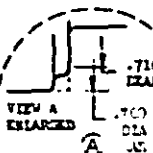
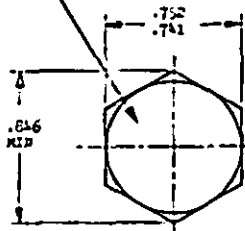


MS9494

FACE PART F RIBS AND FACE PART RIBS
IDENTIFICATION FOR AS 470 CLASS A

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9494-04	.012	.105-.125	8.35	MS9494-31	3.250	1.540-2.000	21.51
MS9494-05	.075	.105-.125	8.73	MS9494-32	3.375	2.065-2.125	22.60
MS9494-06	.913	.105-.125	9.08	MS9494-33	3.500	2.190-2.250	23.30
MS9494-07	1.000	.105-.125	9.41	MS9494-34	3.625	2.315-2.375	24.99
MS9494-08	1.062	.105-.125	9.77	MS9494-35	3.750	2.440-2.500	26.60
MS9494-09	1.125	.105-.125	10.12	MS9494-36	3.875	2.565-2.625	28.38
MS9494-10	1.188	.105-.125	10.47	MS9494-37	4.000	2.690-2.750	29.07
MS9494-11	1.250	.105-.125	10.81	MS9494-38	4.125	2.815-2.875	30.76
MS9494-12	1.312	.105-.125	11.16	MS9494-39	4.250	2.940-3.000	32.46
MS9494-13	1.375	.105-.125	11.51	MS9494-40	4.375	3.065-3.125	34.16
MS9494-14	1.438	.125-.188	11.86	MS9494-41	4.500	3.190-3.250	35.85
MS9494-15	1.500	.190-.250	12.20	MS9494-42	4.625	3.315-3.375	37.54
MS9494-16	1.562	.252-.312	12.54	MS9494-43	4.750	3.440-3.500	39.23
MS9494-17	1.625	.315-.375	12.89	MS9494-44	4.875	3.565-3.625	40.92
MS9494-18	1.688	.378-.438	13.24	MS9494-45	5.000	3.690-3.750	42.62
MS9494-19	1.750	.440-.500	13.59	MS9494-46	5.125	3.815-3.875	44.31
MS9494-20	1.813	.565-.625	14.23	MS9494-47	5.250	3.940-4.000	46.00
MS9494-21	2.000	.625-.750	14.97	MS9494-48	5.375	4.065-4.125	47.70
MS9494-22	2.125	.615-.875	15.61	MS9494-49	5.500	4.190-4.250	49.39
MS9494-23	2.250	.540-1.000	16.36	MS9494-50	5.625	4.315-4.375	51.09
MS9494-24	2.375	1.065-1.125	17.05	MS9494-51	5.750	4.440-4.500	52.78
MS9494-25	2.500	1.190-1.250	17.75	MS9494-52	5.875	4.565-4.625	54.47
MS9494-26	2.625	1.315-1.375	18.44	MS9494-53	6.000	4.690-4.750	56.17
MS9494-27	2.750	1.440-1.500	19.13	MS9494-54	6.125	4.815-4.875	57.86
MS9494-28	2.875	1.565-1.625	19.83	MS9494-55	6.250	4.940-5.000	59.56
MS9494-29	3.000	1.690-1.750	20.52				
MS9494-30	3.125	1.815-1.875	21.22				

1. CRACK CHALL IS STRAIGHT WITHIN .002 TOTAL PER INCH OF BOLT LENGTH.
2. THE CONCENTRICITY OF THREAD PD IS RELATION TO THE CRACK CHALL IS WITHIN .006 FIR.
3. THE CONCENTRICITY OF THE CRACK IS RELATION TO THE WACHER FACE DIAMETER AND CRACK CHALL IS WITHIN .023 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIALS CORROSION AND HEAT RESISTANT STEEL AND 5731.
6. MANUFACTURING SPECIFICATION: AMS 7477.
7. FINISH: 125 MICROINCHES IDENTIFIED PER AND 6045.
8. SURFACE TREATMENT: 1045 046.1-1962 (UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON).
9. CRACK CHALL RIBS: .003-.015 UNLESS OTHERWISE SPECIFIED.
10. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS: .010, ANGULAR DIMENSIONS: 5°.
11. DO NOT USE UNFINISHED PART NUMBERS.

AD & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES OF THE SAE AEROSPACE PART STANDARDS DIVISION

P.A. MAP - 11 Other Case	OPERATION 17/2	TITLE A BOLT, MACHINE - HEXAGON HEAD, FULL CRACK, AMS 5731, 300-20 UNF-3A	MILITARY STANDARD MS9494
PROCUREMENT SPECIFICATION	SUPERSEDES.	SHEET 1 OF 1	

For activities:

Review activities:
APR - 12, 54

This military standard is approved by the Department of Defense and is mandatory on all activities. Attention for all new engineering and design applications and for negative use shall be made from this document.

DD FORM 672-1 (Continued)

REPLACES EDITIONS OF THIS FORM ARE OBSOLETE