

REV.  
B

RATIONALE

FIGURE REDRAWN , THREAD SPEC REVISED, CORRECT CADMIUM WARNING NOTE ADDED, INVENTORY/USE NOTE 14 ADDED.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9402 (ASG). THIS SAE STANDARD RETAINS THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

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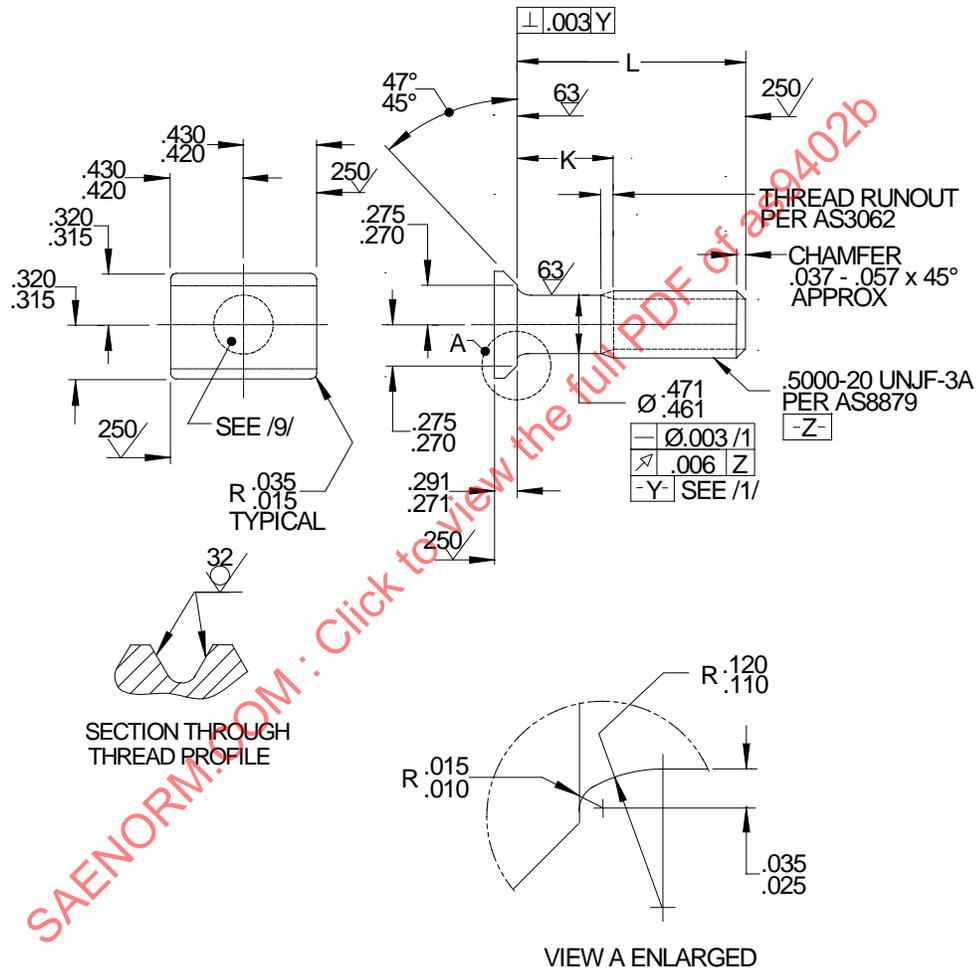
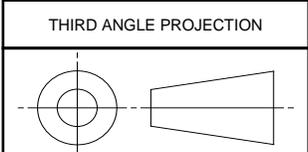


FIGURE 1 - BOLT

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CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7452



**AEROSPACE STANDARD**

(R) BOLT, TEE HEAD - CADMIUM PLATED, STEEL, UNS G87400, 125 KSI MIN, CHAMFERED, .5000-20 UNJF-3A

AS9402™  
SHEET 1 OF 3

REV.  
B

**TABLE 1 - PART NUMBERS AND DIMENSIONS**

PART NUMBER	L	K	APPROX. MASS LB/100	PART NUMBER	L	K	APPROX. MASS LB/100
MS9402-05	.865 - .885	.155 - .175	8.41	MS9402-30	3.115 - 3.135	1.815 - 1.875	19.29
MS9402-06	.928 - .948	.155 - .175	8.71	MS9402-31	3.240 - 3.260	1.940 - 2.000	19.89
MS9402-07	.990 - 1.010	.155 - .175	9.01	MS9402-32	3.365 - 3.385	2.065 - 2.125	20.50
MS9402-08	1.052 - 1.072	.155 - .175	9.32	MS9402-33	3.490 - 3.510	2.190 - 2.250	21.10
MS9402-09	1.115 - 1.135	.155 - .175	9.62	MS9402-34	3.615 - 3.635	2.315 - 2.375	21.70
MS9402-10	1.178 - 1.198	.155 - .175	9.92	MS9402-35	3.740 - 3.760	2.440 - 2.500	22.31
MS9402-11	1.240 - 1.260	.155 - .175	10.22	MS9402-36	3.865 - 3.885	2.565 - 2.625	22.91
MS9402-12	1.302 - 1.322	.155 - .175	10.53	MS9402-37	3.990 - 4.010	2.690 - 2.750	23.52
MS9402-13	1.365 - 1.385	.155 - .175	10.83	MS9402-38	4.115 - 4.135	2.815 - 2.875	24.12
MS9402-14	1.428 - 1.448	.155 - .175	11.13	MS9402-39	4.240 - 4.260	2.940 - 3.000	24.72
MS9402-15	1.490 - 1.510	.190 - .250	11.43	MS9402-40	4.365 - 4.385	3.065 - 3.125	25.33
MS9402-16	1.552 - 1.572	.252 - .312	11.73	MS9402-41	4.490 - 4.510	3.190 - 3.250	25.93
MS9402-17	1.615 - 1.635	.315 - .375	12.04	MS9402-42	4.615 - 4.635	3.315 - 3.375	26.54
MS9402-18	1.678 - 1.698	.378 - .438	12.34	MS9402-43	4.740 - 4.760	3.440 - 3.500	27.14
MS9402-19	1.740 - 1.760	.440 - .500	12.64	MS9402-44	4.865 - 4.885	3.565 - 3.625	27.75
MS9402-20	1.865 - 1.885	.565 - .625	13.24	MS9402-45	4.990 - 5.010	3.690 - 3.750	28.35
MS9402-21	1.990 - 2.010	.690 - .750	13.85	MS9402-46	5.115 - 5.135	3.815 - 3.875	28.95
MS9402-22	2.115 - 2.135	.815 - .875	14.45	MS9402-47	5.240 - 5.260	3.940 - 4.000	29.56
MS9402-23	2.240 - 2.260	.940 - 1.000	15.06	MS9402-48	5.365 - 5.385	4.065 - 4.125	30.16
MS9402-24	2.365 - 2.385	1.065 - 1.125	15.66	MS9402-49	5.490 - 5.510	4.190 - 4.250	30.77
MS9402-25	2.490 - 2.510	1.190 - 1.250	16.27	MS9402-50	5.615 - 5.635	4.315 - 4.375	31.37
MS9402-26	2.615 - 2.635	1.315 - 1.375	16.87	MS9402-51	5.740 - 5.760	4.440 - 4.500	31.98
MS9402-27	2.740 - 2.760	1.440 - 1.500	17.47	MS9402-52	5.865 - 5.885	4.565 - 4.625	32.58
MS9402-28	2.865 - 2.885	1.565 - 1.625	18.08	MS9402-53	5.990 - 6.010	4.690 - 4.750	33.18
MS9402-29	2.990 - 3.010	1.690 - 1.750	18.68				

NOTES:

**NOTICE**

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

- FOR PART NUMBERS MS9402-05 THRU MS9402-22 THE THREAD PD DATUM -Z- SHALL REPLACE DATUM -Y-.
- MATERIAL: LOW ALLOY STEEL AMS6322 (UNS G87400).
- PROCUREMENT SPECIFICATION: AS7452, EXCEPT HEAD SHALL BE UPSET.
- HEAD TO SHANK FILLET SHALL BE COLD ROLLED.
- FINISH: CADMIUM PLATE PER AMS2400. DIMENSIONS ARE AFTER PLATING.
- MAGNETIC PARTICLE INSPECTION PER ASTM E1444/E1444M AFTER PLATING.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.

	<b>AEROSPACE STANDARD</b>	<b>AS9402™</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
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