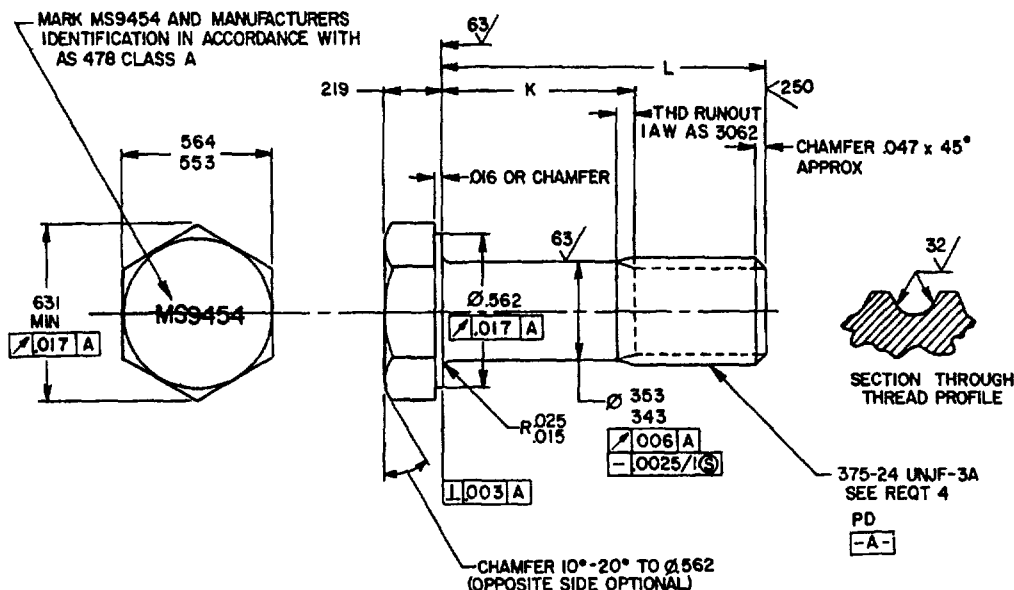


TABLE I. DASH NUMBERS AND DIMENSIONS.

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
				-31	2.875	1.815-1.875	9.41
				-32	3.000	1.940-2.000	9.74
				-33	3.125	2.065-2.125	10.08
-04	.625	.088-.108	3.35	-34	3.250	2.190-2.250	10.41
-05	.688	.088-.108	3.52	-35	3.375	2.315-2.375	10.75
-06	.750	.088-.108	3.69	-36	3.500	2.440-2.500	11.09
-07	.812	.088-.108	3.86	-37	3.625	2.565-2.625	11.42
-08	.875	.088-.108	4.03	-38	3.750	2.690-2.750	11.76
-09	.938	.088-.108	4.20	-39	3.875	2.815-2.875	12.09
-10	1.000	.088-.108	4.37	-40	4.000	2.940-3.000	12.43
-11	1.062	.088-.108	4.53	-41	4.125	3.065-3.125	12.77
-12	1.125	.125-.145	4.70	-42	4.250	3.190-3.250	13.10
-13	1.188	.128-.188	4.87	-43	4.375	3.315-3.375	13.44
-14	1.250	.190-.250	5.04	-44	4.500	3.440-3.500	13.77
-15	1.312	.252-.312	5.21	-45	4.625	3.565-3.625	14.11
-16	1.375	.315-.375	5.37	-46	4.750	3.690-3.750	14.45
-17	1.438	.378-.438	5.54	-47	4.875	3.815-3.875	14.78
-18	1.500	.440-.500	5.71	-48	5.000	3.940-4.000	15.12
-19	1.562	.502-.562	5.88	-49	5.125	4.065-4.125	15.45
-20	1.625	.565-.625	6.05	-50	5.250	4.190-4.250	15.79
-21	1.688	.628-.688	6.21	-51	5.375	4.315-4.375	16.13
-22	1.750	.690-.750	6.38	-52	5.500	4.440-4.500	16.46
-23	1.875	.815-.875	6.72	-53	5.625	4.565-4.625	16.80
-24	2.000	.940-1.000	7.05	-54	5.750	4.690-4.750	17.13
-25	2.125	1.065-1.125	7.39	-55	5.875	4.815-4.875	17.47
-26	2.250	1.190-1.250	7.73	-56	6.000	4.940-5.000	17.81
-27	2.375	1.315-1.375	8.06				
-28	2.500	1.440-1.500	8.40				
-29	2.625	1.565-1.625	8.73				
-30	2.750	1.690-1.750	9.07				

Ⓐ ENTIRE STANDARD REVISED

P. A. <b>NAVY-AS</b> Other Cust	INTERNATIONAL INTEREST	TITLE <b>BOLT, MACHINE, HEXAGON HEAD,          STEEL, .375-24 UNJF-3A</b>	<b>MILITARY STANDARD</b>
<b>AIR FORCE-II</b>			<b>MS 9454</b>
PROCUREMENT SPECIFICATION	SUPERSEDES:	PAGE 1 OF 2	

USER ACTIVITIES

REVIEWER ACTIVITIES  
AIR FORCE-82  
DLA-IS

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

FED SUP CLASS  
5306

## REQUIREMENTS:

1. **MATERIAL:** STEEL, IN ACCORDANCE WITH AMS 6304.
2. **PROTECTIVE COATING AND SURFACE TREATMENT:** DIFFUSED NICKEL-CADMIUM PLATE IN ACCORDANCE WITH AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
3. **HARDNESS:** RC42-46 MAXIMUM.
4. **THREADS:** THREADS IN ACCORDANCE WITH MIL-S-8879.
5. **MANUFACTURING:** MANUFACTURING IN ACCORDANCE WITH AMS 7455-80. PARTS SUBJECT TO MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640-83 BEFORE PLATING.
6. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
7. **SURFACE TEXTURE:** SURFACE TEXTURE IN ACCORDANCE WITH AS 291-64; UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON.
8. **MARKING:** MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478-79 CLASS A.
9. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS9454-04

DASH NUMBER

BASIC MS NUMBER

MS9454-04 INDICATES: BOLT, MACHINE-STEEL AMS 6304, DIFFUSED  
NICKEL-CADMIUM PLATED, HEXAGON HEAD,  
.375-24 UNJF-3A, LENGTH .625

## NOTES:

1. ALL DIMENSIONS IN INCHES.
2. UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
3. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
4. DO NOT USE UNASSIGNED PART NUMBERS.
5. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
6. REFERENCED GOVERNMENT (OR NONGOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DoDISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
7. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
8. AS AND AMS ARE SAE PUBLICATIONS.

APPROVED 21 DEC 62 REVISED (A) FOR CHANGES SEE PAGES 1 AND 2

P A NAVY-AS Other Cost	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE, HEXAGON HEAD, STEEL, .375-24 UNJF-3A	MILITARY STANDARD
AIR FORCE-II			MS 9454
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 2 OF 2	