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FEDERAL SUPPLY CLASS
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AS9452

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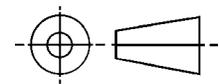
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THIS DOCUMENT INCLUDES CADMIUM AS A PLATING MATERIAL. THE USE OF CADMIUM HAS BEEN RESTRICTED AND/OR BANNED FOR USE IN MANY COUNTRIES DUE TO ENVIRONMENTAL AND HEALTH CONCERNS. THE USER SHOULD CONSULT WITH LOCAL OFFICIALS ON THE ENVIRONMENTAL AND HEALTH REGULATIONS REGARDING ITS USE.

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THIRD ANGLE PROJECTION



ISSUED 1998-08 REVISED 2001-12

PREPARED BY SAE COMMITTEE E-25, GENERAL STANDARDS FOR AEROSPACE PROPULSION SYSTEMS



AEROSPACE STANDARD

(R) BOLT, MACHINE - STEEL, DIFFUSED NICKEL-CADMIUM PLATED, HEXAGON HEAD, UNS K14675, 195 KSI MIN, .2500-28 UNJF-3A

AS9452
SHEET 1 OF 4

**REV.
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REV.
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AS9452

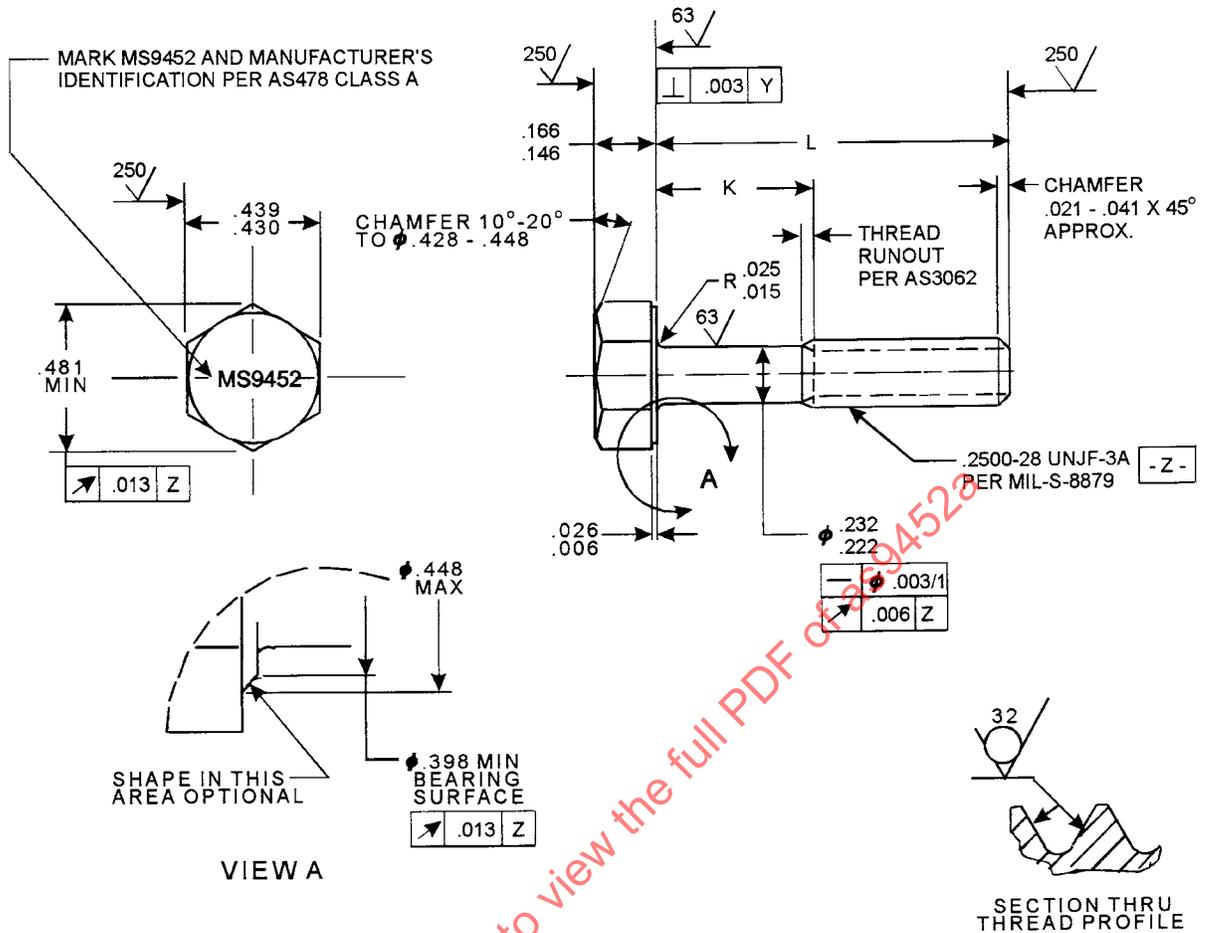


FIGURE 1 - BOLT

REV.
A

AS9452

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	K	APPROX. MASS LB/100	PART NO.	L	K	APPROX. MASS LB/100
MS9452-04	.365 - .385	.079 - .099	1.16	MS9452-34	2.740 - 2.760	1.940 - 2.000	3.88
MS9452-05	.428 - .448	.079 - .099	1.23	MS9452-35	2.865 - 2.885	2.065 - 2.125	4.02
MS9452-06	.490 - .510	.079 - .099	1.30	MS9452-36	2.990 - 3.010	2.190 - 2.250	4.16
MS9452-07	.552 - .572	.079 - .099	1.37	MS9452-37	3.115 - 3.135	2.315 - 2.375	4.31
MS9452-08	.615 - .635	.079 - .099	1.44	MS9452-38	3.240 - 3.260	2.440 - 2.500	4.45
MS9452-09	.678 - .698	.079 - .099	1.51	MS9452-39	3.365 - 3.385	2.565 - 2.625	4.60
MS9452-10	.740 - .760	.079 - .099	1.58	MS9452-40	3.490 - 3.510	2.690 - 2.750	4.74
MS9452-11	.802 - .822	.079 - .099	1.66	MS9452-41	3.615 - 3.635	2.815 - 2.875	4.88
MS9452-12	.865 - .885	.125 - .145	1.73	MS9452-42	3.740 - 3.760	2.940 - 3.000	5.03
MS9452-13	.928 - .948	.128 - .188	1.80	MS9452-43	3.865 - 3.885	3.065 - 3.125	5.17
MS9452-14	.990 - 1.010	.190 - .250	1.87	MS9452-44	3.990 - 4.010	3.190 - 3.250	5.31
MS9452-15	1.052 - 1.072	.252 - .312	1.94	MS9452-45	4.115 - 4.135	3.315 - 3.375	5.46
MS9452-16	1.115 - 1.135	.315 - .375	2.01	MS9452-46	4.240 - 4.260	3.440 - 3.500	5.60
MS9452-17	1.178 - 1.198	.378 - .438	2.09	MS9452-47	4.365 - 4.385	3.565 - 3.625	5.74
MS9452-18	1.240 - 1.260	.440 - .500	2.16	MS9452-48	4.490 - 4.510	3.690 - 3.750	5.89
MS9452-19	1.302 - 1.322	.502 - .562	2.23	MS9452-49	4.615 - 4.635	3.815 - 3.875	6.03
MS9452-20	1.365 - 1.385	.565 - .625	2.30	MS9452-50	4.740 - 4.760	3.940 - 4.000	6.17
MS9452-21	1.428 - 1.448	.628 - .688	2.37	MS9452-51	4.865 - 4.885	4.065 - 4.125	6.32
MS9452-22	1.490 - 1.510	.690 - .750	2.44	MS9452-52	4.990 - 5.010	4.190 - 4.250	6.46
MS9452-23	1.552 - 1.572	.752 - .812	2.52	MS9452-53	5.115 - 5.135	4.315 - 4.375	6.60
MS9452-24	1.615 - 1.635	.815 - .875	2.59	MS9452-54	5.240 - 5.260	4.440 - 4.500	6.75
MS9452-25	1.678 - 1.698	.878 - .938	2.66	MS9452-55	5.365 - 5.385	4.565 - 4.625	6.89
MS9452-26	1.740 - 1.760	.940 - 1.000	2.73	MS9452-56	5.490 - 5.510	4.690 - 4.750	7.03
MS9452-27	1.865 - 1.885	1.065 - 1.125	2.87	MS9452-57	5.615 - 5.635	4.815 - 4.875	7.18
MS9452-28	1.990 - 2.010	1.190 - 1.250	3.02	MS9452-58	5.740 - 5.760	4.940 - 5.000	7.32
MS9452-29	2.115 - 2.135	1.315 - 1.375	3.16	MS9452-59	5.865 - 5.885	5.065 - 5.125	7.46
MS9452-30	2.240 - 2.260	1.440 - 1.500	3.30	MS9452-60	5.990 - 6.010	5.190 - 5.250	7.61
MS9452-31	2.365 - 2.385	1.565 - 1.625	3.45				
MS9452-32	2.490 - 2.510	1.690 - 1.750	3.59				
MS9452-33	2.615 - 2.635	1.815 - 1.875	3.73				

NOTES:

1. MATERIAL: LOW ALLOY STEEL AMS 6304 (UNS K14675).
2. PROCUREMENT SPECIFICATION: AS7455.
3. HARDNESS: 42-46 HRC.
4. FINISH: DIFFUSED NICKEL-CADMIUM PLATE AMS 2416. DIMENSIONS ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
5. MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 BEFORE PLATING.
6. INCOMPLETE THREADS NOT TO ENTER FILLET.
7. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
8. BREAK SHARP EDGES .003-.015, UNLESS OTHERWISE SPECIFIED.
9. DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982 (ASME PUBLICATION).
10. DIMENSIONS IN INCHES.
11. DO NOT USE UNASSIGNED PART NUMBERS.

AEROSPACE STANDARD

(R) BOLT, MACHINE - STEEL, DIFFUSED NICKEL-
CADMIUM PLATED, HEXAGON HEAD,
UNS K14675, 195 KSI MIN, .2500-28 UNJF-3A

AS9452
SHEET 3 OF 4

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