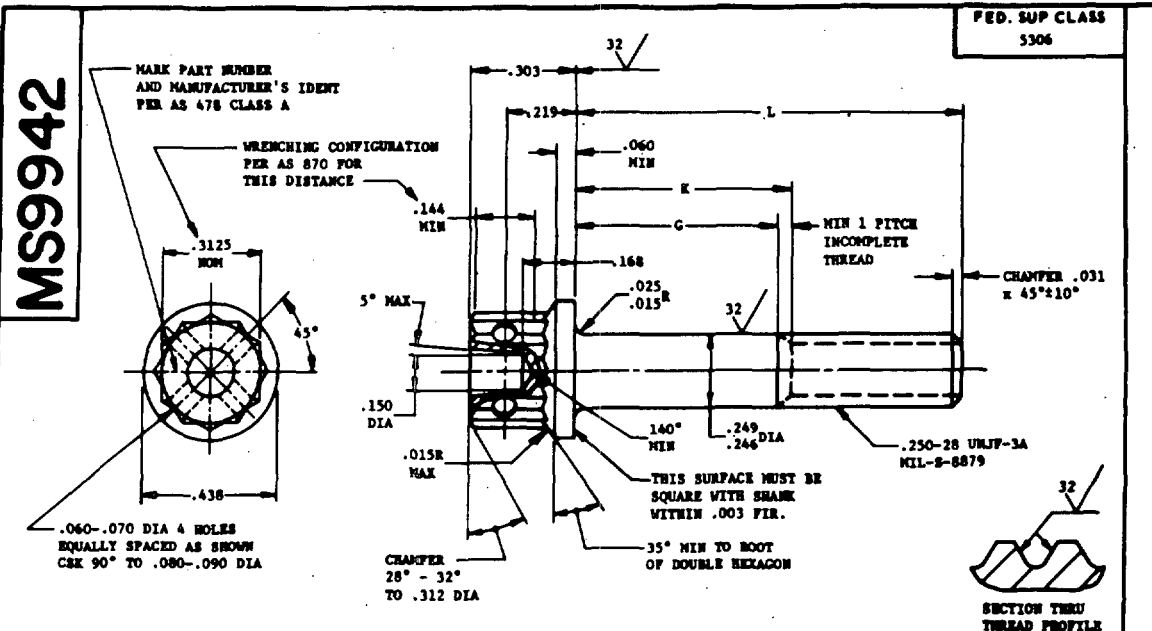


MS9942User activities:
Navy - MC, CGReview activities:
Air Force - 82
Navy - AS

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 where suitable.



PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9942-13	.938	.057	.188	1.88
MS9942-14	1.000	.119	.250	1.96
MS9942-15	1.062	.181	.312	2.05
MS9942-16	1.125	.244	.375	2.14
MS9942-17	1.188	.307	.438	2.22
MS9942-18	1.250	.369	.500	2.31
MS9942-19	1.312	.431	.562	2.40
MS9942-20	1.375	.494	.625	2.49
MS9942-21	1.438	.557	.688	2.57
MS9942-22	1.500	.619	.750	2.66
MS9942-23	1.562	.681	.812	2.74
MS9942-24	1.625	.744	.875	2.83
MS9942-25	1.688	.807	.938	2.92
MS9942-26	1.750	.869	1.000	3.00
MS9942-27	1.812	.931	1.062	3.09

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9942-28	1.875	.994	1.125	3.18
MS9942-29	1.938	1.057	1.188	3.26
MS9942-30	2.000	1.119	1.250	3.33
MS9942-31	2.125	1.244	1.375	3.53
MS9942-32	2.250	1.369	1.500	3.70
MS9942-33	2.375	1.494	1.625	3.87
MS9942-34	2.500	1.619	1.750	4.04
MS9942-35	2.625	1.744	1.875	4.22
MS9942-36	2.750	1.869	2.000	4.39
MS9942-37	2.875	1.994	2.125	4.56
MS9942-38	3.000	2.119	2.250	4.74
MS9942-39	3.125	2.244	2.375	4.91
MS9942-40	3.250	2.369	2.500	5.08
MS9942-41	3.375	2.494	2.625	5.26
MS9942-42	3.500	2.619	2.750	5.43
MS9942-43	3.625	2.744	2.875	5.60
MS9942-44	3.750	2.869	3.000	5.78
MS9942-45	3.875	2.994	3.125	5.95

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9942-46	4.000	3.119	3.250	6.12
MS9942-47	4.125	3.244	3.375	6.30
MS9942-48	4.250	3.369	3.500	6.47
MS9942-49	4.375	3.494	3.625	6.64
MS9942-50	4.500	3.619	3.750	6.82
MS9942-51	4.625	3.744	3.875	6.99
MS9942-52	4.750	3.869	4.000	7.16
MS9942-53	4.875	3.994	4.125	7.34
MS9942-54	5.000	4.119	4.250	7.51
MS9942-55	5.125	4.244	4.375	7.69
MS9942-56	5.250	4.369	4.500	7.86
MS9942-57	5.375	4.494	4.625	8.03
MS9942-58	5.500	4.619	4.750	8.21
MS9942-59	5.625	4.744	4.875	8.38
MS9942-60	5.750	4.869	5.000	8.55
MS9942-61	5.875	4.994	5.125	8.74
MS9942-62	6.000	5.119	5.250	8.88

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 .007 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 ±.010 ANGULAR DIMENSIONS ±5°.
13. DO NOT USE UNASSIGNED PART NUMBERS.

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

P.A. AIR FORCE - 11 Other Cast NAVY - AS	TITLE BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, FULL SHANK, STEEL AMS 6322, CADMIUM PLATED, .250-28 UNJF-3A	MILITARY STANDARD MS 9942
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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