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**REV. C**

**AS9519**

FEDERAL SUPPLY CLASS  
5306

**RATIONALE**

THIS DOCUMENT HAS BEEN DETERMINED TO CONTAIN BASIC AND STABLE TECHNOLOGY WHICH IS NOT DYNAMIC IN NATURE.

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CUSTODIAN: E-25

|  |  |               |               |
|--|--|---------------|---------------|
|  | <b>AEROSPACE STANDARD</b>  | <b>AS9519</b> | <b>REV. C</b> |
|  | BOLT, MACHINE - HEXAGON HEAD, STEEL, CADMIUM PLATED, UNS G87400, 125 KSI MIN, .2500-28 UNJF-3A |               |               |

ISSUED 1999-04 REVISED 2007-07 STABILIZED 2015-06

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9519A. THIS SAE STANDARD RETAINS THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

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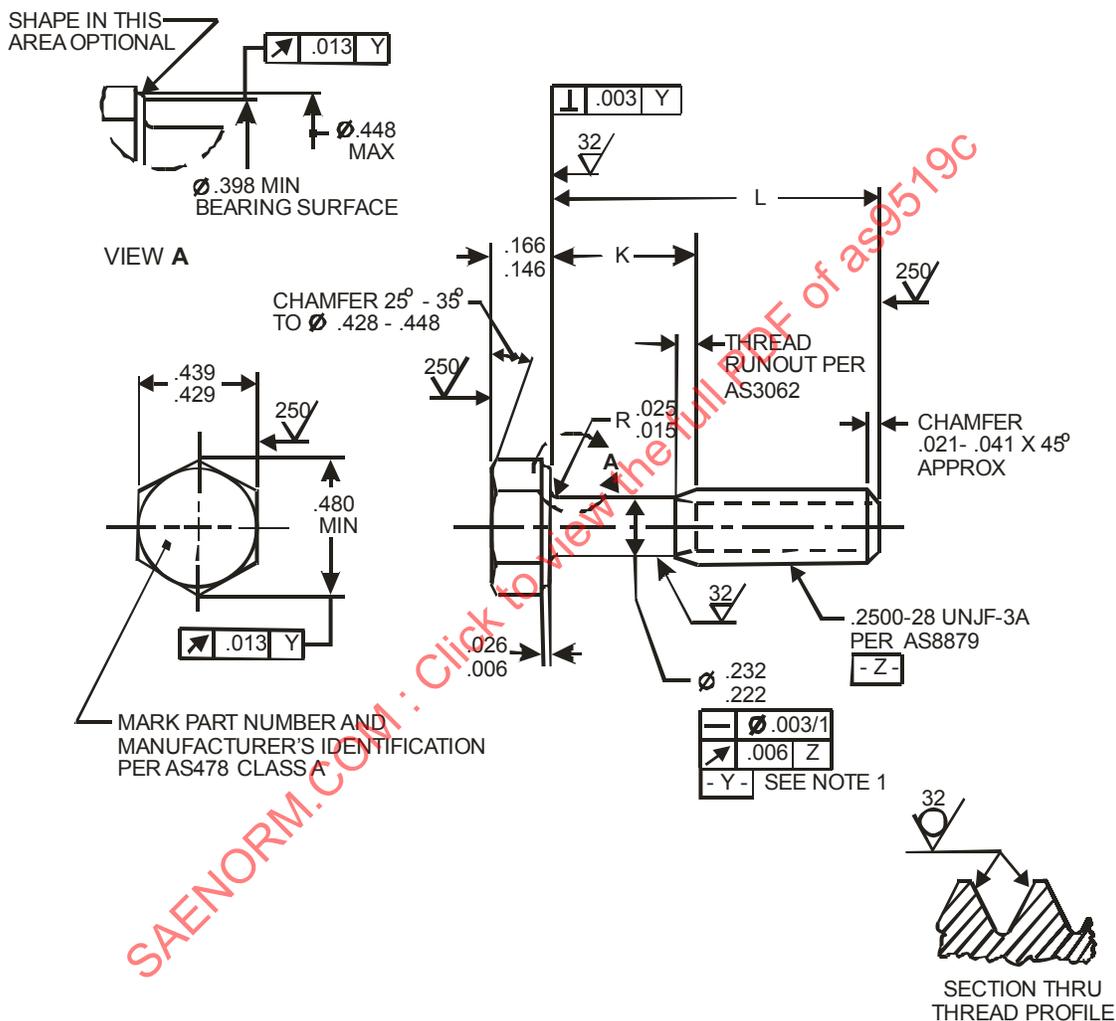


FIGURE 1 - BOLT

|  |  |                               |               |
|--|--|-------------------------------|---------------|
|  | <b>AEROSPACE STANDARD</b>  | <b>AS9519</b><br>SHEET 1 OF 3 | <b>REV. C</b> |
|  | BOLT, MACHINE - HEXAGON HEAD, STEEL,<br>CADMIUM PLATED, UNS G87400, 125 KSI MIN,<br>.2500-28 UNJF-3A |                               |               |

TABLE 1 - PART NUMBERS AND DIMENSIONS

| PART NO.  | L           | K           | APPROX. MASS LB/100 | PART NO.  | L           | K           | APPROX. MASS LB/100 |
|-----------|-------------|-------------|---------------------|-----------|-------------|-------------|---------------------|
| MS9519-04 | .365- .385  | .079- .099  | 1.16                | MS9519-34 | 2.740-2.760 | 1.940-2.000 | 3.88                |
| MS9519-05 | .428- .448  | .079- .099  | 1.23                | MS9519-35 | 2.865-2.885 | 2.065-2.125 | 4.02                |
| MS9519-06 | .490- .510  | .079- .099  | 1.30                | MS9519-36 | 2.990-3.010 | 2.190-2.250 | 4.16                |
| MS9519-07 | .552- .572  | .079- .099  | 1.37                | MS9519-37 | 3.115-3.135 | 2.315-2.375 | 4.31                |
| MS9519-08 | .615- .635  | .079- .099  | 1.44                | MS9519-38 | 3.240-3.260 | 2.440-2.500 | 4.45                |
| MS9519-09 | .678- .698  | .079- .099  | 1.51                | MS9519-39 | 3.365-3.385 | 2.565-2.625 | 4.60                |
| MS9519-10 | .740- .760  | .079- .099  | 1.58                | MS9519-40 | 3.490-3.510 | 2.690-2.750 | 4.74                |
| MS9519-11 | .802- .822  | .079- .099  | 1.66                | MS9519-41 | 3.615-3.635 | 2.815-2.875 | 4.88                |
| MS9519-12 | .865- .885  | .079- .125  | 1.73                | MS9519-42 | 3.740-3.760 | 2.940-3.000 | 5.03                |
| MS9519-13 | .928- .948  | .128- .188  | 1.80                | MS9519-43 | 3.865-3.885 | 3.065-3.125 | 5.17                |
| MS9519-14 | .990-1.010  | .190- .250  | 1.87                | MS9519-44 | 3.990-4.010 | 3.190-3.250 | 5.31                |
| MS9519-15 | 1.052-1.072 | .252- .312  | 1.94                | MS9519-45 | 4.115-4.135 | 3.315-3.375 | 5.46                |
| MS9519-16 | 1.115-1.135 | .315- .375  | 2.01                | MS9519-46 | 4.240-4.260 | 3.440-3.500 | 5.60                |
| MS9519-17 | 1.178-1.198 | .378- .438  | 2.09                | MS9519-47 | 4.365-4.385 | 3.565-3.625 | 5.74                |
| MS9519-18 | 1.240-1.260 | .440- .500  | 2.16                | MS9519-48 | 4.490-4.510 | 3.690-3.750 | 5.89                |
| MS9519-19 | 1.302-1.322 | .502- .562  | 2.23                | MS9519-49 | 4.615-4.635 | 3.815-3.875 | 6.03                |
| MS9519-20 | 1.365-1.385 | .565- .625  | 2.30                | MS9519-50 | 4.740-4.760 | 3.940-4.000 | 6.17                |
| MS9519-21 | 1.428-1.448 | .628- .688  | 2.37                | MS9519-51 | 4.865-4.885 | 4.065-4.125 | 6.32                |
| MS9519-22 | 1.490-1.510 | .690- .750  | 2.44                | MS9519-52 | 4.990-5.010 | 4.190-4.250 | 6.46                |
| MS9519-23 | 1.552-1.572 | .752- .812  | 2.52                | MS9519-53 | 5.115-5.135 | 4.315-4.375 | 6.60                |
| MS9519-24 | 1.615-1.635 | .815- .875  | 2.59                | MS9519-54 | 5.240-5.260 | 4.440-4.500 | 6.75                |
| MS9519-25 | 1.678-1.698 | .878- .938  | 2.66                | MS9519-55 | 5.365-5.385 | 4.565-4.625 | 6.89                |
| MS9519-26 | 1.740-1.760 | .940-1.000  | 2.73                | MS9519-56 | 5.490-5.510 | 4.690-4.750 | 7.03                |
| MS9519-27 | 1.865-1.885 | 1.065-1.125 | 2.87                | MS9519-57 | 5.615-5.635 | 4.815-4.875 | 7.18                |
| MS9519-28 | 1.990-2.010 | 1.190-1.250 | 3.02                | MS9519-58 | 5.740-5.760 | 4.940-5.000 | 7.32                |
| MS9519-29 | 2.115-2.135 | 1.315-1.375 | 3.16                | MS9519-59 | 5.865-5.885 | 5.065-5.125 | 7.46                |
| MS9519-30 | 2.240-2.260 | 1.440-1.500 | 3.30                | MS9519-60 | 5.990-6.010 | 5.190-5.250 | 7.61                |
| MS9519-31 | 2.365-2.385 | 1.565-1.625 | 3.45                |           |             |             |                     |
| MS9519-32 | 2.490-2.510 | 1.690-1.750 | 3.59                |           |             |             |                     |
| MS9519-33 | 2.615-2.635 | 1.815-1.875 | 3.73                |           |             |             |                     |

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 MS9519-04 THRU MS9519-18 THE THREAD PD (DATUM  $\square$ -Z) SHALL REPLACE DATUM  $\square$ -Y.
- MATERIAL: LOW ALLOY STEEL AMS 6322 (UNS G87400).
- PROCUREMENT SPECIFICATION: AS7452.
- HEAD TO SHANK FILLET RADIUS: FOR PART NUMBERS MS9519-15 AND LARGER, THE HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.

|   |  |                               |                         |
|---|--|-------------------------------|-------------------------|
|  | <b>AEROSPACE STANDARD</b>  | <b>AS9519</b><br>SHEET 2 OF 3 | <b>REV.</b><br><b>C</b> |
|   | BOLT, MACHINE - HEXAGON HEAD, STEEL,<br>CADMIUM PLATED, UNS G87400, 125 KSI MIN,<br>.2500-28 UNJF-3A |                               |                         |