

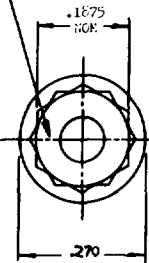
FED. SUP CLASS

5305

**MS9930**

MARK MS9930  
AND MANUFACTURER'S IDENT  
PER AS 478 CLASS A

WRENCHING CONFIGURATION  
PER AS 870 FOR  
THIS DISTANCE



5° MAX

.076  
MAX DIA  
HOLE  
OPTIONAL

.015R MAX

.205

.030 MIN

.101 MIN

.068 MIN

.020R  
.010

MIN 1 PITCH  
INCOMPLETE  
THREAD

CHAMFER .025  
x 45°±10°

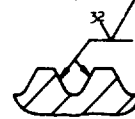
140° MIN

.137  
.134 DIA

THIS SURFACE MUST BE  
SQUARE WITH SHANK  
WITHIN .003 FIR.

35° MIN TO ROOT OF DOUBLE HEXAGON

CHAMFER  
28° - 32°  
TO .188 DIA



SECTION THRU  
THREAD PROFILE

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100	PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9930-09	.688	.042	.162	.430	MS9930-19	1.312	.666	.786	.694
MS9930-10	.750	.104	.224	.456	MS9930-20	1.375	.729	.849	.720
MS9930-11	.812	.166	.286	.482	MS9930-21	1.438	.792	.912	.747
MS9930-12	.875	.229	.349	.508	MS9930-22	1.500	.854	.974	.774
MS9930-13	.938	.292	.412	.535	MS9930-23	1.562	.916	1.036	.801
MS9930-14	1.000	.354	.474	.562	MS9930-24	1.625	.979	1.099	.828
MS9930-15	1.062	.416	.536	.588	MS9930-25	1.688	1.042	1.162	.855
MS9930-16	1.125	.479	.599	.614	MS9930-26	1.750	1.104	1.224	.882
MS9930-17	1.188	.542	.662	.641	MS9930-27	1.812	1.166	1.286	.909
MS9930-18	1.250	.604	.724	.668	MS9930-28	1.875	1.229	1.349	.936
					MS9930-29	1.938	1.292	1.412	.963
					MS9930-30	2.000	1.354	1.474	.990

- SHANK SHALL BE STRAIGHT WITHIN .003 TOTAL PER INCH OF SCREW LENGTH.
- THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .004 FIR.
- MATERIAL: STEEL AMS 6322.
- HARDNESS: ROCKWELL C26-32.
- FINISH: CADMIUM PLATE AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
- MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE UPSET.
- HEAD TO SHANK FILLET SHALL BE COLD WORKED.
- MAGNETIC PARTICLE INSPECTION PER AMS 2640 AFTER PLATING.
- SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
- BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
- DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATION.

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE USAF AEROSPACE PART STANDARDS DIVISION.

P.A. AIR FORCE - II Other Cast NAVY - AS	TITLE SCREW, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, FULL SHANK, STEEL AMS 6322 CADMIUM PLATED, .138-40 UNJF-3A	MILITARY STANDARD <b>MS9930</b>
PROCUREMENT SPECIFICATION AMS-7452	SUPERSEDES:	SHEET 1 OF 1

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

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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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:  
Air Force - 82  
Navy - AS

User activities:  
Navy - MC, CG

APPROVED 30 Dec 70 REVISED