

FED. SUP. CLASS
5306

USER ACTIVITIES:

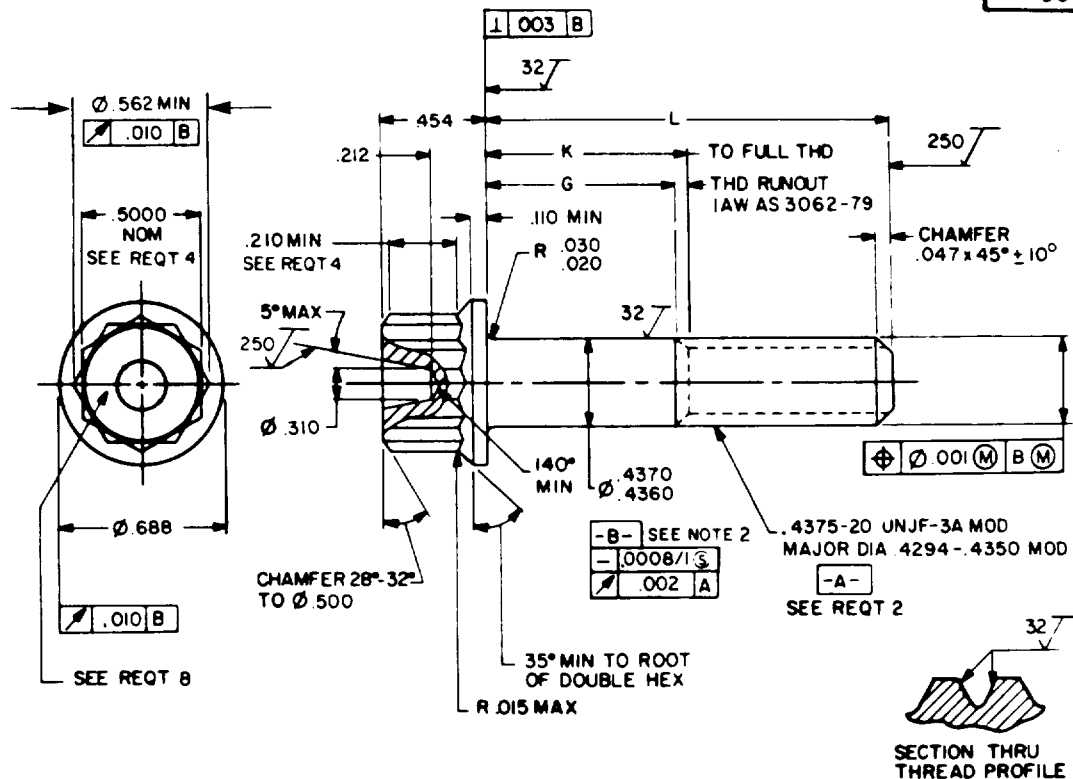
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AIR FORCE - 82
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TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-03	.885	.088	.198	6.38	-31	2.635	1.838	1.948	14.13
-04	.947	.150	.260	6.66	-32	2.697	1.900	2.010	14.41
-05	1.009	.212	.322	6.93	-33	2.759	1.962	2.072	14.68
-06	1.072	.275	.385	7.21	-34	2.822	2.025	2.135	14.96
-07	1.135	.338	.448	7.49	-35	2.885	2.088	2.198	15.24
-08	1.197	.400	.510	7.76	-36	2.947	2.150	2.260	15.51
-09	1.259	.462	.572	8.04	-37	3.009	2.212	2.322	15.79
-10	1.322	.525	.635	8.32	-38	3.072	2.275	2.385	16.07
-11	1.385	.588	.698	8.60	-39	3.135	2.338	2.448	16.34
-12	1.447	.650	.760	8.87	-40	3.197	2.400	2.510	16.62
-13	1.509	.712	.822	9.15	-41	3.259	2.462	2.572	16.90
-14	1.572	.775	.885	9.42	-42	3.322	2.525	2.635	17.17
-15	1.635	.838	.948	9.70	-43	3.385	2.588	2.698	17.45
-16	1.697	.900	1.010	9.98	-44	3.447	2.650	2.760	17.73
-17	1.759	.962	1.072	10.25	-45	3.509	2.712	2.822	18.00
-18	1.822	1.025	1.135	10.53	-46	3.572	2.775	2.885	18.28
-19	1.885	1.088	1.198	10.81	-47	3.635	2.838	2.948	18.56
-20	1.947	1.150	1.260	11.08	-48	3.697	2.900	3.010	18.83
-21	2.009	1.212	1.322	11.36	-49	3.759	2.962	3.072	19.11
-22	2.072	1.275	1.385	11.64	-50	3.822	3.025	3.135	19.39
-23	2.135	1.338	1.448	11.92	-51	3.885	3.088	3.198	19.67
-24	2.197	1.400	1.510	12.19	-52	3.947	3.150	3.260	19.94
-25	2.259	1.462	1.572	12.47	-53	4.009	3.212	3.322	20.22
-26	2.322	1.525	1.635	12.74	-54	4.072	3.275	3.385	20.50
-27	2.385	1.588	1.698	13.02	-55	4.135	3.338	3.448	20.77
-28	2.447	1.650	1.760	13.30	-56	4.197	3.400	3.510	21.05
-29	2.509	1.712	1.822	13.57	-57	4.259	3.462	3.572	21.32
-30	2.572	1.775	1.885	13.85	-58	4.322	3.525	3.635	21.60

© ENTIRE STANDARD REVISED

P. A. NAVY-AS
Other Cost
ARMY-AV
AIR FORCE-99INTERNATIONAL
INTERESTTITLE BOLT, MACHINE-DOUBLE HEXAGON,
EXTENDED WASHER HEAD, CLOSE TOLER-
ANCE SHANK, CORROSION AND HEAT
RESISTANT STEEL, 4375-20 UNJF-3A

MILITARY STANDARD

MS9727

PROCUREMENT SPECIFICATION
AMS 7471

SUPERSEDES:

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5306

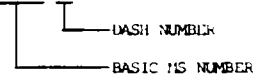
TABLE 1. DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-59	4.385	3.588	3.698	21.88	-69	5.009	4.212	4.322	24.64
-60	4.447	3.650	3.760	22.16	-70	5.072	4.275	4.385	24.92
-61	4.509	3.712	3.822	22.43	-71	5.135	4.338	4.448	25.20
-62	4.572	3.775	3.885	22.71	-72	5.197	4.400	4.510	25.48
-63	4.635	3.838	3.948	22.99	-73	5.259	4.462	4.572	25.75
-64	4.697	3.900	4.010	23.26	-74	5.322	4.525	4.635	26.03
-65	4.759	3.962	4.072	23.54	-75	5.385	4.588	4.698	26.31
-66	4.822	4.025	4.135	23.82	-76	5.447	4.650	4.760	26.58
-67	4.885	4.088	4.198	24.09	-77	5.509	4.712	4.822	26.86
-68	4.947	4.150	4.260	24.37	-78	5.572	4.775	4.885	27.14

REQUIREMENTS:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5708.
2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. DIMENSIONING AND TOLERANCING: DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
4. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
5. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI B46.1.
6. FLUORESCENT PENETRANT INSPECTION: FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645-B3.
7. 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 EXCEPT THAT DISTORTIONS AT A IN FIGURE 2 OF THE PROCUREMENT SPECIFICATION SHALL NOT BE PERMITTED ON THE HEAD BEARING AREA AND SHALL BE PERMITTED ON THE SHANK DIAMETER ONLY IF THE DISTORTION DOES NOT CAUSE THE SHANK DIAMETER TO EXCEED .4375 DIAMETER EXCEPT DASH NUMBER SIZES -12 AND SMALLER.
8. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478-79, CLASS A.
9. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $^{+}.010$, ANGULAR DIMENSIONS $^{+}5^{\circ}$.
10. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS9727-03



MS9727-03 INDICATES: BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, CLOSE TOLERANCE SHANK, .4375-20 UNJF-3A, LENGTH .885

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. FOR PART NUMBERS -03 THRU -12 THE THREAD PD SHALL REPLACE DATUM B.
3. DO NOT USE UNASSIGNED PART NUMBERS.
4. 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.
5. REFERENCED GOVERNMENT (OR NONGOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DDISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
6. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.
7. AS AND AMS ARE SAE PUBLICATIONS.

P. A. NAVY-AS Other Cost ARMY- AV AIR FORCE-99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CLOSE TOLER- ANCE SHANK, CORROSION AND HEAT RESISTANT STEEL, .4375-20 UNJF-3A	MILITARY STANDARD MS9727
PROCUREMENT SPECIFICATION AMS 7471	SUPERSEDES:	PAGE 2 OF 2	