



VIEW A ENLARGED

SECTION THROUGH THREAD PROFILE

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9518-04	.375	.072-.092	.66	MS9518-31	2.775	1.685-1.745	1.95
MS9518-05	.438	.072-.092	.70	MS9518-32	2.800	1.810-1.870	2.03
MS9518-06	.500	.072-.092	.74	MS9518-33	2.825	1.935-1.995	2.11
MS9518-07	.562	.072-.092	.78	MS9518-34	2.750	2.060-2.120	2.19
MS9518-08	.625	.072-.092	.82	MS9518-35	2.875	2.185-2.245	2.27
MS9518-09	.688	.072-.092	.86	MS9518-36	3.000	2.310-2.370	2.35
MS9518-10	.750	.072-.120	.90	MS9518-37	3.125	2.435-2.495	2.43
MS9518-11	.812	.122-.182	.94	MS9518-38	3.250	2.560-2.620	2.51
MS9518-12	.875	.185-.245	.98	MS9518-39	3.375	2.685-2.745	2.59
MS9518-13	.938	.248-.308	1.02	MS9518-40	3.500	2.810-2.870	2.67
MS9518-14	1.000	.310-.370	1.07	MS9518-41	3.625	2.935-2.995	2.75
MS9518-15	1.062	.372-.432	1.11	MS9518-42	3.750	3.060-3.120	2.83
MS9518-16	1.125	.435-.495	1.15	MS9518-43	3.875	3.185-3.245	2.91
MS9518-17	1.188	.498-.558	1.19				
MS9518-18	1.250	.560-.620	1.23				
MS9518-19	1.312	.622-.682	1.27				
MS9518-20	1.375	.685-.745	1.31				
MS9518-21	1.438	.748-.808	1.35				
MS9518-22	1.500	.810-.870	1.39				
MS9518-23	1.562	.872-.932	1.43				
MS9518-24	1.625	.935-.995	1.47				
MS9518-25	1.688	.998-1.058	1.51				
MS9518-26	1.750	1.060-1.120	1.55				
MS9518-27	1.875	1.185-1.245	1.63				
MS9518-28	2.000	1.310-1.370	1.71				
MS9518-29	2.125	1.435-1.495	1.79				
MS9518-30	2.250	1.560-1.620	1.87				

- SHANK SHALL BE STRAIGHT WITHIN .003 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 .011 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET
- MATERIAL STEEL AMS 6322.
- HARDNESS ROCKWELL C26-32.
- FINISH CADMIUM PLATE PER AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING
- MAGNETIC PARTICLE INSPECTION PER AMS 2640.
- MANUFACTURING SPECIFICATION AMS 7452 EXCEPT HEAD MUST BE UPSET.
- SURFACE TEXTURE USAS 846 1-1962 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 ± .010, ANGULAR DIMENSIONS ± 5°.
- DO NOT USE UNASSIGNED PART NUMBERS.

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P.A. USAF -11	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cust		BOLT, MACHINE STEEL AMS 6322, CADMIUM PLATE, HEXAGON HEAD, .190-32 UNJF-3A	MS9518
NAVY -AS			
ARMY -AV			
PROCUREMENT SPECIFICATION 103E	SUPERSEDES:		SHEET 1 OF 1

This military standard has been approved by the Department of Defense and is mandatory 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.

Reviewer activities.

APPROVED 2 FEB 1968