

FED. SUP CLASS
5306

USER ACTIVITIES:

REVIEWER ACTIVITIES:
AIR FORCE - 82
DLA - IS

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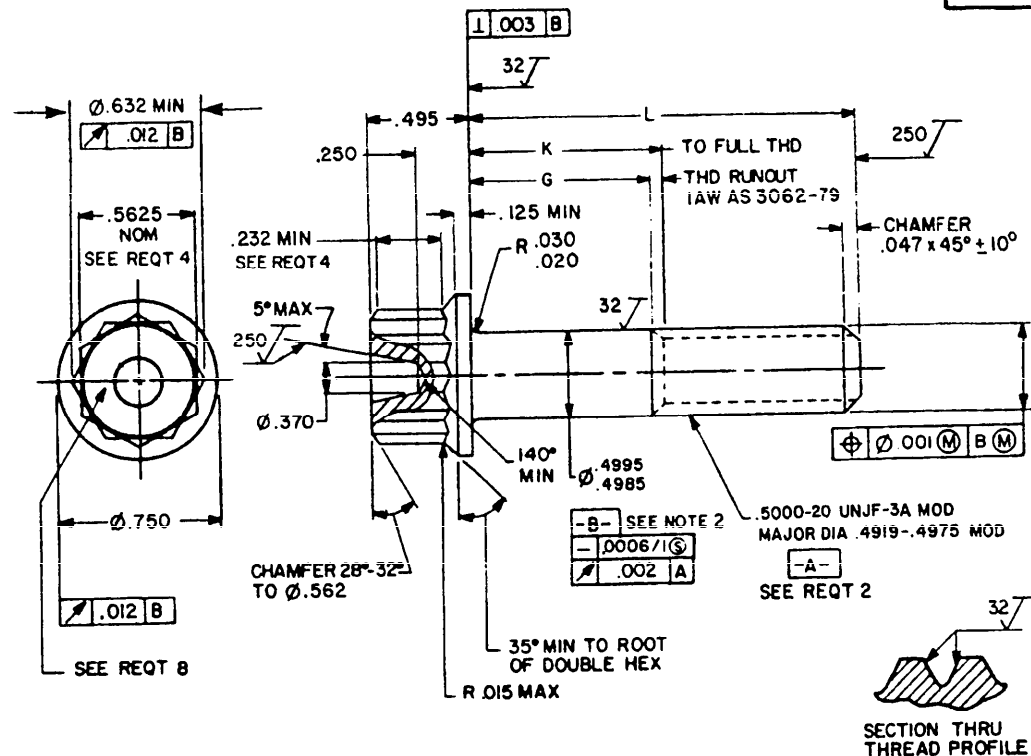


TABLE I. DASH NUMBERS AND DIMENSIONS

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-99

INTERNATIONAL INTEREST

TITLE BOLT, MACHINE - DOUBLE HEXAGON, EXTENDED WASHER HEAD, CLOSE TOLERANCE 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

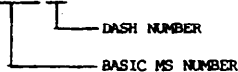
TABLE 1. DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-59	4.484	3.588	3.698	29.13	-69	5.108	4.212	4.322	32.74
-60	4.546	3.650	3.760	29.49	-70	5.171	4.275	4.385	33.11
-61	4.608	3.712	3.822	29.85	-71	5.234	4.338	4.448	33.47
-62	4.671	3.775	3.885	30.22	-72	5.296	4.400	4.510	33.83
-63	4.734	3.838	3.948	30.58	-73	5.358	4.462	4.572	34.19
-64	4.796	3.900	4.010	30.94	-74	5.421	4.525	4.635	34.56
-65	4.858	3.962	4.072	31.30	-75	5.484	4.588	4.698	34.92
-66	4.921	4.025	4.135	31.66	-76	5.546	4.650	4.760	35.28
-67	4.984	4.088	4.198	32.03					
-68	5.046	4.150	4.260	32.38					

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.

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	