



VIEW A ENLARGED				SECTION THROUGH THREAD PROFILE			
PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9519-04	.375	.079-.099	1.16	MS9519-31	2.375	1.965-1.625	3.45
MS9519-05	.438	.079-.099	1.23	MS9519-32	2.400	1.690-1.750	3.59
MS9519-06	.500	.079-.099	1.30	MS9519-33	2.625	1.815-1.875	3.71
MS9519-07	.562	.079-.099	1.37	MS9519-34	2.750	1.940-2.000	3.88
MS9519-08	.625	.079-.099	1.44	MS9519-35	2.875	2.065-2.125	4.02
MS9519-09	.688	.079-.099	1.51	MS9519-36	3.000	2.190-2.250	4.16
MS9519-10	.750	.079-.099	1.58	MS9519-37	3.125	2.315-2.375	4.31
MS9519-11	.812	.079-.099	1.66	MS9519-38	3.250	2.440-2.500	4.45
MS9519-12	.875	.079-.125	1.73	MS9519-39	3.375	2.565-2.625	4.60
MS9519-13	.938	.128-.168	1.80	MS9519-40	3.500	2.690-2.750	4.74
MS9519-14	1.000	.190-.240	1.87	MS9519-41	3.625	2.815-2.875	4.88
MS9519-15	1.062	.252-.312	1.94	MS9519-42	3.750	2.940-3.000	5.03
MS9519-16	1.125	.315-.375	2.01	MS9519-43	3.875	3.065-3.125	5.17
MS9519-17	1.188	.378-.438	2.09	MS9519-44	4.000	3.190-3.250	5.31
MS9519-18	1.250	.440-.500	2.16	MS9519-45	4.125	3.315-3.375	5.46
MS9519-19	1.312	.502-.562	2.23	MS9519-46	4.250	3.440-3.500	5.60
MS9519-20	1.375	.565-.625	2.30	MS9519-47	4.375	3.565-3.625	5.74
MS9519-21	1.438	.628-.688	2.37	MS9519-48	4.500	3.690-3.750	5.89
MS9519-22	1.500	.690-.750	2.44	MS9519-49	4.625	3.815-3.875	6.03
MS9519-23	1.562	.752-.812	2.52	MS9519-50	4.750	3.940-4.000	6.17
MS9519-24	1.625	.815-.875	2.59	MS9519-51	4.875	4.065-4.125	6.32
MS9519-25	1.688	.878-.938	2.66	MS9519-52	5.000	4.190-4.250	6.46
MS9519-26	1.750	.940-1.000	2.73	MS9519-53	5.125	4.315-4.375	6.60
MS9519-27	1.812	1.002-1.125	2.80	MS9519-54	5.250	4.440-4.500	6.75
MS9519-28	2.000	1.190-1.250	3.02	MS9519-55	5.375	4.565-4.625	6.89
MS9519-29	2.125	1.315-1.375	3.16	MS9519-56	5.500	4.690-4.750	7.03
MS9519-30	2.250	1.440-1.500	3.30	MS9519-57	5.625	4.815-4.875	7.18
				MS9519-58	5.750	4.940-5.000	7.32
				MS9519-59	5.875	5.065-5.125	7.46
				MS9519-60	6.000	5.190-5.250	7.61

- 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 .013 FIR.
 - INCOMPLETE THREADS NOT TO ENTER PILET
 - 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 B46 1-156Z UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICRONS, 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.
- CERTAIN PROVISIONS OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ASSOC AIR STD 17/2 WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED THE DEPARTMENTAL AGENCIES WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICES SO THAT APPROPRIATE ACTION CAN BE TAKEN REFERRING TO THE INTERNATIONAL AGREEMENT CONCERNING AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE S & S AEROSPACE PROPULSION DIVISION

PA USAF - 11 Other Cust NAVY - AS ARMY - AV	INTERNATIONAL INTEREST	TITLE BOLT MACHINE STEEL AMS 6322, CADMIUM PLATE, HEXAGON HEAD, 250-28 UNJF-3A	MILITARY STANDARD MS 9519
PROCUREMENT SPECIFICATION	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.

APPROVED 2 Feb 1968