

INCH-POUND

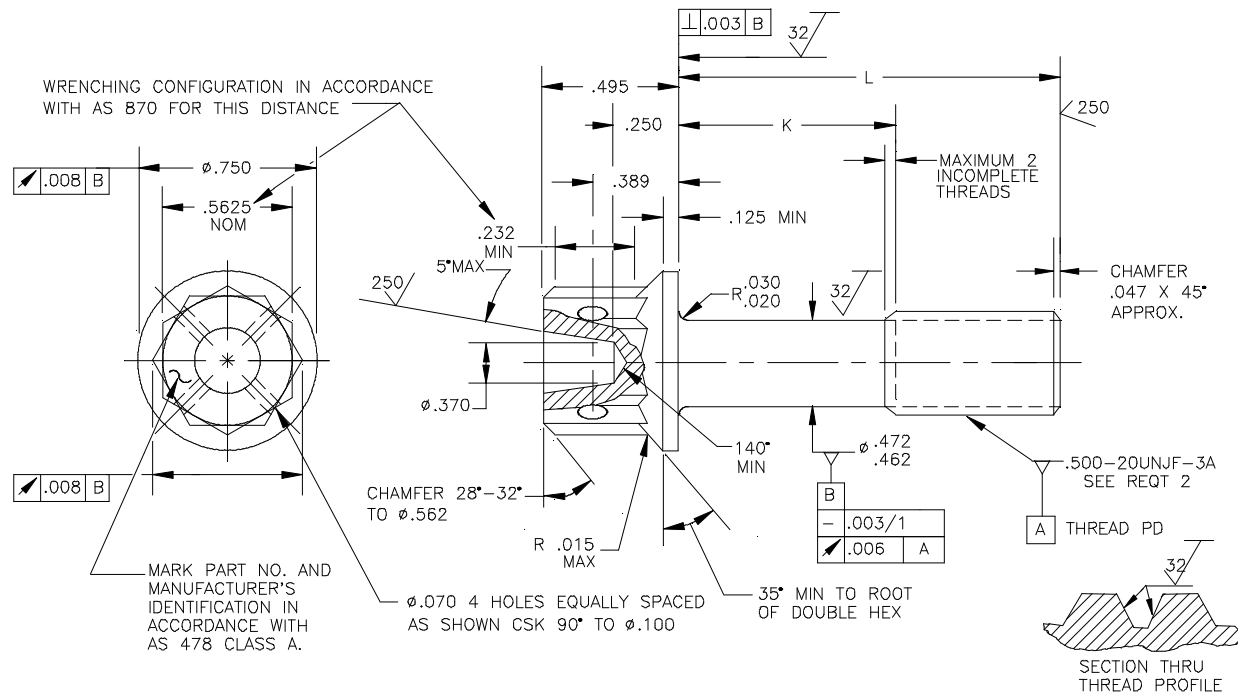
MS9928A
 9 September 1996
 Superseding
 MS9928
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MILITARY SPECIFICATION SHEET

BOLT, MACHINE, DOUBLE HEXAGON EXTENDED WASHER HEAD,
 DRILLED, PD SHANK, STEEL AMS 6322, CADMIUM PLATED,
 .500-20 UNJF-3A

This specification is approved for use by all Departments
 and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and the issue of the following specification listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation: AMS 2640 except head shall be upset.



(A) Entire document revised

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Table I. Dash Numbers and Dimensions.

Part No.	L	K	Approximate Weight LB/100	Part No.	L	K	Approximate Weight LB/100
-03	.750	.105- .125	7.25	-31	3.000	1.590-1.750	18.14
-04	.812	.105- .125	7.56	-32	3.125	1.815-1.875	18.75
-05	.875	.105- .125	7.86	-33	3.250	1.940-2.000	19.35
-06	.938	.105- .125	8.16	-34	3.375	2.065-2.125	19.95
-07	1.000	.105- .125	8.47	-35	3.500	2.190-2.250	20.54
-08	1.062	.105- .125	8.77	-36	3.625	2.315-2.375	21.17
-09	1.125	.105- .125	9.07	-37	3.750	2.440-2.500	21.77
-10	1.188	.105- .125	9.37	-38	3.875	2.565-2.625	22.32
-11	1.250	.105- .125	9.67	-39	4.000	2.690-2.750	22.98
-12	1.312	.105- .125	9.97	-40	4.125	2.815-2.875	23.59
-13	1.375	.105- .125	10.27	-41	4.250	2.940-3.000	24.16
-14	1.438	.128- .188	10.57	-42	4.375	3.065-3.125	24.79
-15	1.500	.190- .250	10.87	-43	4.500	3.190-3.250	25.40
-16	1.562	.252- .312	11.18	-44	4.625	3.315-3.375	26.01
-17	1.625	.315- .375	11.49	-45	4.750	3.440-3.500	26.61
-18	1.688	.378- .438	11.79	-46	4.875	3.565-3.625	27.22
-19	1.750	.440- .500	12.09	-47	5.000	3.690-3.750	27.82
-20	1.812	.502- .562	12.40	-48	5.125	3.815-3.875	28.43
-21	1.875	.565- .625	12.70	-49	5.250	3.940-4.000	29.22
-22	1.938	.628- .688	13.00	-50	5.375	4.065-4.125	29.61
-23	2.000	.690- .750	13.31	-51	5.500	4.190-4.250	30.24
-24	2.125	.815- .875	13.91	-52	5.625	4.315-4.375	30.85
-25	2.250	.940-1.000	14.51	-53	5.750	4.440-4.500	31.45
-26	2.375	1.065-1.125	15.11	-54	5.875	4.565-4.625	32.05
-27	2.500	1.190-1.250	15.72	-55	6.000	4.690-4.750	32.66
-28	2.625	1.315-1.375	16.33				
-29	2.750	1.440-1.500	16.93				
-30	2.875	1.565-1.625	17.54				

REQUIREMENTS:

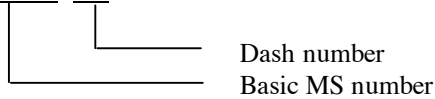
1. Material: Corrosion and heat resistant steel in accordance with AMS 6322.
2. Threads: Threads in accordance with MIL-S-8879. Incomplete threads not to enter fillet.
3. Finish: Cadmium plate in accordance with AMS 2400. Dimensions specified are after plating.
4. Magnetic Particle Inspection: Magnetic particle inspection shall be in accordance with AMS 2640 after plating.
5. Surface Texture: Surface texture in accordance with ANSI/ASME B46.1. Unless otherwise specified, surface to be 125 microinches except upset head.

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Requirements (Continued)

6. Hardness. Rockwell C26-32
7. Dimensioning and Tolerancing: Dimensioning and tolerancing shall be in accordance with ASME Y14.5M
8. Tolerances: Unless otherwise specified, Tolerances shall be for linear dimensions $\pm.010$, angular dimensions $\pm 5^\circ$.
9. Edges: Break sharp edges .003-.015 unless otherwise specified.
10. Head to shank fillet shall be cold rolled.
11. Part Number: The part number shall consist of the basis MS number followed by a dash number from Table I.

Example: MS9928 -04



NOTES:

1. Dimension are in inches unless otherwise specified.
2. Do not use unassigned part numbers.
3. In the event of a conflict between the text of this document and the references cited herein, the text of this document shall take precedence.
4. Unless otherwise specified, issues of referenced documents are those in effect at the time of solicitation.
5. This standard was developed cooperatively with the SAE Aerospace Propulsion Division.
6. AS and AMS are SAE publications

Military Interests:

Custodians:
Navy - AS
Air Force - 11

Preparing activity:
DLA - IS

(Project 5306-2006)

Reviewer:
Air Force - 82, 85