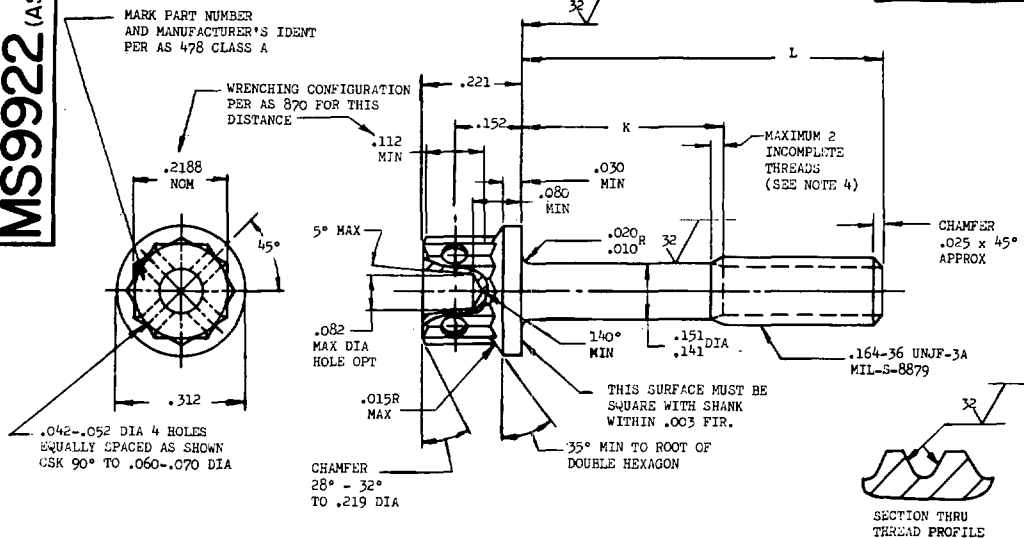


5305



PART NO.	L	K	APPROX WEIGHT LB/100
MS9922-02	.250	.062-.082	.407
MS9922-03	.312	.062-.082	.436
MS9922-04	.375	.062-.082	.466
MS9922-05	.438	.062-.082	.486
MS9922-06	.500	.062-.082	.525
MS9922-07	.562	.062-.082	.555
MS9922-08	.625	.062-.082	.584
MS9922-09	.688	.062-.110	.614
MS9922-10	.750	.112-.172	.643
MS9922-11	.812	.174-.234	.673
MS9922-12	.875	.237-.297	.703
MS9922-13	.938	.300-.360	.732
MS9922-14	1.000	.362-.422	.762
MS9922-15	1.062	.424-.484	.792
MS9922-16	1.125	.487-.547	.821
MS9922-17	1.188	.550-.610	.851
MS9922-18	1.250	.612-.672	.880
MS9922-19	1.312	.674-.734	.910
MS9922-20	1.375	.737-.797	.939
MS9922-21	1.438	.800-.860	.969
MS9922-22	1.500	.862-.922	.998
MS9922-23	1.562	.924-.984	1.028
MS9922-24	1.625	.987-1.047	1.057
MS9922-25	1.688	1.050-1.110	1.087
MS9922-26	1.750	1.112-1.172	1.117
MS9922-27	1.812	1.174-1.234	1.146
MS9922-28	1.875	1.237-1.297	1.176
MS9922-29	1.938	1.300-1.360	1.206
MS9922-30	2.000	1.362-1.422	1.235

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: USA8 B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICRONS 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 Other Cost Navy - AS	TITLE SCREW, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, PD SHANK, STEEL AMS 6322, CAMMID PLATED, .164-36 UNJF-3A	MILITARY STANDARD MS9922 (ASG)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)
ASG use only

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

☆ U. S. GOVERNMENT PRINTING OFFICE: 1969-393-065/S-1790

APPROVED	15 Aug 69	REVISED
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