

NOTICE

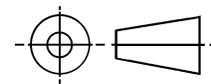
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THIRD ANGLE PROJECTION



ISSUED 1998-11 REAFFIRMED 2004-07

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PREPARED BY COMMITTEE E-25

PROCUREMENT SPECIFICATION: NONE



**AEROSPACE STANDARD**

BOLT, MACHINE-STEEL, AMS 6322, BLACK OXIDE, HEXAGON HEAD, .250-28 UNJF-3A

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SHEET 1 OF 4

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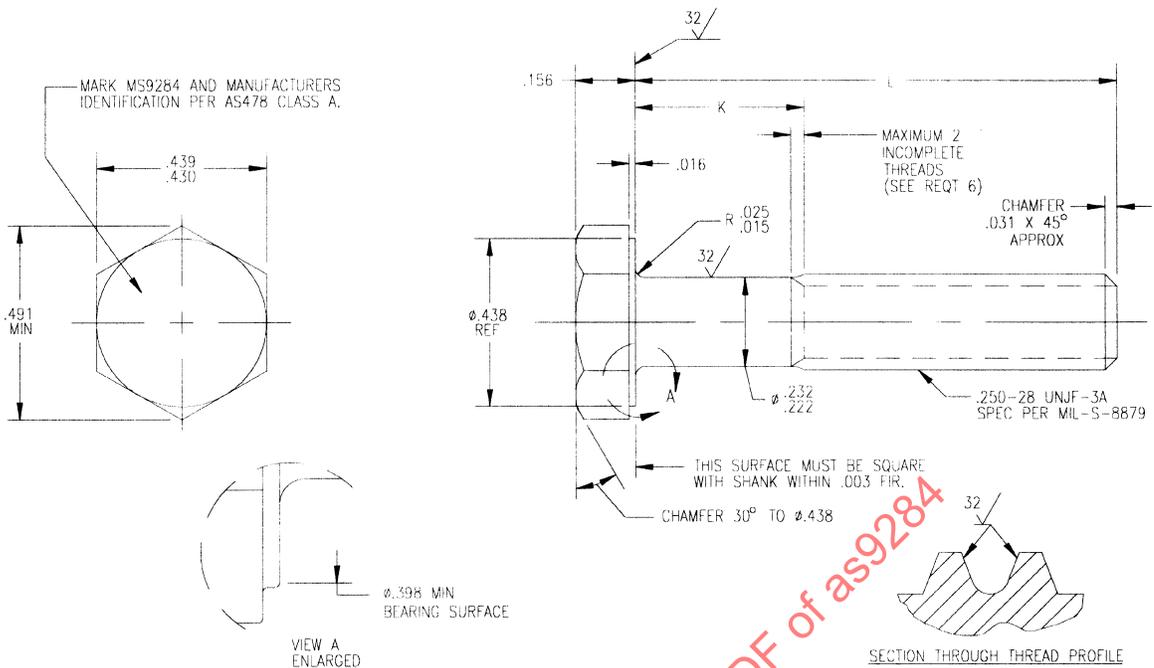


FIGURE 1 - BOLT

TABLE I - PART NUMBERS AND DIMENSIONS

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9284-04	.375	.079-.099	1.16	MS9284-16	1.125	.315-.375	2.01
MS9284-05	.438	.079-.099	1.23	MS9284-17	1.188	.378-.438	2.09
MS9284-06	.500	.079-.099	1.30	MS9284-18	1.250	.440-.500	2.16
MS9284-07	.562	.079-.099	1.37	MS9284-19	1.312	.502-.562	2.23
MS9284-08	.625	.079-.099	1.44	MS9284-20	1.375	.565-.625	2.30
MS9284-09	.688	.079-.099	1.51	MS9284-21	1.438	.628-.688	2.37
MS9284-10	.750	.079-.099	1.58	MS9284-22	1.500	.690-.750	2.44
MS9284-11	.812	.079-.099	1.66	MS9284-23	1.562	.752-.812	2.52
MS9284-12	.875	.079-.125	1.73	MS9284-24	1.625	.815-.875	2.59
MS9284-13	.938	.128-.188	1.80	MS9284-25	1.688	.878-.938	2.66
MS9284-14	1.000	.190-.250	1.87	MS9284-26	1.750	.940-1.000	2.73
MS9284-15	1.062	.252-.312	1.94	MS9284-27	1.875	1.065-1.125	2.87

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TABLE I - PART NUMBERS AND DIMENSIONS - CONTINUED

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9284-28	2.000	1.190-1.250	3.02	MS9284-46	4.250	3.440-3.500	5.60
MS9284-29	2.125	1.315-1.375	3.16	MS9284-47	4.375	3.565-3.625	5.74
MS9284-30	2.250	1.440-1.500	3.30	MS9284-48	4.500	3.690-3.750	5.89
MS9284-31	2.375	1.565-1.625	3.45	MS9284-49	4.625	3.815-3.875	6.03
MS9284-32	2.500	1.690-1.750	3.59	MS9284-50	4.750	3.940-4.000	6.17
MS9284-33	2.625	1.815-1.875	3.73	MS9284-51	4.875	4.065-4.125	6.32
MS9284-34	2.750	1.940-2.000	3.88	MS9284-52	5.000	4.190-4.250	6.46
MS9284-35	2.875	2.065-2.125	4.02	MS9284-53	5.125	4.315-4.375	6.60
MS9284-36	3.000	2.190-2.250	4.16	MS9284-54	5.250	4.440-4.500	6.75
MS9284-37	3.125	2.315-2.375	4.31	MS9284-55	5.375	4.565-4.625	6.89
MS9284-38	3.250	2.440-2.500	4.45	MS9284-56	5.500	4.690-4.750	7.03
MS9284-39	3.375	2.565-2.625	4.60	MS9284-57	5.625	4.815-4.875	7.18
MS9284-40	3.500	2.690-2.750	4.74	MS9284-58	5.750	4.940-5.000	7.32
MS9284-41	3.625	2.815-2.875	4.88	MS9284-59	5.875	5.065-5.125	7.46
MS9284-42	3.750	2.940-3.000	5.03	MS9284-60	6.000	5.190-5.250	7.61
MS9284-43	3.875	3.065-3.125	5.17				
MS9284-44	4.000	3.190-3.250	5.31				
MS9284-45	4.125	3.315-3.375	5.46				

## REQUIREMENTS:

- MATERIAL: STEEL, AMS 6322.
- HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
- SHANK SHALL BE STRAIGHT WITHIN .003 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 HEXAGON SHALL BE WITHIN .013 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- HARDNESS: ROCKWELL C26-32.
- FINISH: BLACK OXIDE TREATMENT AMS 2485.
- MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD MUST BE UPSET.
- MAGNETIC PARTICLE INSPECTION PER AMS 2640.
- SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON.