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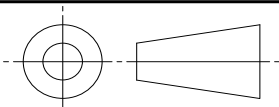
|                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                          |                                                                                      |
|----------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|
| REV.<br>B                                                                              | <p style="text-align: right;">FEDERAL SUPPLY CLASS<br/>5306</p> <p style="text-align: center;">RATIONALE</p> <p>THIS NONCURRENT STANDARD HAS BEEN STABILIZED.</p> <p style="text-align: center;">STABILIZED NOTICE</p> <p>THIS DOCUMENT HAS BEEN DECLARED "STABILIZED" BY THE SAE E-25 GENERAL STANDARDS FOR AEROSPACE AND PROPULSION SYSTEMS COMMITTEE AND WILL NO LONGER BE SUBJECTED TO PERIODIC REVIEWS FOR CURRENCY. USERS ARE RESPONSIBLE FOR VERIFYING REFERENCES AND CONTINUED SUITABILITY OF TECHNICAL REQUIREMENTS. NEWER TECHNOLOGY MAY EXIST.</p> |                                                                                                                                                                                                                                                                                                                          | <p>ISSUED 2000-08    REAFFIRMED 2005-05    REVISED 2012-08    STABILIZED 2014-08</p> |
|                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                          |                                                                                      |
| <p style="text-align: center;">SAENORM.COM : Click to view the full PDF of as9944b</p> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <p>SAE values your input. To provide feedback on this Technical Report, please visit <a href="http://www.sae.org/technical/standards/AS9944B">http://www.sae.org/technical/standards/AS9944B</a></p> <p>THIRD ANGLE PROJECTION</p>  |                                                                                      |
| CUSTODIAN: E-25                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | PROCUREMENT SPECIFICATION: /2/ AS7452                                                                                                                                                                                                                                                                                    |                                                                                      |
|     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <p style="text-align: center;"><b>AEROSPACE STANDARD</b></p> <p>BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, FULL SHANK, STEEL AMS6322, CADMIUM PLATED, .3750-24 UNJF-3A</p>                                                                                                                            | <p style="text-align: center;"><b>AS9944</b></p>                                     |
|                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <p style="text-align: center;"><b>REV.<br/>B</b></p>                                                                                                                                                                                                                                                                     |                                                                                      |



TABLE 1 - PART NUMBERS AND DIMENSIONS

| PART NO.  | L            | G<br>MIN | K<br>MAX | APPROX.<br>MASS<br>LB/100 | PART NO.  | L           | G<br>MIN | K<br>MAX | APPROX.<br>MASS<br>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><br>SHEET 2 OF 3 | <b>REV.</b><br><b>B</b> |
|                                                                                     | BOLT, MACHINE - DOUBLE HEXAGON EXTENDED<br>WASHER HEAD, DRILLED, FULL SHANK, STEEL<br>AMS6322, CADMIUM PLATED, .3750-24 UNJF-3A |                               |                         |