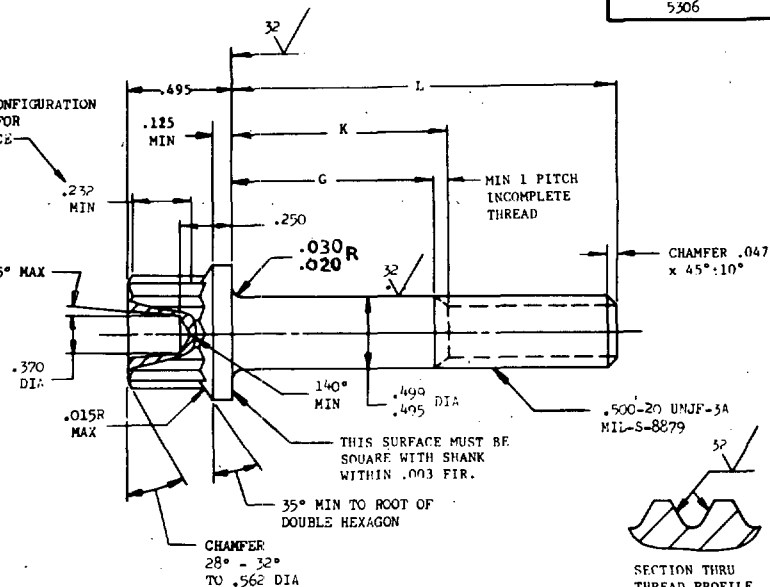
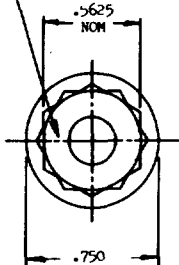


**MS9937**

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

WRENCHING CONFIGURATION  
PER AS 870 FOR  
THIS DISTANCE



SECTION THRU  
THREAD PROFILE

User activities:  
Navy - MG, CG

Review activities:  
Air Force - 82  
Navy - AS

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.

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9937-15	1.500	.090	.250	11.05
MS9937-16	1.562	.152	.312	11.40
MS9937-17	1.625	.215	.375	11.75
MS9937-18	1.688	.278	.438	12.10
MS9937-19	1.750	.340	.500	12.44
MS9937-20	1.812	.402	.562	12.79
MS9937-21	1.875	.465	.625	13.12
MS9937-22	1.938	.528	.688	13.49
MS9937-23	2.000	.590	.750	13.84
MS9937-24	2.125	.715	.875	14.53
MS9937-25	2.250	.840	1.000	15.23
MS9937-26	2.375	.965	1.125	15.92

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9937-27	2.500	1.090	1.250	16.62
MS9937-28	2.625	1.215	1.375	17.32
MS9937-29	2.750	1.340	1.500	18.01
MS9937-30	2.875	1.465	1.625	18.71
MS9937-31	3.000	1.590	1.750	19.40
MS9937-32	3.125	1.715	1.875	20.10
MS9937-33	3.250	1.840	2.000	20.79
MS9937-34	3.375	1.965	2.125	21.49
MS9937-35	3.500	2.090	2.250	22.19
MS9937-36	3.625	2.215	2.375	22.88
MS9937-37	3.750	2.340	2.500	23.58
MS9937-38	3.875	2.465	2.625	24.28
MS9937-39	4.000	2.590	2.750	24.97
MS9937-40	4.125	2.715	2.875	25.67
MS9937-41	4.250	2.840	3.000	26.36

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9937-42	4.375	2.965	3.125	27.06
MS9937-43	4.500	3.090	3.250	27.76
MS9937-44	4.625	3.215	3.375	28.45
MS9937-45	4.750	3.340	3.500	29.15
MS9937-46	4.875	3.465	3.625	29.84
MS9937-47	5.000	3.590	3.750	30.54
MS9937-48	5.125	3.715	3.875	31.24
MS9937-49	5.250	3.840	4.000	31.93
MS9937-50	5.375	3.965	4.125	32.63
MS9937-51	5.500	4.090	4.250	33.32
MS9937-52	5.625	4.215	4.375	34.02
MS9937-53	5.750	4.340	4.500	34.72
MS9937-54	5.875	4.465	4.625	35.41
MS9937-55	6.000	4.590	4.750	36.11

1. SHANK SHALL BE STRAIGHT WITHIN .002 TOTAL 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 .012 FIR.
4. MATERIAL: STEEL AMS 6322.
5. HARDNESS: ROCKWELL C26-32.
6. FINISH: CADMIUM PLATE AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
7. MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE UPSET.
8. HEAD TO SHANK FILLET SHALL BE COLD WORKED.
9. MAGNETIC PARTICLE INSPECTION PER AMS 2640 AFTER PLATING.
10. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
11. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
13. 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 SAE AEROSPACE PART STANDARDS

P.A. AIR FORCE - 11 Other Cost NAVY - AS	TITLE BOLT, MACHINE-DOUBLE HEXAGON EXTENDED WASHER HEAD, FULL SHANK, STEEL AMS 6322, CADMIUM PLATED, .500-20 UNJF-3A	MILITARY STANDARD <b>MS9937</b>
PROCUREMENT SPECIFICATION AMS-7452	SUPERSEDES:	SHEET 1 OF 1

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

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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