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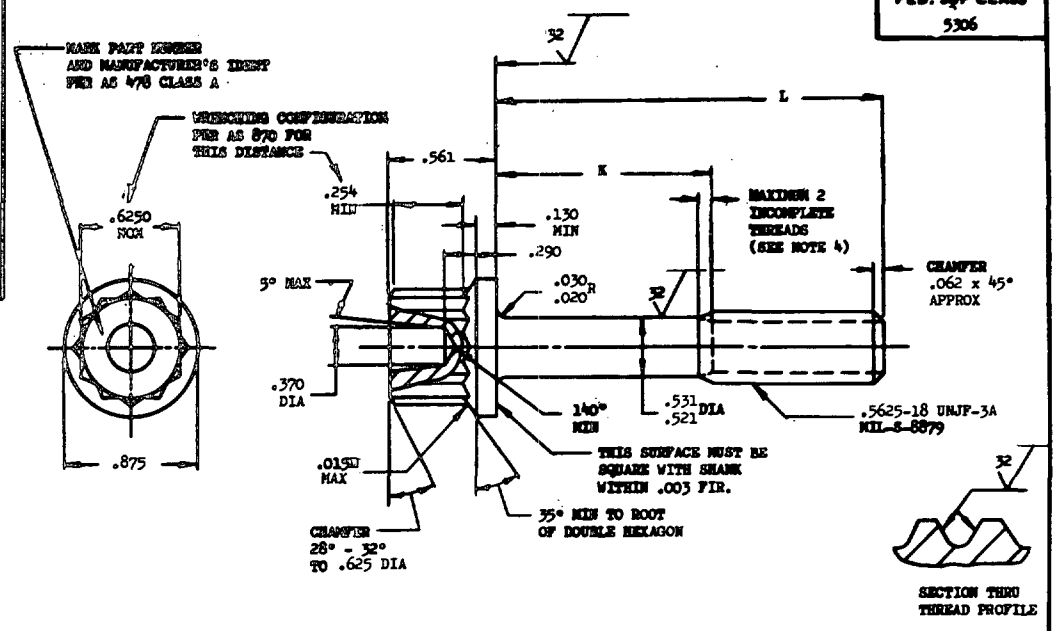
MS9920 (ASG)

FED. SUP CLASS 5306



PART NO.	L	K	APPROX WEIGHT LB/100
MS9920-04	.875	.113- .133	10.01
MS9920-05	.938	.113- .133	10.39
MS9920-06	1.000	.113- .133	11.77
MS9920-07	1.062	.113- .133	12.15
MS9920-08	1.125	.113- .133	12.53
MS9920-09	1.188	.113- .133	12.91
MS9920-10	1.250	.113- .133	13.29
MS9920-11	1.312	.113- .133	13.68
MS9920-12	1.375	.113- .133	14.06
MS9920-13	1.438	.113- .133	14.44
MS9920-14	1.500	.113- .133	14.84
MS9920-15	1.562	.128- .188	15.22
MS9920-16	1.625	.190- .250	15.60
MS9920-17	1.688	.252- .312	15.98
MS9920-18	1.750	.315- .375	16.36
MS9920-19	1.812	.378- .438	16.75
MS9920-20	1.875	.440- .500	17.13
MS9920-21	1.938	.502- .562	17.52
MS9920-22	2.000	.565- .625	17.91
MS9920-23	2.125	.690- .750	18.67
MS9920-24	2.250	.815- .875	19.44
MS9920-25	2.375	.940-1.000	20.21
MS9920-26	2.500	1.065-1.125	20.98
MS9920-27	2.625	1.190-1.250	21.73
MS9920-28	2.750	1.315-1.375	22.50
MS9920-29	2.875	1.440-1.500	23.27
MS9920-30	3.000	1.565-1.625	24.05
MS9920-31	3.125	1.690-1.750	24.81
MS9920-32	3.250	1.815-1.875	25.58
MS9920-33	3.375	1.940-2.000	26.35
MS9920-34	3.500	2.065-2.125	27.12
MS9920-35	3.625	2.190-2.250	27.87
MS9920-36	3.750	2.315-2.375	28.64
MS9920-37	3.875	2.440-2.500	29.41
MS9920-38	4.000	2.565-2.625	30.19
MS9920-39	4.125	2.690-2.750	30.95
MS9920-40	4.250	2.815-2.875	31.72
MS9920-41	4.375	2.940-3.000	32.49
MS9920-42	4.500	3.065-3.125	33.26
MS9920-43	4.625	3.190-3.250	34.01
MS9920-44	4.750	3.315-3.375	34.78
MS9920-45	4.875	3.440-3.500	35.55
MS9920-46	5.000	3.565-3.625	36.33
MS9920-47	5.125	3.690-3.750	37.09
MS9920-48	5.250	3.815-3.875	37.86
MS9920-49	5.375	3.940-4.000	38.63
MS9920-50	5.500	4.065-4.125	39.40
MS9920-51	5.625	4.190-4.250	40.15
MS9920-52	5.750	4.315-4.375	40.92
MS9920-53	5.875	4.440-4.500	41.69
MS9920-54	6.000	4.565-4.625	42.47

1. SHANK SHALL BE STRAIGHT WITHIN .002 PER INCH OF BOLT 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 .013 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 ±.010, ANGULAR DIMENSIONS ±5°.
14. DO NOT USE UNASSIGNED PART NUMBERS.

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THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

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 those activities. All other military activities are required to employ this standard where suitable.

APPROVED 15 Aug 69 REVISED

P.A. USAF - 11 Other Cust Navy - AS	TITLE BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, PD SHANK, STEEL AMS 6322, CADMIUM PLATED, .5625-18 UNJF-3A	MILITARY STANDARD MS9920 (ASG)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1

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