

AS9724

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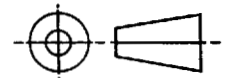
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THIRD ANGLE PROJECTION



PREPARED BY COMMITTEE E-25

PROCUREMENT SPECIFICATION: AMS 7471

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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

BOLT, MACHINE - DOUBLE HEXAGON EXTENDED
WASHER HEAD, CLOSE TOLERANCE SHANK, CORROSION
AND HEAT RESISTANT STEEL, .250-28 UNJF-3A

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SHEET 1 OF 4

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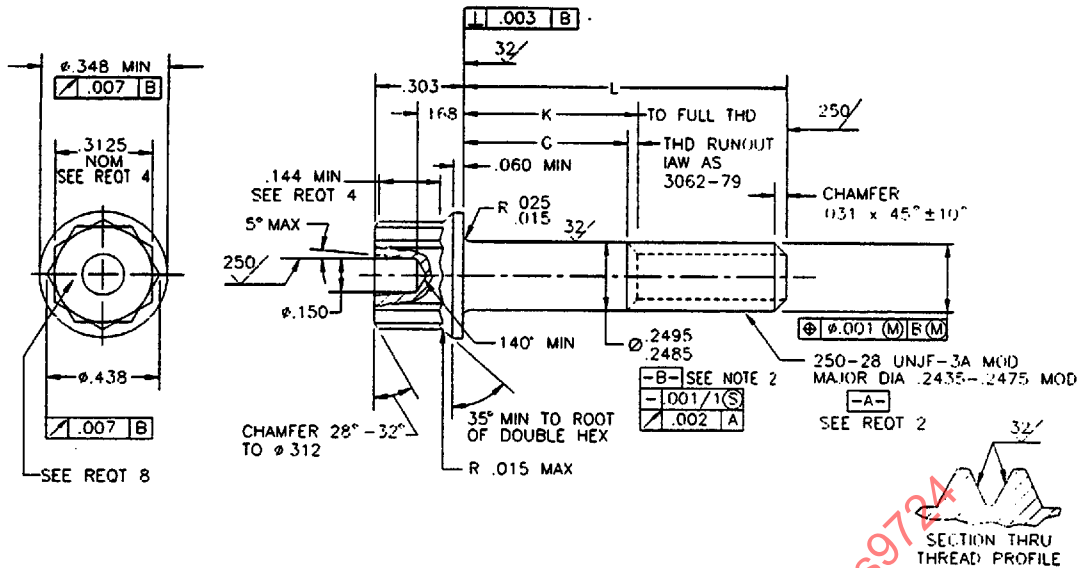


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-03	.700	.117	.198	1.70	-31	2.450	1.867	1.948	4.22
-04	.762	.179	.260	1.79	-32	2.512	1.929	2.010	4.31
-05	.824	.241	.322	1.88	-33	2.574	1.991	2.072	4.40
-06	.887	.304	.385	1.96	-34	2.637	2.054	2.135	4.49
-07	.950	.367	.448	2.06	-35	2.700	2.117	2.198	4.58
-08	1.012	.429	.510	2.15	-36	2.762	2.179	2.260	4.67
-09	1.074	.491	.572	2.24	-37	2.824	2.241	2.322	4.76
-10	1.137	.554	.635	2.33	-38	2.887	2.304	2.385	4.85
-11	1.200	.617	.698	2.42	-39	2.950	2.367	2.448	4.94
-12	1.262	.679	.760	2.51	-40	3.012	2.429	2.510	5.03
-13	1.324	.741	.822	2.60	-41	3.074	2.491	2.572	5.12
-14	1.387	.804	.885	2.69	-42	3.137	2.554	2.635	5.21
-15	1.450	.867	.948	2.78	-43	3.200	2.617	2.698	5.30
-16	1.512	.929	1.010	2.87	-44	3.262	2.679	2.760	5.39
-17	1.574	.991	1.072	2.96	-45	3.324	2.741	2.822	5.48
-18	1.637	1.045	1.135	3.05	-46	3.387	2.804	2.885	5.57
-19	1.700	1.117	1.198	3.14	-47	3.450	2.867	2.948	5.66
-20	1.762	1.179	1.260	3.23	-48	3.512	2.929	3.010	5.75
-21	1.824	1.241	1.322	3.32	-49	3.574	2.991	3.072	5.84
-22	1.887	1.304	1.385	3.41	-50	3.637	3.054	3.135	5.93
-23	1.950	1.376	1.448	3.50	-51	3.700	3.117	3.198	6.02
-24	2.012	1.429	1.510	3.59	-52	3.762	3.179	3.260	6.11
-25	2.074	1.491	1.572	3.68	-53	3.824	3.241	3.322	6.20
-26	2.137	1.554	1.635	3.77	-54	3.887	3.304	3.385	6.29
-27	2.200	1.617	1.698	3.86	-55	3.950	3.367	3.448	6.38
-28	2.262	1.679	1.760	3.95	-56	4.012	3.429	3.510	6.47
-29	2.324	1.741	1.822	4.04	-57	4.074	3.491	3.572	6.56
-30	2.387	1.804	1.885	4.13	-58	4.137	3.554	3.625	6.65

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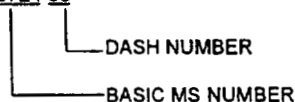
TABLE I. DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100	DASH NUMBER	L INCH	G MIN INCH	K MAX INCH	APPROX MASS LB/100
-59	4.200	3.617	3.698	6.74	-73	5.074	4.491	4.572	8.00
-60	4.262	3.679	3.760	6.83	-74	5.137	4.554	4.635	8.09
-61	4.324	3.741	3.822	6.92	-75	5.200	4.617	4.698	8.18
-62	4.387	3.804	3.885	7.01	-76	5.262	4.679	4.760	8.27
-63	4.450	3.867	3.948	7.10	-77	5.324	4.741	4.822	8.36
-64	4.512	3.929	4.010	7.19	-78	5.387	4.804	4.885	8.45
-65	4.574	3.991	4.072	7.28	-79	5.450	4.867	4.948	8.54
-66	4.637	4.054	4.135	7.37	-80	5.512	4.929	5.010	8.63
-67	4.700	4.117	4.198	7.46	-81	5.574	4.991	5.072	8.72
-68	4.762	4.179	4.260	7.55	-82	5.637	5.054	5.135	8.81
-69	4.824	4.241	4.322	7.64	-83	5.700	5.117	5.198	8.90
-70	4.887	4.304	4.385	7.73	-84	5.762	5.179	5.260	9.00
-71	4.950	4.367	4.448	7.82	-85	5.824	5.241	5.322	9.08
-72	5.012	4.429	4.510	7.91	-86	5.887	5.304	5.385	9.17

REQUIREMENTS:

1. **MATERIAL:** CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5708.
2. **THREADS:** THREADS IN ACCORDANCE WITH MIL-S-8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
4. **WRENCHING CONFIGURATION:** WRENCHING CONFIGURATION IN ACCORDANCE WITH AS 870.
5. **SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI B46.1.
6. **FLUORESCENT PENETRANT INSPECTION:** FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH ASTM E1417.
7. **HEAD TO SHANK FILLET:** HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS EXCEPT THAT DISTORTIONS AT A IN FIGURE 2 OF THE PROCUREMENT SPECIFICATION SHALL NOT BE PERMITTED ON THE HEAD BEARING AREA AND SHALL BE PERMITTED ON THE SHANK DIAMETER ONLY IF THE DISTORTION DOES NOT CAUSE THE SHANK DIAMETER TO EXCEED .2500 DIAMETER EXCEPT DASH NUMBER SIZES -06 AND SMALLER.
8. **MARKING:** MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS 478-79, CLASS A.
9. **TOLERANCES:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
10. **EDGES:** BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. **MANUFACTURING SPECIFICATION:** AMS 7471.
12. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS9724-03



MS9724-03 INDICATES: BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, CLOSE TOLERANCE SHANK, .250-.28 UNJF-3A, LENGTH .700