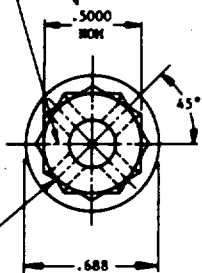
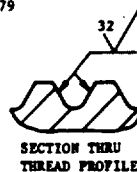
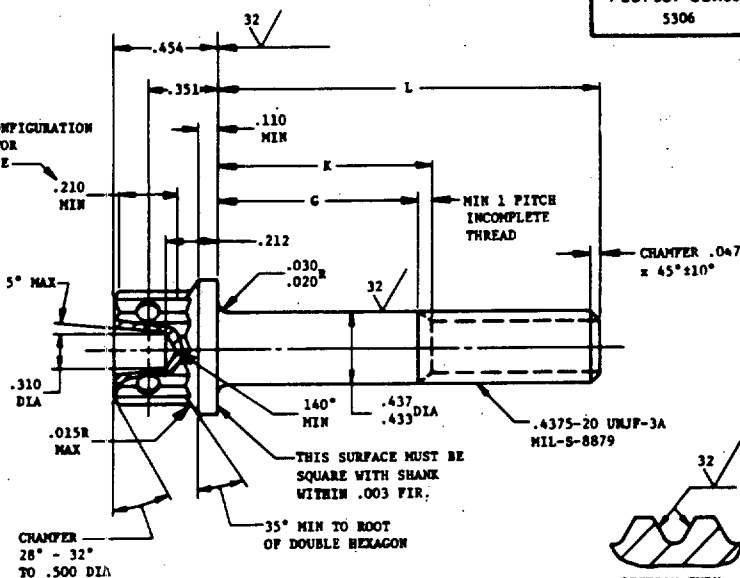


MS9945MARK PART NUMBER
AND MANUFACTURER'S IDENT
PER AS 478 CLASS AWRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE.070 DIA 4 HOLES
EQUALLY SPACED AS SHOWN
CSK 90° TO .100 DIASECTION THRU
THREAD PROFILEUser activities:
Navy - MC, CGReview activities:
Air Force - 82
Navy - AS

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
MS9945-15	1.375	.090	.250	7.88
MS9945-16	1.438	.152	.312	8.14
MS9945-17	1.500	.215	.375	8.41
MS9945-18	1.562	.278	.438	8.68
MS9945-19	1.625	.340	.500	8.94
MS9945-20	1.688	.402	.562	9.20
MS9945-21	1.750	.465	.625	9.46
MS9945-22	1.812	.528	.688	9.73
MS9945-23	1.875	.590	.750	10.00
MS9945-24	1.938	.652	.812	10.26
MS9945-25	2.000	.715	.875	10.53
MS9945-26	2.125	.840	1.000	11.06
MS9945-27	2.250	.965	1.125	11.59
MS9945-28	2.375	1.090	1.250	12.12
MS9945-29	2.500	1.215	1.375	12.66

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9945-30	2.625	1.340	1.500	13.19
MS9945-31	2.750	1.465	1.625	13.72
MS9945-32	2.875	1.590	1.750	14.25
MS9945-33	3.000	1.715	1.875	14.78
MS9945-34	3.125	1.840	2.000	15.33
MS9945-35	3.250	1.965	2.125	15.84
MS9945-36	3.375	2.090	2.250	16.38
MS9945-37	3.500	2.215	2.375	16.91
MS9945-38	3.625	2.340	2.500	17.44
MS9945-39	3.750	2.465	2.625	17.98
MS9945-40	3.875	2.590	2.750	18.51
MS9945-41	4.000	2.715	2.875	19.04
MS9945-42	4.125	2.840	3.000	19.57
MS9945-43	4.250	2.965	3.125	20.10
MS9945-44	4.375	3.090	3.250	20.64
MS9945-45	4.500	3.215	3.375	21.17
MS9945-46	4.625	3.340	3.500	21.70
MS9945-47	4.750	3.465	3.625	22.23

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9945-48	4.875	3.590	3.750	22.76
MS9945-49	5.000	3.715	3.875	23.30
MS9945-50	5.125	3.840	4.000	23.83
MS9945-51	5.250	3.965	4.125	24.36
MS9945-52	5.375	4.090	4.250	24.89
MS9945-53	5.500	4.215	4.375	25.42
MS9945-54	5.625	4.340	4.500	26.49
MS9945-55	5.750	4.465	4.625	27.02
MS9945-56	5.875	4.590	4.750	27.55
MS9945-57	6.000	4.715	4.875	28.08

- 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 .006 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .010 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.	TITLE
AIR FORCE - 11 Other Code NAVY - AS	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER. HEAD DRILLED, FULL SHANK, STEEL AMS 6322, CADMIUM PLATED .4375-20 UNJF-3A

PROCUREMENT SPECIFICATION
AMS-7452

SUPERSEDES:

MILITARY STANDARD

MS 9945

SHEET 1 OF 1

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

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

☆ U. S. GOVERNMENT PRINTING OFFICE: 1971-433-696/4878

APPROVED 30 Dec 70 REVISED