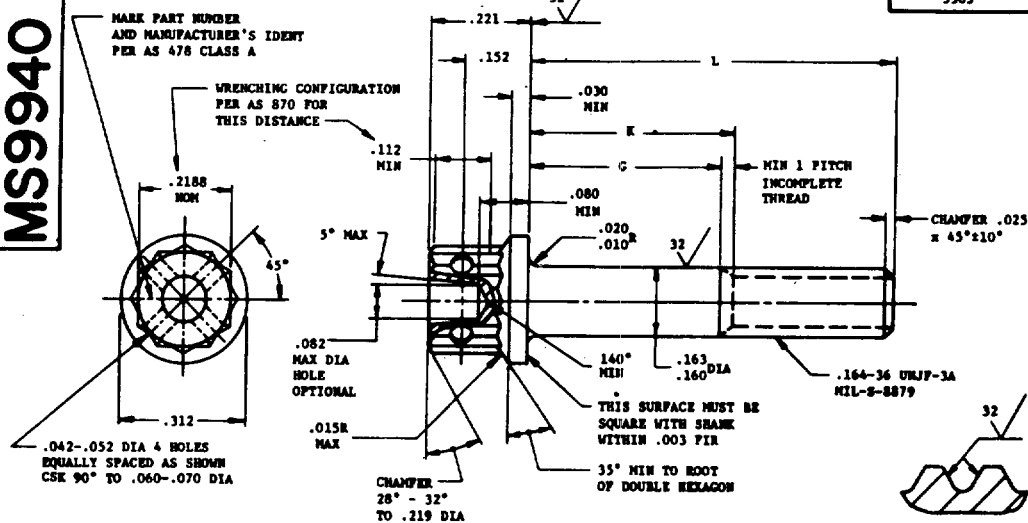


MS9940User activities:
Navy - MC, CGReview activities:
Air Force - 82
Navy - AS

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 when suitable.



PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9940-10	.750	.052	.172	.658
MS9940-11	.812	.114	.234	.696
MS9940-12	.875	.177	.297	.734
MS9940-13	.938	.240	.360	.771
MS9940-14	1.000	.302	.422	.809
MS9940-15	1.062	.364	.484	.846
MS9940-16	1.125	.427	.547	.883
MS9940-17	1.188	.490	.610	.921
MS9940-18	1.250	.542	.672	.958
MS9940-19	1.312	.614	.734	.996
MS9940-20	1.375	.677	.797	1.033
MS9940-21	1.438	.740	.860	1.070
MS9940-22	1.500	.802	.922	1.108

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9940-23	1.562	.864	.984	1.145
MS9940-24	1.625	.927	1.047	1.183
MS9940-25	1.688	.990	1.110	1.220
MS9940-26	1.750	1.052	1.172	1.257
MS9940-27	1.812	1.114	1.234	1.295
MS9940-28	1.875	1.177	1.297	1.332
MS9940-29	1.938	1.240	1.360	1.370
MS9940-30	2.000	1.302	1.422	1.407

- 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 .005 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. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

P.A. AIR FORCE - 11 Other Cost NAVY - AS	TITLE SCREW, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, FULL SHANK, STEEL AMS 6322, CADMIUM PLATED, .164-36 UNJF-3A	MILITARY STANDARD MS 9940
PROCLAMATION SPECIFICATION AMS-7452	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)
1 SEP 67
ASG use only

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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APPROVED 30 Dec 70 REVISED