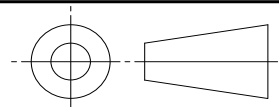


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REV. C	FEDERAL SUPPLY CLASS 5306	
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	AEROSPACE STANDARD BOLT, MACHINE - STEEL, CADMIUM PLATED, HEXAGON HEAD, UNS G87400, 125 KSI MIN, .1900-32 UNJF-3A	AS9518
		REV. C

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9518A, 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 QPL'S HAVE NOT BEEN ADOPTED BY THE SAE FOR THIS STANDARD AND ARE NOT PART OF THIS SAE DOCUMENT.

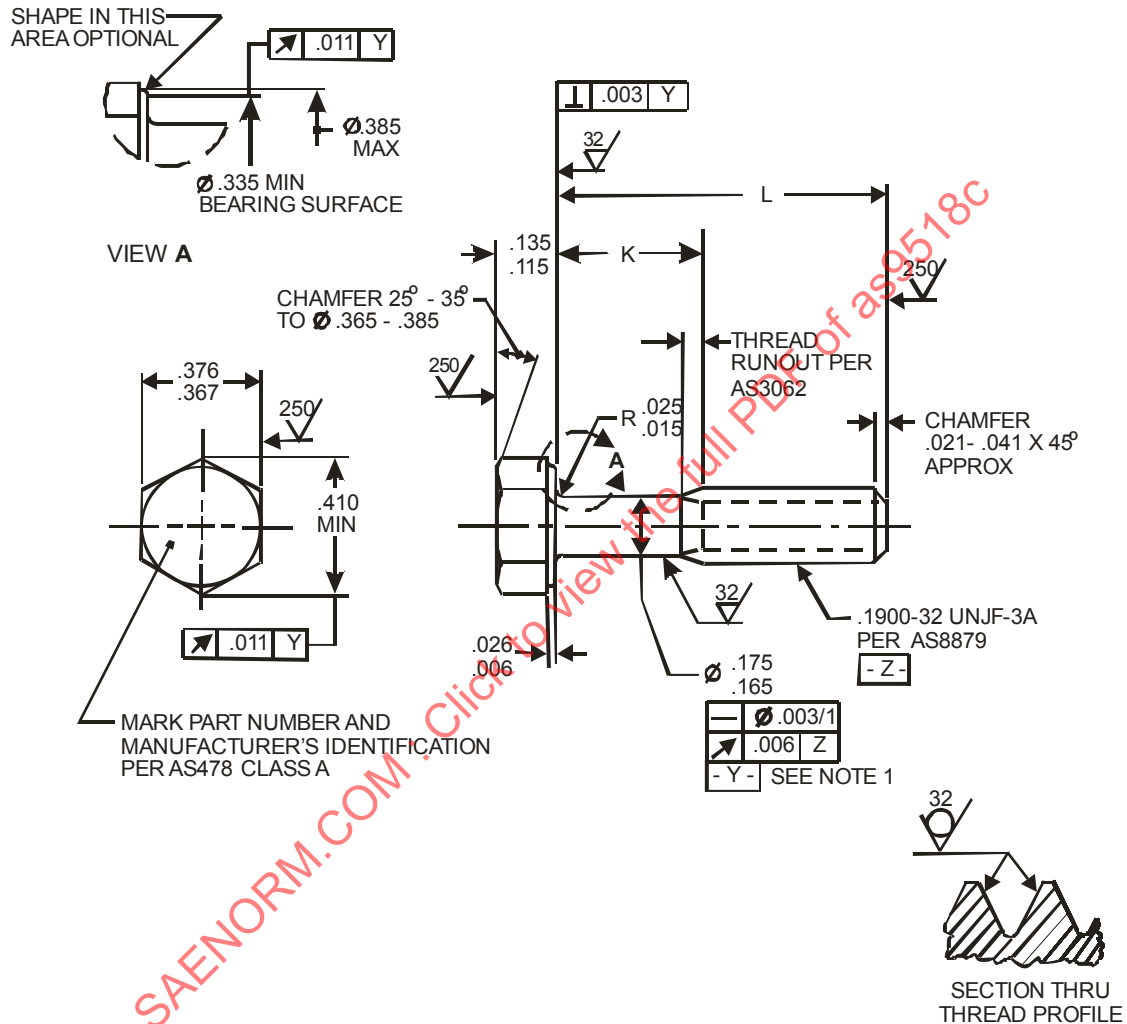


FIGURE 1 - BOLT

	AEROSPACE STANDARD	AS9518 SHEET 1 OF 3	REV. C
	BOLT, MACHINE - STEEL, CADMIUM PLATED, HEXAGON HEAD, UNS G87400, 125 KSI MIN, .1900-32 UNJF-3A		

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	K	APPROX. MASS LB/100	PART NO.	L	K	APPROX. MASS LB/100
MS9518-04	.365-.385	.072-.092	.66	MS9518-24	1.615-1.635	.935-.995	1.47
MS9518-05	.428-.448	.072-.092	.70	MS9518-25	1.678-1.698	.998-1.058	1.51
MS9518-06	.490-.510	.072-.092	.74	MS9518-26	1.740-1.760	1.060-1.120	1.55
MS9518-07	.552-.572	.072-.092	.78	MS9518-27	1.865-1.885	1.185-1.245	1.63
MS9518-08	.615-.635	.072-.092	.82	MS9518-28	1.990-2.010	1.310-1.370	1.71
MS9518-09	.678-.698	.072-.092	.86	MS9518-29	2.115-2.135	1.435-1.495	1.79
MS9518-10	.740-.760	.072-.120	.90	MS9518-30	2.240-2.260	1.560-1.620	1.87
MS9518-11	.802-.822	.122-.182	.94	MS9518-31	2.365-2.385	1.685-1.745	1.95
MS9518-12	.865-.885	.185-.245	.98	MS9518-32	2.490-2.510	1.810-1.870	2.03
MS9518-13	.928-.948	.248-.308	1.02	MS9518-33	2.615-2.635	1.935-1.995	2.11
MS9518-14	.990-1.010	.310-.370	1.07	MS9518-34	2.740-2.760	2.060-2.120	2.19
MS9518-15	1.052-1.072	.372-.432	1.11	MS9518-35	2.865-2.885	2.185-2.245	2.27
MS9518-16	1.115-1.135	.435-.495	1.15	MS9518-36	2.990-3.010	2.310-2.370	2.35
MS9518-17	1.178-1.198	.498-.558	1.19	MS9518-37	3.115-3.135	2.435-2.495	2.43
MS9518-18	1.240-1.260	.560-.620	1.23	MS9518-38	3.240-3.260	2.560-2.620	2.51
MS9518-19	1.302-1.322	.622-.682	1.27	MS9518-39	3.365-3.385	2.685-2.745	2.59
MS9518-20	1.365-1.385	.685-.745	1.31	MS9518-40	3.490-3.510	2.810-2.870	2.67
MS9518-21	1.428-1.448	.748-.808	1.35	MS9518-41	3.615-3.635	2.935-2.995	2.75
MS9518-22	1.490-1.510	.810-.870	1.39	MS9518-42	3.740-3.760	3.060-3.120	2.83
MS9518-23	1.552-1.572	.872-.932	1.43	MS9518-43	3.865-3.885	3.185-3.245	2.91

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. FOR PART NUMBERS MS9518-04 THRU MS9518-14 THE THREAD PD (DATUM "Z") SHALL REPLACE DATUM "Y".
2. MATERIAL: LOW ALLOY STEEL AMS 6322 (UNS G87400).
3. PROCUREMENT SPECIFICATION: AS7452.
4. HEAD TO SHANK FILLET RADIUS: FOR PART NUMBERS MS9518-13 AND LARGER, THE HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
5. FINISH: CADMIUM PLATE PER AMS 2400. DIMENSIONS ARE AFTER PLATING.
6. MAGNETIC PARTICLE INSPECTION PER ASTM E 1444.
7. INCOMPLETE THREADS NOT TO ENTER FILLET.
8. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 μ in Ra.
9. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

	AEROSPACE STANDARD	AS9518 SHEET 2 OF 3	REV. C
	BOLT, MACHINE - STEEL, CADMIUM PLATED, HEXAGON HEAD, UNS G87400, 125 KSI MIN, .1900-32 UNJF-3A		