

INCH-POUND

MS9459C  
27 OCTOBER 95  
SUPERSEDING  
MS9459B  
31 MARCH 86

## MILITARY SPECIFICATION SHEET

BOLT, MACHINE-STEEL, AMS 6304, DIFFUSED  
NICKEL-CADMIUM PLATED HEXAGO HEAD,  
.750-16 UNJF-3A

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS  
AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST  
OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING DOCUMENT  
LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS  
AND STANDARDS (DDOISS) SPECIFIED IN THE SOLICITATION: (SEE REQ. 13)

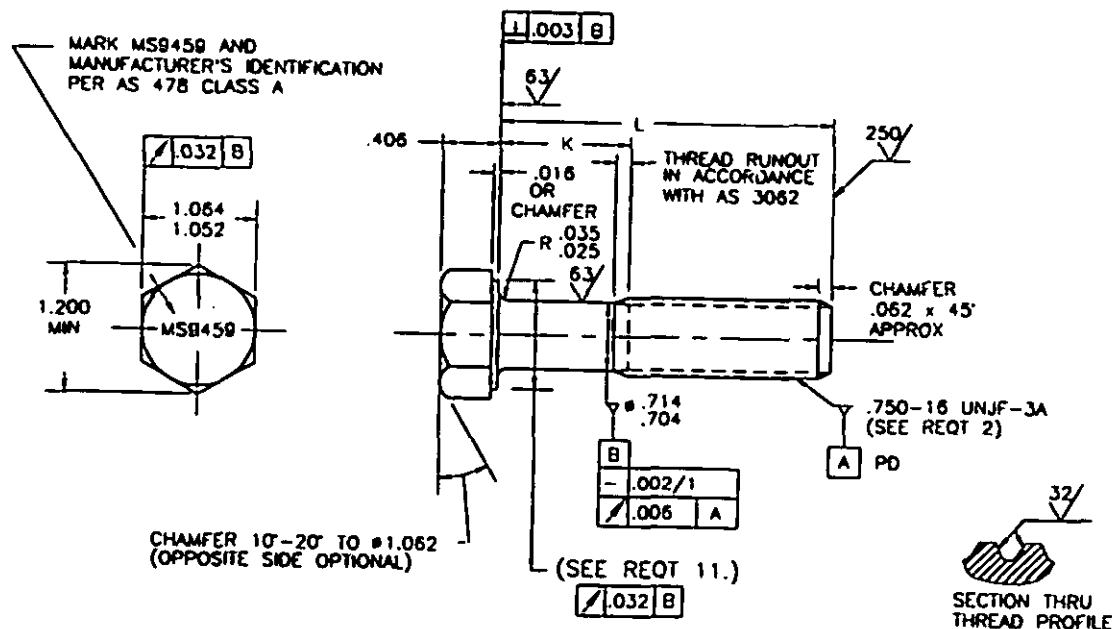


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-06	1.250	.129-.149	25.04	-31	3.625	1.815-1.875	51.47
-07	1.312	.129-.149	25.74	-32	3.750	1.940-2.000	52.86
-08	1.375	.129-.149	26.43	-33	3.875	2.065-2.125	54.25
-09	1.438	.129-.149	27.13	-34	4.000	2.190-2.250	55.64
-10	1.500	.129-.149	27.82	-35	4.125	2.315-2.375	57.03
-11	1.562	.129-.149	28.52	-36	4.250	2.440-2.500	58.42
-12	1.625	.129-.149	29.22	-37	4.375	2.565-2.625	59.81
-13	1.688	.129-.149	29.91	-38	4.500	2.690-2.750	61.20
-14	1.750	.129-.149	30.61	-39	4.625	2.815-2.875	62.59
-15	1.812	.129-.149	31.30	-40	4.750	2.940-3.000	63.98
-16	1.875	.129-.149	32.00	-41	4.875	3.065-3.125	65.37
-17	1.938	.168-.188	32.69	-42	5.000	3.190-3.250	66.76
-18	2.000	.190-.250	33.39	-43	5.125	3.315-3.375	68.15
-19	2.125	.315-.375	34.78	-44	5.250	3.440-3.500	69.54
-20	2.250	.440-.500	36.17	-45	5.375	3.565-3.625	70.93
-21	2.375	.565-.625	37.56	-46	5.500	3.690-3.750	72.33
-22	2.500	.690-.750	38.95	-47	5.625	3.815-3.875	73.72
-23	2.625	.815-.875	40.34	-48	5.750	3.940-4.000	75.11
-24	2.750	.940-1.000	41.73	-49	5.875	4.065-4.125	76.50
-25	2.875	1.065-1.125	43.12	-50	6.000	4.190-4.250	77.89
-26	3.000	1.190-1.250	44.51				
-27	3.125	1.315-1.375	45.90				
-28	3.200	1.440-1.500	47.29				
-29	3.375	1.565-1.625	48.68				
-30	3.500	1.690-1.750	50.08				

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ASMC N/A

1 OF 2

FSC 5306

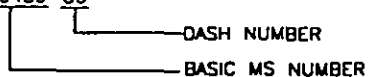
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## REQUIREMENTS:

1. MATERIAL: STEEL IN ACCORDANCE WITH AMS 6304.
2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879.
3. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ASME Y14.5M.
4. HEAD TO SHANK FILLET: HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
5. MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640 BEFORE PLATING.
6. HARDNESS: ROCKWELL C42-46.
7. FINISH: FINISH SHALL BE DIFFUSED NICKEL-CADMIUM PLATE IN ACCORDANCE WITH AMS 2416. DIMENSIONS SPECIFIED ARE MET AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
8. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI/ASME B46.1.
9. TOLERANCE: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
10. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. BEARING SURFACE: BEARING SURFACE SHALL BE FLAT AND WASHER FACED. DIAMETER OF BEARING SURFACE SHALL BE EQUAL TO THE MAXIMUM WIDTH ACROSS FLATS WITHIN A TOLERANCE OF MINUS 10% IN ACCORDANCE WITH ANSI B18.2.1.
12. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS9459-06



MS9459-06 INDICATES: BOLT, MACHINE - STEEL, AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, HEXAGON HEAD, .750-16 UNJF-3A, LENGTH 1.250.

13. PROCUREMENT SPECIFICATION: AMS 7452.

## NOTES:

1. ALL DIMENSIONS IN INCHES.
2. DO NOT USE UNASSIGNED PART NUMBERS.
3. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.
4. UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION.
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
6. AS AND AMS ARE SAE PUBLICATIONS.

## MILITARY INTERESTS

CUSTODIANS

NAVY - AS

AIR FORCE - 11

REVIEWER:

AIR FORCE - 82

## PREPARING ACTIVITY

DLA-IS

(PROJECT: 5306-1B80)