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**REV. B**

**AS9944**

FEDERAL SUPPLY CLASS  
5306

**RATIONALE**

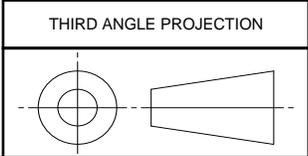
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CUSTODIAN: E-25 PROCUREMENT SPECIFICATION: /2/ AS7452

	<b>AEROSPACE STANDARD</b>	<b>AS9944</b>	<b>REV. B</b>
	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, FULL SHANK, STEEL AMS6322, CADMIUM PLATED, .3750-24 UNJF-3A		

ISSUED 2000-08 REAFFIRMED 2005-05 REVISED 2012-08 STABILIZED 2014-08

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9944, NOTICE. THIS SAE STANDARD MAY RETAIN THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

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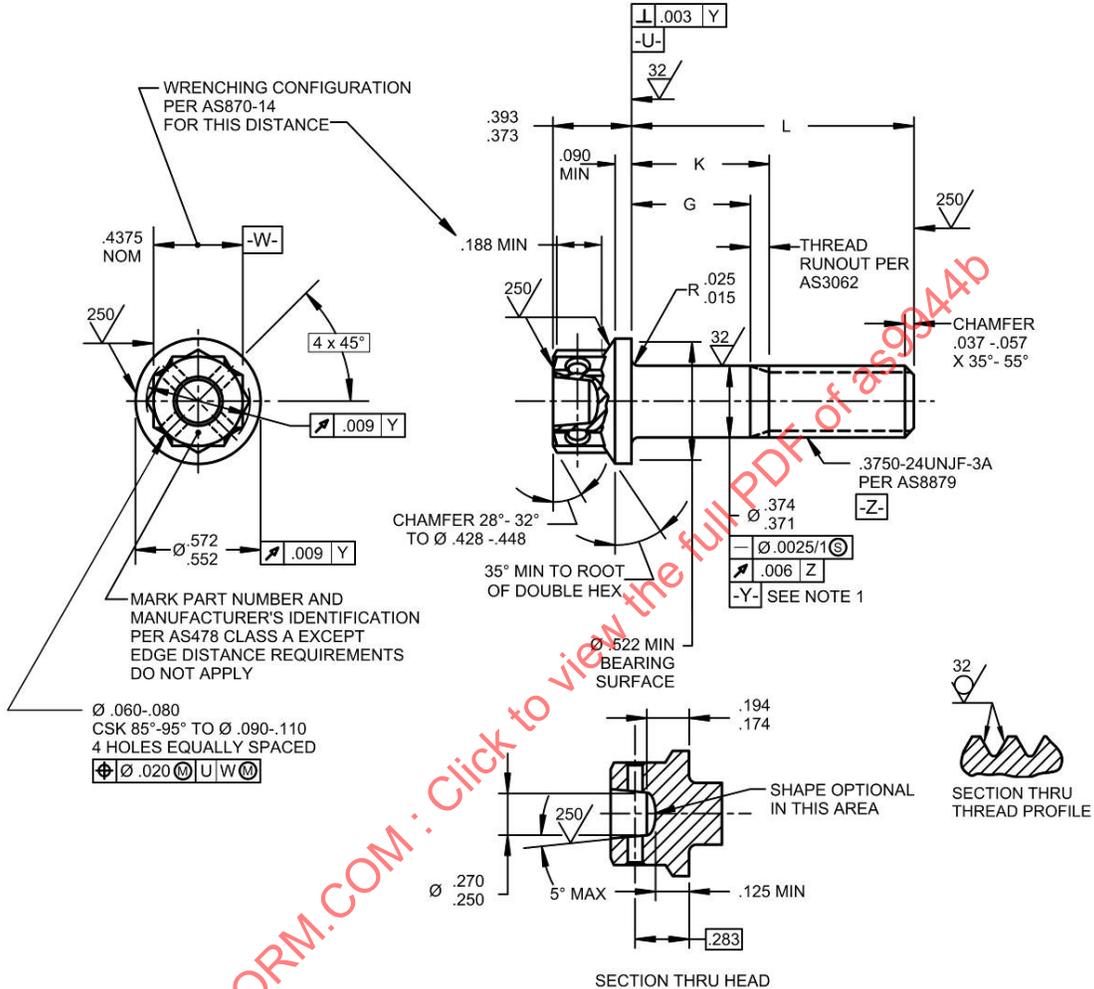


FIGURE 1 - BOLT

	<b>AEROSPACE STANDARD</b>	<b>AS9944</b> SHEET 1 OF 3	<b>REV.</b> <b>B</b>
	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, FULL SHANK, STEEL AMS6322, CADMIUM PLATED, .3750-24 UNJF-3A		

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	G MIN	K MAX	APPROX. MASS LB/100	PART NO.	L	G MIN	K MAX	APPROX. MASS LB/100
MS9944-13	1.178 -1.198	.045	.188	4.90	MS9944-37	3.365-3.385	2.232	2.375	11.73
MS9944-14	1.240-1.260	.107	.250	5.10	MS9944-38	3.490-3.510	2.357	2.500	12.12
MS9944-15	1.302-1.322	.169	.312	5.30	MS9944-39	3.615-3.635	2.482	2.625	12.51
MS9944-16	1.365-1.385	.232	.375	5.49	MS9944-40	3.740-3.760	2.607	2.750	12.90
MS9944-17	1.428-1.448	.295	.438	5.69	MS9944-41	3.865-3.885	2.732	2.875	13.29
MS9944-18	1.490-1.510	.357	.500	5.88	MS9944-42	3.990-4.010	2.857	3.000	13.68
MS9944-19	1.552-1.572	.419	.562	6.08	MS9944-43	4.115-4.135	2.982	3.125	14.07
MS9944-20	1.615-1.635	.482	.625	6.27	MS9944-44	4.240-4.260	3.107	3.250	14.44
MS9944-21	1.678-1.698	.545	.688	6.47	MS9944-45	4.365-4.385	3.232	3.375	14.85
MS9944-22	1.740-1.760	.607	.750	6.66	MS9944-46	4.490-4.510	3.357	3.500	15.24
MS9944-23	1.802-1.822	.641	.812	6.86	MS9944-47	4.615-4.635	3.482	3.625	15.63
MS9944-24	1.865-1.885	.732	.875	7.05	MS9944-48	4.740-4.760	3.607	3.750	16.02
MS9944-25	1.928-1.948	.795	.938	7.25	MS9944-49	4.865-4.885	3.732	3.875	16.41
MS9944-26	1.990-2.010	.837	1.000	7.44	MS9944-50	4.990-5.010	3.857	4.000	16.80
MS9944-27	2.115-2.135	.932	1.125	7.83	MS9944-51	5.115-5.135	3.982	4.125	17.19
MS9944-28	2.240-2.260	1.107	1.250	7.22	MS9944-52	5.240-5.260	4.107	4.250	17.48
MS9944-29	2.365-2.385	1.232	1.375	8.61	MS9944-53	5.365-5.385	4.232	4.375	17.87
MS9944-30	2.490-2.510	1.357	1.500	9.00	MS9944-54	5.490-5.510	4.357	4.500	18.24
MS9944-31	2.615-2.635	1.482	1.625	9.39	MS9944-55	5.615-5.635	4.482	4.625	18.65
MS9944-32	2.740-2.760	1.607	1.750	9.78	MS9944-56	5.740-5.760	4.607	4.750	19.04
MS9944-33	2.865-2.885	1.732	1.875	10.17	MS9944-57	5.865-5.885	4.732	4.875	19.43
MS9944-34	2.990-3.010	1.857	2.000	10.54	MS9944-58	5.990-6.010	4.857	5.000	19.82
MS9944-35	3.115-3.135	1.982	2.125	10.95					
MS9944-36	3.240-3.260	2.107	2.250	11.34					

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.

1. MATERIAL: STEEL AMS6322 (SAE 8740, COMPOSITION SIMILAR TO UNS G87400).
2. PROCUREMENT SPECIFICATION: AS7452 EXCEPT HEAD SHALL BE UPSET.
3. FINISH: CADMIUM PLATE AMS2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
4. HARDNESS: 26-32 HRC.
5. HEAD TO SHANK FILLET SHALL BE COLD WORKED.
6. MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 AFTER PLATING.
7. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra EXCEPT UPSET HEAD.

	<b>AEROSPACE STANDARD</b>	<b>AS9944</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
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