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AS9284

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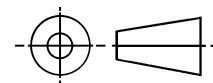
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THIRD ANGLE PROJECTION



PREPARED BY COMMITTEE E-25

PROCUREMENT SPECIFICATION: NONE

SAE Aerospace
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AEROSPACE STANDARD

BOLT, MACHINE-STEEL, AMS 6322, BLACK OXIDE,
HEXAGON HEAD, .250-28 UNJF-3A

AS9284
SHEET 1 OF 4

ISSUED 1998-11 REAFFIRMED 2004-07

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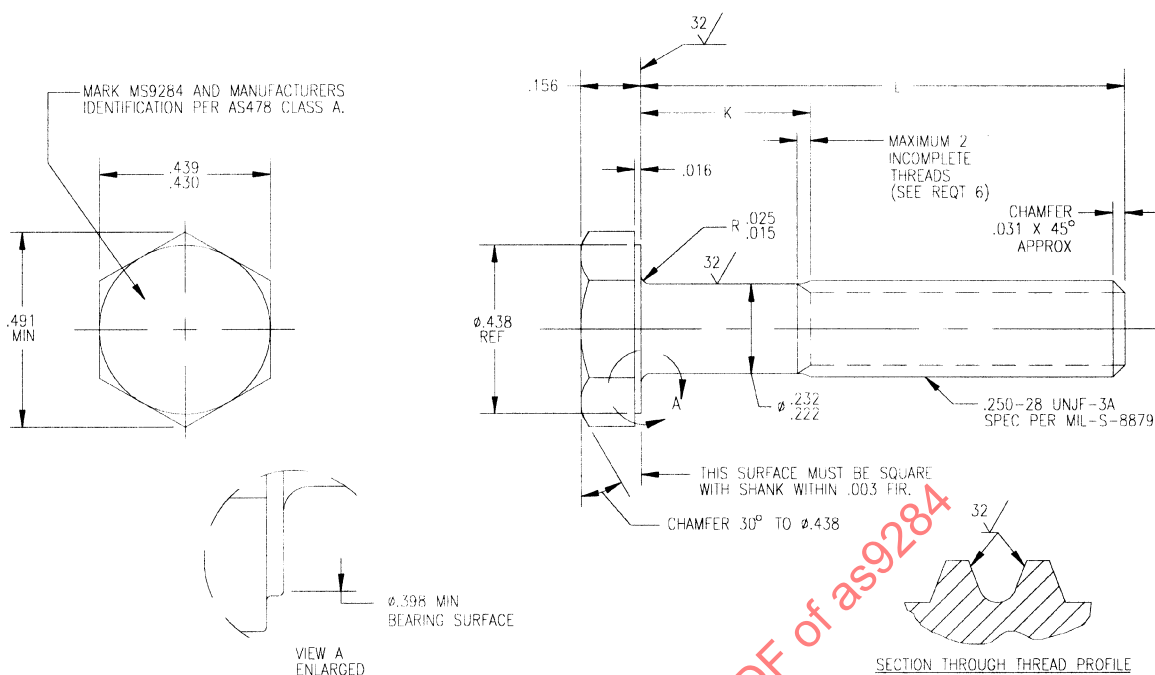


FIGURE 1 - BOLT

TABLE I - PART NUMBERS AND DIMENSIONS

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9284-04	.375	.079-.099	1.16	MS9284-16	1.125	.315-.375	2.01
MS9284-05	.438	.079-.099	1.23	MS9284-17	1.188	.378-.438	2.09
MS9284-06	.500	.079-.099	1.30	MS9284-18	1.250	.440-.500	2.16
MS9284-07	.562	.079-.099	1.37	MS9284-19	1.312	.502-.562	2.23
MS9284-08	.625	.079-.099	1.44	MS9284-20	1.375	.565-.625	2.30
MS9284-09	.688	.079-.099	1.51	MS9284-21	1.438	.628-.688	2.37
MS9284-10	.750	.079-.099	1.58	MS9284-22	1.500	.690-.750	2.44
MS9284-11	.812	.079-.099	1.66	MS9284-23	1.562	.752-.812	2.52
MS9284-12	.875	.079-.125	1.73	MS9284-24	1.625	.815-.875	2.59
MS9284-13	.938	.128-.188	1.80	MS9284-25	1.688	.878-.938	2.66
MS9284-14	1.000	.190-.250	1.87	MS9284-26	1.750	.940-1.000	2.73
MS9284-15	1.062	.252-.312	1.94	MS9284-27	1.875	1.065-1.125	2.87

TABLE I - PART NUMBERS AND DIMENSIONS - CONTINUED

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9284-28	2.000	1.190-1.250	3.02	MS9284-46	4.250	3.440-3.500	5.60
MS9284-29	2.125	1.315-1.375	3.16	MS9284-47	4.375	3.565-3.625	5.74
MS9284-30	2.250	1.440-1.500	3.30	MS9284-48	4.500	3.690-3.750	5.89
MS9284-31	2.375	1.565-1.625	3.45	MS9284-49	4.625	3.815-3.875	6.03
MS9284-32	2.500	1.690-1.750	3.59	MS9284-50	4.750	3.940-4.000	6.17
MS9284-33	2.625	1.815-1.875	3.73	MS9284-51	4.875	4.065-4.125	6.32
MS9284-34	2.750	1.940-2.000	3.88	MS9284-52	5.000	4.190-4.250	6.46
MS9284-35	2.875	2.065-2.125	4.02	MS9284-53	5.125	4.315-4.375	6.60
MS9284-36	3.000	2.190-2.250	4.16	MS9284-54	5.250	4.440-4.500	6.75
MS9284-37	3.125	2.315-2.375	4.31	MS9284-55	5.375	4.565-4.625	6.89
MS9284-38	3.250	2.440-2.500	4.45	MS9284-56	5.500	4.690-4.750	7.03
MS9284-39	3.375	2.565-2.625	4.60	MS9284-57	5.625	4.815-4.875	7.18
MS9284-40	3.500	2.690-2.750	4.74	MS9284-58	5.750	4.940-5.000	7.32
MS9284-41	3.625	2.815-2.875	4.88	MS9284-59	5.875	5.065-5.125	7.46
MS9284-42	3.750	2.940-3.000	5.03	MS9284-60	6.000	5.190-5.250	7.61
MS9284-43	3.875	3.065-3.125	5.17				
MS9284-44	4.000	3.190-3.250	5.31				
MS9284-45	4.125	3.315-3.375	5.46				

REQUIREMENTS:

1. MATERIAL: STEEL, AMS 6322.
2. HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
3. SHANK SHALL BE STRAIGHT WITHIN .003 PER INCH OF BOLT LENGTH.
4. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
5. THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND HEXAGON SHALL BE WITHIN .013 FIR.
6. INCOMPLETE THREADS NOT TO ENTER FILLET.
7. HARDNESS: ROCKWELL C26-32.
8. FINISH: BLACK OXIDE TREATMENT AMS 2485.
9. MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD MUST BE UPSET.
10. MAGNETIC PARTICLE INSPECTION PER AMS 2640.
11. SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON.