

RATIONALE

RESTORE ORIGINAL MAGNETIC PARTICLE TEST REQUIREMENT, REVISE LIGHTENING HOLE CONFIGURATION TO ALLOW OPTIONAL SHAPE, ADD EDGE DISTANCE EXCEPTION FOR HEAD MARKING, UPDATE THREADS TO AS8879, UPDATE COLD ROLLING DRAWING NOTE, UPDATE SURFACE FINISH REQUIREMENTS, DELETE .015 MAX RADIUS AT BASE OF WRENCH PAD, AND FIGURE 1 REDRAWN

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9923(ASG), NOTICE 1. THIS SAE STANDARD RETAINS THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

ANY REQUIREMENTS ASSOCIATED WITH QUALIFIED PRODUCTS LISTS (QPL) MAY CONTINUE TO BE MANDATORY FOR DOD CONTRACTS. REQUIREMENTS RELATING TO QPLS HAVE NOT BEEN ADOPTED BY THE SAE FOR THIS STANDARD AND ARE NOT PART OF THIS SAE DOCUMENT.

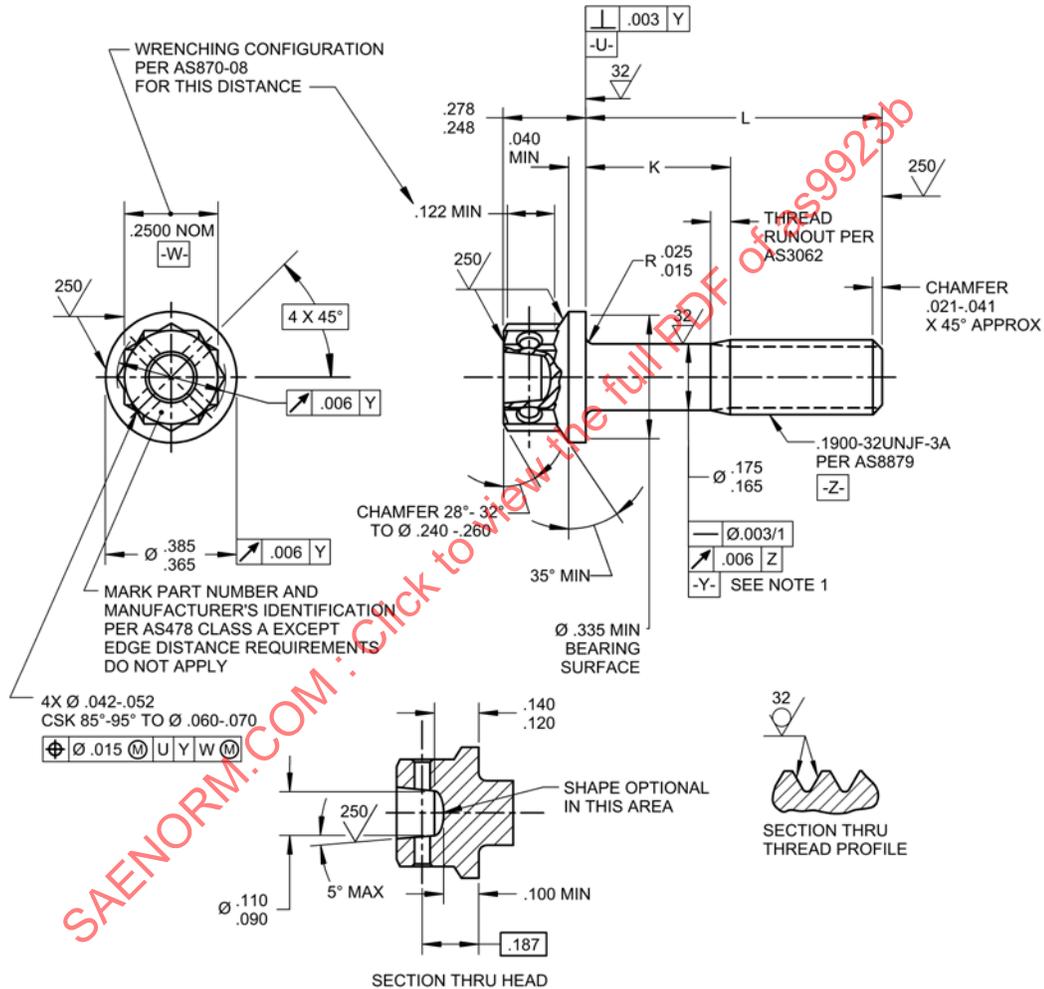
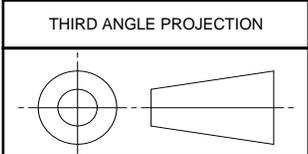


FIGURE 1 - BOLT

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REV. B
AS9923

CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7452 /2/



AEROSPACE STANDARD
(R) BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, PD SHANK, CADMIUM PLATED, STEEL, UNS G87400, 125 KSI MIN, .1900-32 UNJF-3A

AS9923
SHEET 1 OF 3

REV. B

ISSUED 1998-05 REAFFIRMED 2007-06 REVISED 2015-07

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	K	APPROX. MASS LB/100	PART NO.	L	K	APPROX. MASS LB/100
MS9923-03	.302- .322	.072- .092	.65	MS9923-27	1.802-1.822	1.122-1.182	1.60
MS9923-04	.365- .385	.072- .092	.69	MS9923-28	1.865-1.885	1.185-1.245	1.64
MS9923-05	.428- .448	.072- .092	.72	MS9923-29	1.928-1.948	1.248-1.308	1.68
MS9923-06	.490- .510	.072- .092	.76	MS9923-30	1.990-2.010	1.310-1.370	1.72
MS9923-07	.552- .572	.072- .092	.80	MS9923-31	2.115-2.135	1.435-1.495	1.80
MS9923-08	.615- .635	.072- .092	.84	MS9923-32	2.240-2.260	1.560-1.620	1.88
MS9923-09	.678- .698	.072- .092	.88	MS9923-33	2.365-2.385	1.685-1.745	1.96
MS9923-10	.740- .760	.072- .120	.92	MS9923-34	2.490-2.510	1.810-1.870	2.04
MS9923-11	.802- .822	.122- .182	.98	MS9923-35	2.615-2.635	1.935-1.995	2.12
MS9923-12	.865- .885	.185- .245	1.00	MS9923-36	2.740-2.760	2.060-2.120	2.20
MS9923-13	.928- .948	.248- .308	1.04	MS9923-37	2.865-2.885	2.185-2.245	2.28
MS9923-14	.990-1.010	.310- .370	1.08	MS9923-38	2.990-3.010	2.310-2.370	2.36
MS9923-15	1.052-1.072	.372- .432	1.12	MS9923-39	3.115-3.135	2.435-2.495	2.44
MS9923-16	1.115-1.135	.435- .495	1.16	MS9923-40	3.240-3.260	2.560-2.620	2.52
MS9923-17	1.178-1.198	.498- .558	1.20	MS9923-41	3.365-3.385	2.685-2.745	2.61
MS9923-18	1.240-1.260	.560- .620	1.24	MS9923-42	3.490-3.510	2.810-2.870	2.69
MS9923-19	1.302-1.322	.622- .682	1.28	MS9923-43	3.615-3.635	2.935-2.995	2.77
MS9923-20	1.365-1.385	.685- .745	1.32	MS9923-44	3.740-3.760	3.060-3.120	2.85
MS9923-21	1.428-1.448	.748- .808	1.36	MS9923-45	3.865-3.885	3.185-3.245	2.93
MS9923-22	1.490-1.510	.810- .870	1.40				
MS9923-23	1.552-1.572	.872- .932	1.45				
MS9923-24	1.615-1.635	.935- .995	1.48				
MS9923-25	1.678-1.698	.998-1.058	1.52				
MS9923-26	1.740-1.760	1.060-1.120	1.56				

NOTES:

WARNING

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

- /1/ FOR PART NUMBERS MS9923-03 THRU MS9923-14 DATUM **Z** SHALL REPLACE DATUM **Y**.
- /2/ PROCUREMENT SPECIFICATION: AS7452, EXCEPT HEAD SHALL BE UPSET.
- 3. MATERIAL: LOW ALLOY STEEL AMS6322 (UNS G87400).
- 4. HEAD TO SHANK FILLET RADIUS: HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT. COLD ROLLING SHALL BE SUFFICIENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
- 5. FINISH: CADMIUM PLATE AMS2400. DIMENSIONS ARE AFTER PLATING.
- 6. MAGNETIC PARTICLE INSPECTION PER ASTM E1444/E1444M AFTER PLATING.
- 7. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICRINCHES Ra.
- 8. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
- 9. DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982 (ASME PUBLICATION).

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