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AS9307

FEDERAL SUPPLY CLASS
5307

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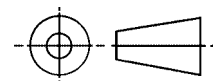
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THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE E-25

PROCUREMENT SPECIFICATION: AMS 7452-73

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

STUD, SHOULDERED AND STEPPED,
HEXAGON WRENCHING STEEL,
.250-28 UNF-3A X .375-24 UNF-3A

AS9307
SHEET 1 OF 4

ISSUED 1999-12 REAFFIRMED 2004-07

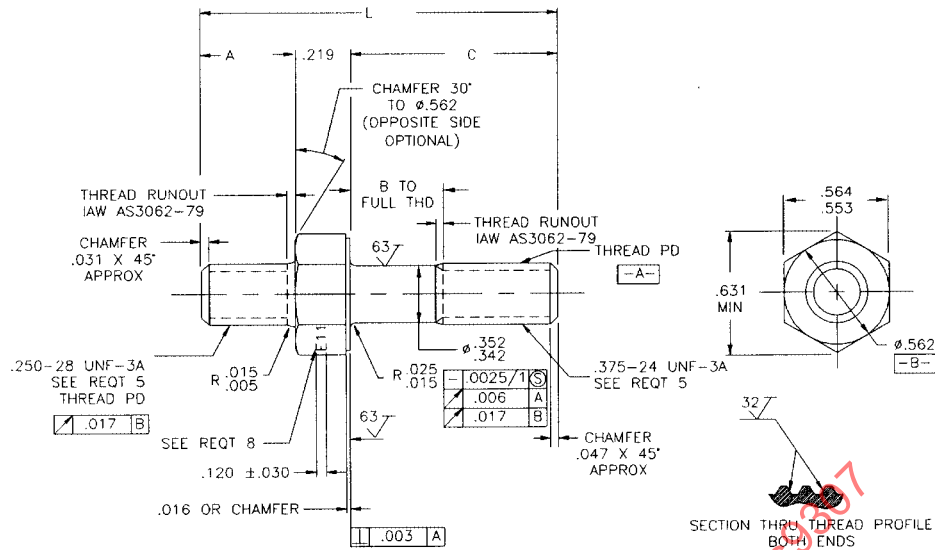


FIGURE 1.

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO.	A	B +.000 -.060	C	L REF	APPROX WEIGHT LBS/100	DASH NO.	A	B +.000 -.060	C	L REF	APPROX WEIGHT LBS/100
-001	.438	1/	.750	1.406	4.16	-050	.500	1/	.750	1.469	4.32
-002	.438	1/	.812	1.469	4.32	-051	.500	1/	.812	1.531	4.49
-003	.438	1/	.875	1.531	4.49	-052	.500	1/	.875	1.594	4.66
-004	.438	1/	.938	1.594	4.66	-053	.500	1/	.938	1.656	4.83
-005	.438	1/	1.000	1.656	4.83	-054	.500	1/	1.000	1.719	5.00
-006	.438	1/	1.062	1.719	5.00	-055	.500	1/	1.062	1.781	5.17
-007	.438	.125	1.125	1.781	5.17	-056	.500	.125	1.125	1.844	5.34
-008	.438	.188	1.188	1.844	5.34	-057	.500	.188	1.188	1.906	5.49
-009	.438	.250	1.250	1.906	5.49	-058	.500	.250	1.250	1.969	5.66
-010	.438	.312	1.312	1.969	5.66	-059	.500	.312	1.312	2.031	5.82
-011	.438	.375	1.375	2.031	5.82	-060	.500	.375	1.375	2.094	5.99
-012	.438	.438	1.438	2.094	5.99	-061	.500	.438	1.438	2.156	6.16
-013	.438	.500	1.500	2.156	6.16	-062	.500	.500	1.500	2.219	6.33
-014	.438	.562	1.562	2.219	6.33	-063	.500	.562	1.562	2.281	6.50
-015	.438	.625	1.625	2.281	6.50	-064	.500	.625	1.625	2.344	6.67
-016	.438	.688	1.688	2.344	6.67	-065	.500	.688	1.688	2.406	6.82
-017	.438	.750	1.750	2.406	6.82	-066	.500	.750	1.750	2.469	6.99
-018	.438	.812	1.812	2.469	6.99	-067	.500	.812	1.812	2.531	7.15
-019	.438	.875	1.875	2.531	7.15	-068	.500	.875	1.875	2.594	7.32
-020	.438	.938	1.938	2.594	7.32	-069	.500	.938	1.938	2.656	7.49
-021	.438	1.000	2.000	2.656	7.49	-070	.500	1.000	2.000	2.719	7.66
-022	.438	1.062	2.062	2.719	7.66	-071	.500	1.062	2.062	2.781	7.83
-023	.438	1.125	2.125	2.781	7.83	-072	.500	1.125	2.125	2.844	8.15
-024	.438	1.250	2.250	2.906	8.15	-073	.500	1.250	2.250	2.969	8.49
-025	.438	1.375	2.375	3.031	8.49	-074	.500	1.375	2.375	3.094	8.82
-026	.438	1.500	2.500	3.156	8.82	-075	.500	1.500	2.500	3.219	9.16
-027	.438	1.625	2.625	3.281	9.16	-076	.500	1.625	2.625	3.344	9.48
-028	.438	1.750	2.750	3.406	9.48	-077	.500	1.750	2.750	3.469	9.82
-029	.438	1.875	2.875	3.531	9.82	-078	.500	1.875	2.875	3.594	10.15
-030	.438	2.000	3.000	3.656	10.15	-079	.500	2.000	3.000	3.719	10.21

TABLE I. DASH NUMBERS AND DIMENSIONS - CONTINUED

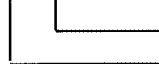
DASH NO.	A	B +.000 -.060	C	L REF	APPROX WEIGHT LBS/100	DASH NO.	A	B +.000 -.060	C	L REF	APPROX WEIGHT LBS/100
-100	.562	1/	.750	1.531	4.49	-150	.625	1/	.750	1.594	4.66
-101	.562	1/	.812	1.594	4.66	-151	.625	1/	.812	1.656	4.83
-102	.562	1/	.875	1.656	4.83	-152	.625	1/	.875	1.719	5.00
-103	.562	1/	.938	1.719	5.00	-153	.625	1/	.938	1.781	5.17
-104	.562	1/	1.000	1.781	5.17	-154	.625	1/	1.000	1.844	5.34
-105	.562	1/	1.062	1.844	5.34	-155	.625	1/	1.062	1.906	5.49
-106	.562	.125	1.125	1.906	5.49	-156	.625	.125	1.125	1.969	5.66
-107	.562	.188	1.188	1.969	5.66	-157	.625	.188	1.188	2.031	5.82
-108	.562	.250	1.250	2.031	5.82	-158	.625	.250	1.250	2.094	5.99
-109	.562	.312	1.312	2.094	5.99	-159	.625	.312	1.312	2.156	6.16
-110	.562	.375	1.375	2.156	6.16	-160	.625	.375	1.375	2.219	6.33
-111	.562	.438	1.438	2.219	6.33	-161	.625	.438	1.438	2.281	6.50
-112	.562	.500	1.500	2.281	6.50	-162	.625	.500	1.500	2.344	6.67
-113	.562	.562	1.562	2.344	6.67	-163	.625	.562	1.562	2.406	6.82
-114	.562	.625	1.625	2.406	6.82	-164	.625	.625	1.625	2.469	6.99
-115	.562	.688	1.688	2.469	6.99	-165	.625	.688	1.688	2.531	7.15
-116	.562	.750	1.750	2.531	7.15	-166	.625	.750	1.750	2.594	7.32
-117	.562	.812	1.812	2.593	7.32	-167	.625	.812	1.812	2.656	7.49
-118	.562	.875	1.875	2.656	7.49	-168	.625	.875	1.875	2.719	7.66
-119	.562	.938	1.938	2.719	7.66	-169	.625	.938	1.938	2.781	7.83
-120	.562	1.000	2.000	2.781	7.83	-170	.625	1.000	2.000	2.844	8.15
-121	.562	1.062	2.062	2.844	8.15	-171	.625	1.062	2.062	2.906	8.49
-122	.562	1.125	2.125	2.906	8.49	-172	.625	1.125	2.125	2.969	8.82
-123	.562	1.250	2.250	3.031	8.82	-173	.625	1.250	2.250	3.094	9.16
-124	.562	1.375	2.375	3.156	9.16	-174	.625	1.375	2.375	3.219	9.48
-125	.562	1.500	2.500	3.281	9.48	-175	.625	1.500	2.500	3.344	9.82
-126	.562	1.625	2.625	3.406	9.82	-176	.625	1.625	2.625	3.469	10.15
-127	.562	1.750	2.750	3.531	10.15	-177	.625	1.750	2.750	3.594	10.21
-128	.562	1.875	2.875	3.656	10.21	-178	.625	1.875	2.875	3.719	10.27
-129	.562	2.000	3.000	3.781	10.27	-179	.625	2.000	3.000	3.844	10.35

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS.

REQUIREMENTS:

- MATERIAL:** STEEL IN ACCORDANCE WITH AMS 6322-80.
- FINISH:** CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80.
- HARDNESS:** 26-32HRC.
- DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
- THREADS:** THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22.
- SURFACE TEXTURE:** SURFACE TEXTURE, SHALL BE IN ACCORDANCE WITH AS291-64.
- MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2640-83.
- MARKING:** MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2800-76. DEPRESSED .010 MAX.
- TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
- EDGES:** BREAK SHARP EDGES .003-.015, UNLESS OTHERWISE SPECIFIED.
- MANUFACTURING SPECIFICATION:** AMS 7452
- PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9307-001



DASH NUMBER

BASIC MS NUMBER

MS9307-001 STUD, SHOULDERED AND STEPPED, HEXAGON WRENCHING, STEEL, .250-
INDICATES: 28 UNF-3A X .375-24 UNF-3A; LENGTH 1.406.