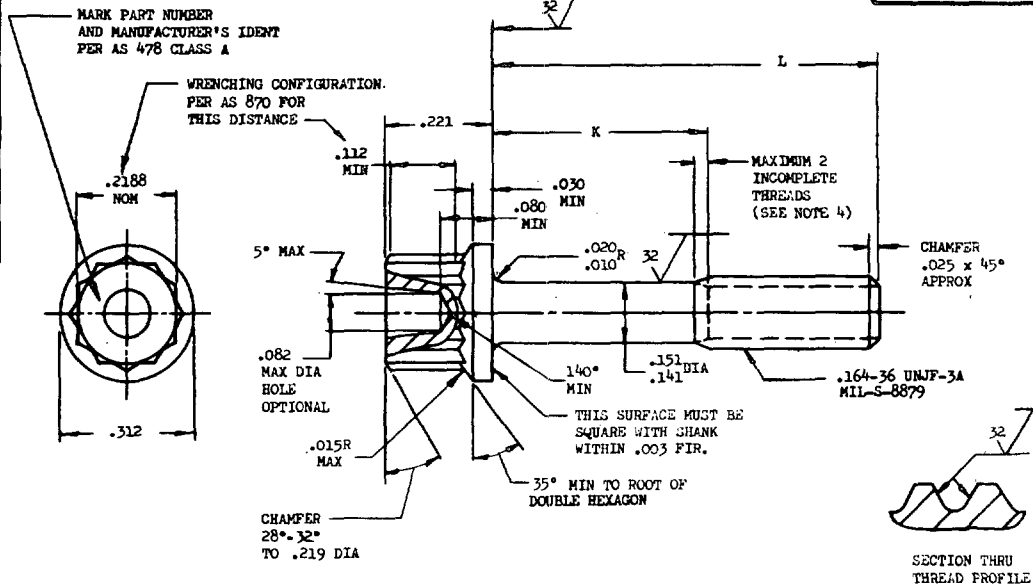


**MS9913** (ASG)

FED. SUP CLASS

5305



PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100
MS9913-02	.250	.062-.082	.419	MS9913-16	1.125	.487-.547	.833
MS9913-03	.312	.062-.082	.448	MS9913-17	1.188	.550-.610	.863
MS9913-04	.375	.062-.082	.478	MS9913-18	1.250	.612-.672	.892
MS9913-05	.438	.062-.082	.498	MS9913-19	1.312	.674-.734	.922
MS9913-06	.500	.062-.082	.537	MS9913-20	1.375	.737-.797	.951
MS9913-07	.562	.062-.082	.567	MS9913-21	1.438	.800-.860	.981
MS9913-08	.625	.062-.082	.596	MS9913-22	1.500	.862-.922	1.010
MS9913-09	.688	.062-.110	.626	MS9913-23	1.562	.924-.984	1.040
MS9913-10	.750	.112-.172	.655	MS9913-24	1.625	.987-1.047	1.069
MS9913-11	.812	.174-.234	.685	MS9913-25	1.688	1.050-1.110	1.099
MS9913-12	.875	.237-.297	.715	MS9913-26	1.750	1.112-1.172	1.129
MS9913-13	.938	.300-.360	.744	MS9913-27	1.812	1.174-1.234	1.158
MS9913-14	1.000	.362-.422	.774	MS9913-28	1.875	1.237-1.297	1.188
MS9913-15	1.062	.424-.484	.804	MS9913-29	1.938	1.300-1.360	1.218
				MS9913-30	2.000	1.362-1.422	1.247

Review activities:  
USAF - 82,85

This military standard is approved by the Department of the Air Force and the Bureau of Naval Weapons and is mandatory for use by these activities. All other military activities are required to employ this standard where suitable.

1. SHANK SHALL BE STRAIGHT WITHIN .003 PER INCH OF SCREW LENGTH.
2. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
3. THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .005 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: STEEL AMS 6322.
6. HARDNESS: ROCKWELL C26-32.
7. FINISH: CADMIUM PLATE AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
8. MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE UPSET.
9. HEAD TO SHANK FILLET SHALL BE COLD WORKED.
10. MAGNETIC PARTICLE INSPECTION PER AMS 2640 AFTER PLATING.
11. SURFACE TEXTURE: USAS B46.1-1962, UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
12. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
13. DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
14. DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS  
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

P.A. USAF - 11	TITLE	MILITARY STANDARD
Other Cast	SCREW, MACHINE - DOUBLE HEXAGON EXTENDED	
Naval - AS	WASHER HEAD, PD SHANK, STEEL AMS 6322,	
	CADMIUM PLATED, .164-36 UNJF-3A	<b>MS9913</b> (ASG)
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 1
NONE		

DD FORM 672-1 (Limited coordination)  
1 SEP 55  
ASD use only

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

\*U.S. GOVERNMENT PRINTING OFFICE: 1969-393-085/S1748

APPROVED 15 Aug 69 REVISED