

MS9928 (ASG)				FED. SUP CLASS 5306			
<p>MARK PART NUMBER AND MANUFACTURER'S IDENT PER AS 475 CLASS A</p> <p>WRENCHING CONFIGURATION PER AS 870 FOR THIS DISTANCE</p> <p>MAXIMUM 2 INCOMPLETE THREADS (SEE NOTE 4)</p> <p>CHAMFER .047 ± .45° APPROX</p> <p>THIS SURFACE MUST BE SQUARE WITH SHANK WITHIN .003 FIR.</p> <p>35° MIN TO ROOT OF DOUBLE HEXAGON</p> <p>SECTION THREE THREAD PROFILE</p>				<p>1. SHANK SHALL BE STRAIGHT WITHIN .002 PER INCH OF BOLT LENGTH.</p> <p>2. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.</p> <p>3. THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON CD SHALL BE WITHIN .012 FIR.</p> <p>4. INCOMPLETE THREADS NOT TO ENTER FILLET.</p> <p>5. MATERIAL: STEEL AMS 6322.</p> <p>6. HARDNESS: ROCKWELL C26-32.</p> <p>7. FINISH: CADMIUM PLATE AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.</p> <p>8. MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE UPSET.</p> <p>9. HEAD TO SHANK FILLET 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, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET 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. PUBLICATIONS.</p> <p>THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE U.S. AFROSPACE PART STANDARDS DIVISION.</p>				<p>APPROVED 15 Aug 69</p>			
<p>P.A. USAF - 11</p> <p>Other Cost</p> <p>Navy - AS</p>		<p>TITLE</p> <p>BOLT, WASHER - DOUBLE HEXAGON EXTENDED</p> <p>WASHER HEAD, DRILLED, PH SHANK, STEEL AMS 6322, CADMIUM PLATED, .500-20 UNF-3A</p>		<p>MILITARY STANDARD</p> <p>MS9928 (ASG)</p>			
<p>PROCUREMENT SPECIFICATION</p> <p>NONE</p>		<p>SUPERSEDES:</p>		<p>SHEET 1 OF 1</p>			

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.

Review activities:
USAF - 82, 85

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

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

☆ U. S. GOVERNMENT PRINTING OFFICE: 1969-35-045-5-1787