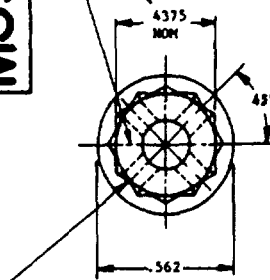


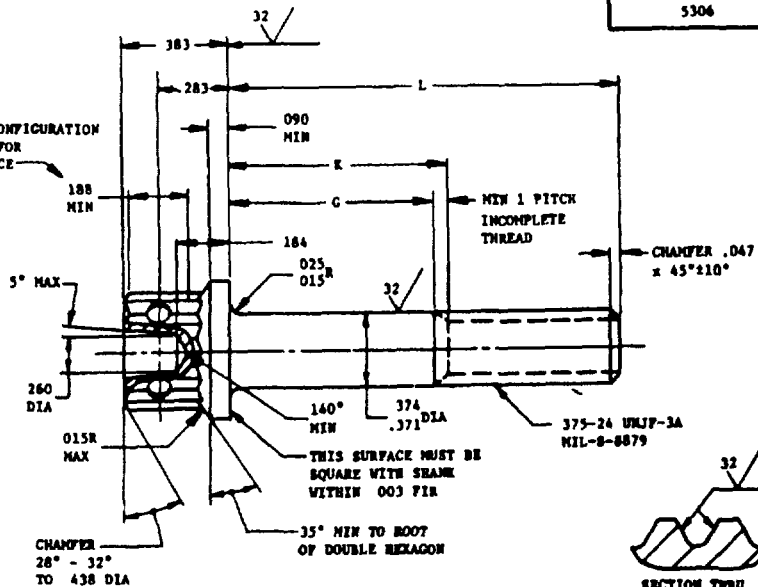
MS9944

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

WRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE



.070 DIA 4 HOLES
EQUALLY SPACED AS SHOWN
CSK 90° TO .100 DIA



SECTION THRU
THREAD PROFILE

PART NO	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9944-13	1.188	.045	.188	4.90
MS9944-14	1.250	.107	.250	5.10
MS9944-15	1.312	.169	.312	5.30
MS9944-16	1.375	.232	.375	5.49
MS9944-17	1.438	.295	.438	5.69
MS9944-18	1.500	.357	.500	5.88
MS9944-19	1.562	.419	.562	6.08
MS9944-20	1.625	.482	.625	6.27
MS9944-21	1.688	.545	.688	6.47
MS9944-22	1.750	.607	.750	6.66
MS9944-23	1.812	.669	.812	6.86
MS9944-24	1.875	.732	.875	7.05
MS9944-25	1.938	.795	.938	7.25
MS9944-26	2.000	.857	1.000	7.44
MS9944-27	2.125	.982	1.125	7.83
MS9944-28	2.250	1.107	1.250	7.22

PART NO	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9944-29	2.375	1.232	1.375	8.61
MS9944-30	2.500	1.357	1.500	9.00
MS9944-31	2.625	1.482	1.625	9.39
MS9944-32	2.750	1.607	1.750	9.78
MS9944-33	2.875	1.732	1.875	10.17
MS9944-34	3.000	1.857	2.000	10.56
MS9944-35	3.125	1.982	2.125	10.95
MS9944-36	3.250	2.107	2.250	11.34
MS9944-37	3.375	2.232	2.375	11.73
MS9944-38	3.500	2.357	2.500	12.12
MS9944-39	3.625	2.482	2.625	12.51
MS9944-40	3.750	2.607	2.750	12.90
MS9944-41	3.875	2.732	2.875	13.29
MS9944-42	4.000	2.857	3.000	13.68
MS9944-43	4.125	2.982	3.125	14.07
MS9944-44	4.250	3.107	3.250	14.46
MS9944-45	4.375	3.232	3.375	14.85
MS9944-46	4.500	3.357	3.500	15.24

PART NO	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9944-47	4.625	3.482	3.625	15.63
MS9944-48	4.750	3.607	3.750	16.02
MS9944-49	4.875	3.732	3.875	16.41
MS9944-50	5.000	3.857	4.000	16.80
MS9944-51	5.125	3.982	4.125	17.19
MS9944-52	5.250	4.107	4.250	17.48
MS9944-53	5.375	4.232	4.375	17.87
MS9944-54	5.500	4.357	4.500	18.26
MS9944-55	5.625	4.482	4.625	18.65
MS9944-56	5.750	4.607	4.750	19.04
MS9944-57	5.875	4.732	4.875	19.43
MS9944-58	6.000	4.857	5.000	19.82

- SHANK SHALL BE STRAIGHT WITHIN .0025 TOTAL PER INCH OF BOLT LENGTH.
- THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .004 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .009 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 Case NAVY - AS	TITLE BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, FULL SHANK, STEEL AMS 6322, CADMIUM PLATED, 375-24 UNJF-3A	MILITARY STANDARD MS 9944 SHEET 1 OF 1
PROCUREMENT SPECIFICATION AMS-7452	SUPERSEDES	

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

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

☆ U S GOVERNMENT PRINTING OFFICE 1971-433-696/4877

User activities
Navy - MC, C6

Review activities
Air Force - B2
Navy - A5

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.

APPROVED 30 Dec 70 REVISED