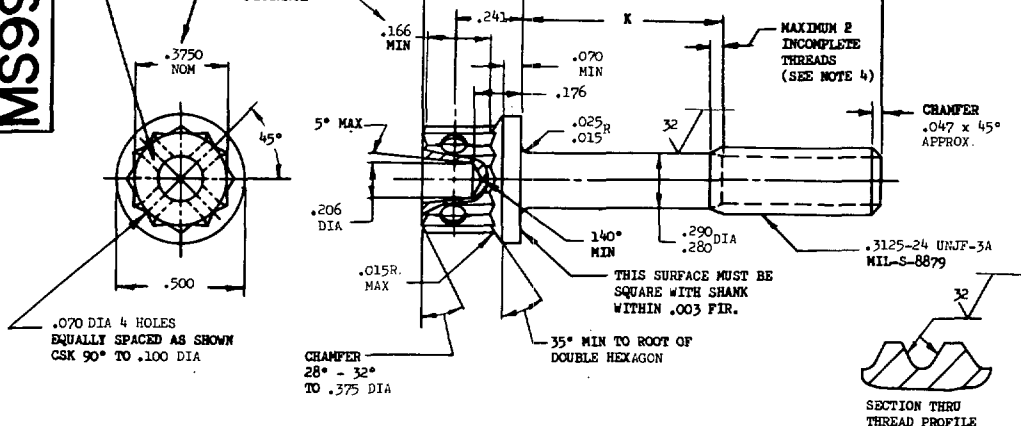


MARK PART NUMBER
AND MANUFACTURER'S IDENT
PER AS 478 CLASS A

WRENCHING CONFIGURATION
PER AS 870 FOR THIS
DISTANCE _____



SECTION THRU
THREAD PROFILE

PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100
MS9925-04	.500	.088-.108	2.05	MS9925-25	1.812	.878-.938	4.51	MS9925-46	4.250	3.315-3.375	8.82
MS9925-05	.562	.088-.108	2.16	MS9925-26	1.875	.940-1.000	4.63	MS9925-47	4.375	3.440-3.500	9.04
MS9925-06	.625	.088-.108	2.27	MS9925-27	1.938	1.002-1.062	4.64	MS9925-48	4.500	3.565-3.625	9.27
MS9925-07	.688	.088-.108	2.39	MS9925-28	2.000	1.065-1.125	4.75	MS9925-49	4.625	3.690-3.750	9.49
MS9925-08	.750	.088-.108	2.50	MS9925-29	2.125	1.130-1.250	4.98	MS9925-50	4.750	3.815-3.875	9.72
MS9925-09	.812	.088-.108	2.64	MS9925-30	2.250	1.315-1.375	5.20	MS9925-51	4.875	3.940-4.000	9.95
MS9925-10	.875	.088-.108	2.27	MS9925-31	2.375	1.440-1.500	5.43	MS9925-52	5.000	4.065-4.125	10.17
MS9925-11	.938	.088-.108	2.84	MS9925-32	2.500	1.565-1.625	5.66	MS9925-53	5.125	4.190-4.250	10.40
MS9925-12	1.000	.088-.125	2.95	MS9925-33	2.625	1.690-1.750	5.88	MS9925-54	5.250	4.315-4.375	10.62
MS9925-13	1.062	.128-.188	3.06	MS9925-34	2.750	1.815-1.875	6.11	MS9925-55	5.375	4.440-4.500	10.85
MS9925-14	1.125	.190-.250	3.17	MS9925-35	2.875	1.940-2.000	6.33	MS9925-56	5.500	4.565-4.625	11.07
MS9925-15	1.188	.252-.312	3.29	MS9925-36	3.000	2.065-2.125	6.56	MS9925-57	5.625	4.690-4.750	11.30
MS9925-16	1.250	.315-.375	3.40	MS9925-37	3.125	2.190-2.250	6.78	MS9925-58	5.750	4.815-4.875	11.53
MS9925-17	1.312	.378-.438	3.51	MS9925-38	3.250	2.315-2.375	7.01	MS9925-59	5.875	4.940-5.000	11.75
MS9925-18	1.375	.440-.500	3.62	MS9925-39	3.375	2.440-2.500	7.24	MS9925-60	6.000	5.065-5.125	11.98
MS9925-19	1.438	.502-.562	3.74	MS9925-40	3.500	2.565-2.625	7.46				
MS9925-20	1.500	.565-.625	3.85	MS9925-41	3.625	2.690-2.750	7.69				
MS9925-21	1.562	.628-.688	3.96	MS9925-42	3.750	2.815-2.875	7.91				
MS9925-22	1.625	.690-.750	4.08	MS9925-43	3.875	2.940-3.000	8.14				
MS9925-23	1.688	.752-.812	4.19	MS9925-44	4.000	3.065-3.125	8.37				
MS9925-24	1.750	.815-.875	4.30	MS9925-45	4.125	3.190-3.250	8.59				

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 .008 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 COLL 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 SAF AEROSPACE PART STANDARDS DIVISION

P.A. USAF - 11 Other Cost Navy - AS	TITLE BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, PD SHANK, STEEL AMS 6322, CADMIUM PLATED, .3125-24 UNJF-3A	MILITARY STANDARD
		MS9925 (ASG)
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)
SEP 57
ASG use only

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

☆ U. S. GOVERNMENT PRINTING OFFICE: 1969-393-065/5-1794

DATE _____

DRAWN BY _____

TYPED BY _____

CHECKED BY _____

NOTES TO PRINTER: REDUCE BORDER TO 6-27/32x9-3/4. PRINT LEFT
BORDER-LINE ONE INCH FROM LEFT EDGE OF 8x10-1/2 SHEET.
PRINT BOTTOM BORDER LINE 3/8 INCH FROM BOTTOM EDGE OF 8x10-1/2
SHEET. SIGNATURE FORM NOT TO BE INCLUDED ON 8x10-1/2 SHEET.

FD-1482