

FED. SUP CLASS
5306

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE - 82
DLA - IS

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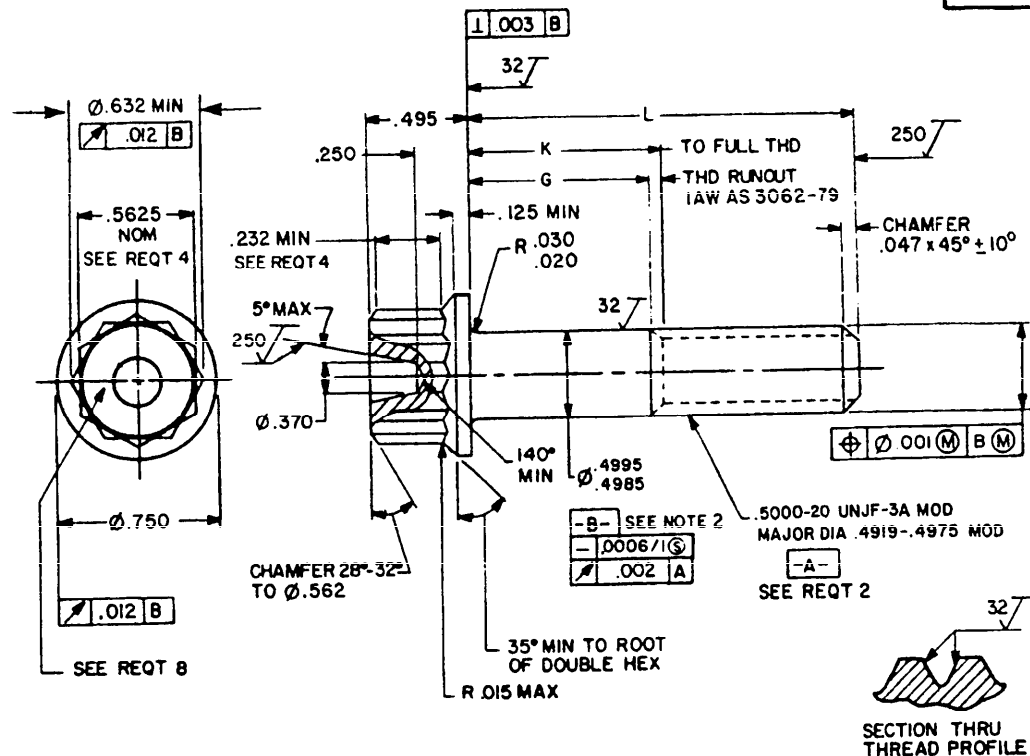


TABLE I. DASH NUMBERS AND DIMENSIONS

| 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 | .984 | .088 | .198 | 8.87 | -31 | 2.734 | 1.838 | 1.948 | 19.00 |
| -04 | 1.046 | .150 | .260 | 9.23 | -32 | 2.796 | 1.900 | 2.010 | 19.36 |
| -05 | 1.108 | .212 | .322 | 9.58 | -33 | 2.858 | 1.962 | 2.072 | 19.72 |
| -06 | 1.171 | .275 | .385 | 9.95 | -34 | 2.921 | 2.025 | 2.135 | 20.08 |
| -07 | 1.234 | .338 | .448 | 10.32 | -35 | 2.984 | 2.088 | 2.198 | 20.45 |
| -08 | 1.296 | .400 | .510 | 10.67 | -36 | 3.046 | 2.150 | 2.260 | 20.80 |
| -09 | 1.358 | .462 | .572 | 11.03 | -37 | 3.108 | 2.212 | 2.322 | 21.16 |
| -10 | 1.421 | .525 | .635 | 11.40 | -38 | 3.171 | 2.275 | 2.385 | 21.53 |
| -11 | 1.484 | .588 | .698 | 11.76 | -39 | 3.234 | 2.338 | 2.448 | 21.90 |
| -12 | 1.546 | .650 | .760 | 12.12 | -40 | 3.296 | 2.400 | 2.510 | 22.25 |
| -13 | 1.608 | .712 | .822 | 12.48 | -41 | 3.358 | 2.462 | 2.572 | 22.61 |
| -14 | 1.671 | .775 | .885 | 12.85 | -42 | 3.421 | 2.525 | 2.635 | 22.98 |
| -15 | 1.734 | .838 | .948 | 13.21 | -43 | 3.484 | 2.588 | 2.698 | 23.34 |
| -16 | 1.796 | .900 | 1.010 | 13.57 | -44 | 3.546 | 2.650 | 2.760 | 23.70 |
| -17 | 1.858 | .962 | 1.072 | 13.93 | -45 | 3.608 | 2.712 | 2.822 | 24.06 |
| -18 | 1.921 | 1.025 | 1.135 | 14.29 | -46 | 3.671 | 2.775 | 2.885 | 24.42 |
| -19 | 1.984 | 1.088 | 1.198 | 14.66 | -47 | 3.734 | 2.838 | 2.948 | 24.79 |
| -20 | 2.046 | 1.150 | 1.260 | 15.02 | -48 | 3.796 | 2.900 | 3.010 | 25.15 |
| -21 | 2.108 | 1.212 | 1.322 | 15.37 | -49 | 3.858 | 2.962 | 3.072 | 25.51 |
| -22 | 2.171 | 1.275 | 1.385 | 15.74 | -50 | 3.921 | 3.025 | 3.135 | 25.87 |
| -23 | 2.234 | 1.338 | 1.448 | 16.10 | -51 | 3.984 | 3.088 | 3.198 | 26.24 |
| -24 | 2.296 | 1.400 | 1.510 | 16.46 | -52 | 4.046 | 3.150 | 3.260 | 26.60 |
| -25 | 2.358 | 1.462 | 1.572 | 16.82 | -53 | 4.108 | 3.212 | 3.322 | 26.95 |
| -26 | 2.421 | 1.525 | 1.635 | 17.19 | -54 | 4.171 | 3.275 | 3.385 | 27.32 |
| -27 | 2.484 | 1.588 | 1.698 | 17.55 | -55 | 4.234 | 3.338 | 3.448 | 27.68 |
| -28 | 2.546 | 1.650 | 1.760 | 17.91 | -56 | 4.296 | 3.400 | 3.510 | 28.04 |
| -29 | 2.608 | 1.712 | 1.822 | 18.27 | -57 | 4.358 | 3.462 | 3.572 | 28.40 |
| -30 | 2.671 | 1.775 | 1.885 | 18.64 | -58 | 4.421 | 3.525 | 3.635 | 28.77 |

Ⓢ 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, .500-20 UNJF-3A

MILITARY STANDARD

MS9728

PROCUREMENT SPECIFICATION
AMS 7471

SUPERSEDES:

PAGE 1 OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0958
E25-187-4

APPROVED 27 JUN 74 REVISED 24 FEB 86

TABLE 1. DASH NUMBERS AND DIMENSIONS - CONTINUED

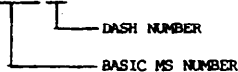
| DASH NUMBER | L INCH | G MIN INCH | K MAX INCH | APPROX MASS LB/100 |
|-------------|-----------|---------------|---------------|-----------------------|
| -59 | 4.484 | 3.588 | 3.698 | 29.13 |
| -60 | 4.546 | 3.650 | 3.760 | 29.49 |
| -61 | 4.608 | 3.712 | 3.822 | 29.85 |
| -62 | 4.671 | 3.775 | 3.885 | 30.22 |
| -63 | 4.734 | 3.838 | 3.948 | 30.58 |
| -64 | 4.796 | 3.900 | 4.010 | 30.94 |
| -65 | 4.858 | 3.962 | 4.072 | 31.30 |
| -66 | 4.921 | 4.025 | 4.135 | 31.66 |
| -67 | 4.984 | 4.088 | 4.198 | 32.03 |
| -68 | 5.046 | 4.150 | 4.260 | 32.38 |

| DASH NUMBER | L INCH | G MIN INCH | K MAX INCH | APPROX MASS LB/100 |
|-------------|-----------|---------------|---------------|-----------------------|
| -69 | 5.108 | 4.212 | 4.322 | 32.74 |
| -70 | 5.171 | 4.275 | 4.385 | 33.11 |
| -71 | 5.234 | 4.338 | 4.448 | 33.47 |
| -72 | 5.296 | 4.400 | 4.510 | 33.83 |
| -73 | 5.358 | 4.462 | 4.572 | 34.19 |
| -74 | 5.421 | 4.525 | 4.635 | 34.56 |
| -75 | 5.484 | 4.588 | 4.698 | 34.92 |
| -76 | 5.546 | 4.650 | 4.760 | 35.28 |

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 2645-83.
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 .5000 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 $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
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: MS9728-03



MS9728-03 INDICATES: BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, CLOSE TOLERANCE SHANK, .500-20 UNJF-3A, LENGTH .984

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 (DODISS) 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.

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| P. A. NAVY-AS Other Cust ARMY - AV AIR FORCE-99 | INTERNATIONAL INTEREST | TITLE BOLT, MACHINE - DOUBLE HEXAGON, EXTENDED WASHER HEAD, CLOSE TOLER- ANCE SHANK, CORROSION AND HEAT RESISTANT STEEL, .500-20 UNJF-3A | MILITARY STANDARD MS9728 |
| PROCUREMENT SPECIFICATION AMS 7471 | SUPERSEDES: | PAGE 2 OF 2 | |

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE-82
DLA-IS

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