

MS9927 (ASG)				FED. SUP CLASS 5306			
<p>MAKE PART NUMBER AND MANUFACTURER'S IDENTIFY FOR AS 478 CLASS A</p> <p>WELDING CONFIGURATION PER AS 810 FOR THIS DISTANCE</p> <p>MAXIMUM 2 INCOMPLETE THREADS (SEE NOTE 4)</p> <p>CHAMFER .047 ± .45° APPROX</p> <p>CHAMFER 28° - 32° TO .500 DIA</p> <p>THIS SURFACE MUST BE SQUARE WITH SHANK WITHIN .003 FIP.</p> <p>35° MIN TO ROOT OF DOUBLE BEVEL</p> <p>SECTION THREE THREAD PROFILE</p>				<p>1. SHANK SHALL BE STRAIGHT WITHIN .0025 PER INCH OF BOLT LENGTH.</p> <p>2. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIP.</p> <p>3. THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE BEVEL ON SHANK SHALL BE WITHIN .010 FIP.</p> <p>4. INCOMPLETE THREADS NOT TO ENTER FILLET.</p> <p>5. MATERIAL: STEEL AND 8320.</p> <p>6. HARDNESS: ROCKWELL C26-30.</p> <p>7. FINISH: CALCIUM PLATE AND 1000. DIMENSION SPECIFIED ARE AFTER PLATING.</p> <p>8. MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE WENT.</p> <p>9. HEAT TREATING: SHALL BE COLD WORKED.</p> <p>10. MAGNETIC PARTICLE INSPECTION PER AMS 2640 AFTER PLATING.</p> <p>11. SURFACE TEXTURE: USAS B46.1-1962, UNLESS OTHERWISE SPECIFIED, 32.0 AR BY 10.0 HIPS HIGH INCHES EXCEPT WENT HEAD.</p> <p>12. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.</p> <p>13. DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS .010, ANGULAR DIMENSIONS .5°.</p> <p>14. DO NOT USE UNASSIGNED PART NUMBERS.</p>			
<p>AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATION.</p> <p>THIS STANDARD WAS DEVELOPED COOPERATIVELY BY THE MILITARY AND AUTOMOTIVE INDUSTRIES.</p>				<p>APPROVED 15 Aug 69</p>			
<p>P.A. USAF - 11</p> <p>Other Code</p> <p>Navy - AS</p>		<p>TITLE</p> <p>BOLT, WASHER, AND NUT, 1/2-13, 1/2-11, 1/2-9, 1/2-7, 1/2-5, 1/2-4, 1/2-3, 1/2-2, 1/2-1, 1/2-1/2, 1/2-1/4, 1/2-1/8, 1/2-1/16, 1/2-1/32, 1/2-1/64, 1/2-1/128, 1/2-1/256, 1/2-1/512, 1/2-1/1024, 1/2-1/2048, 1/2-1/4096, 1/2-1/8192, 1/2-1/16384, 1/2-1/32768, 1/2-1/65536, 1/2-1/131072, 1/2-1/262144, 1/2-1/524288, 1/2-1/1048576, 1/2-1/2097152, 1/2-1/4194304, 1/2-1/8388608, 1/2-1/16777216, 1/2-1/33554432, 1/2-1/67108864, 1/2-1/134217728, 1/2-1/268435456, 1/2-1/536870912, 1/2-1/1073741824, 1/2-1/2147483648, 1/2-1/4294967296, 1/2-1/8589934592, 1/2-1/17179869184, 1/2-1/34359738368, 1/2-1/68719476736, 1/2-1/137438953472, 1/2-1/274877906944, 1/2-1/549755813888, 1/2-1/1099511627776, 1/2-1/2199023255552, 1/2-1/4398046511104, 1/2-1/8796093022208, 1/2-1/17592186044416, 1/2-1/35184372088832, 1/2-1/70368744177664, 1/2-1/140737488355328, 1/2-1/281474976710656, 1/2-1/562949953421312, 1/2-1/1125899906842624, 1/2-1/2251799813685248, 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