

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODDISS SPECIFIED IN THE SOLICITATION: AS7477 (E)

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

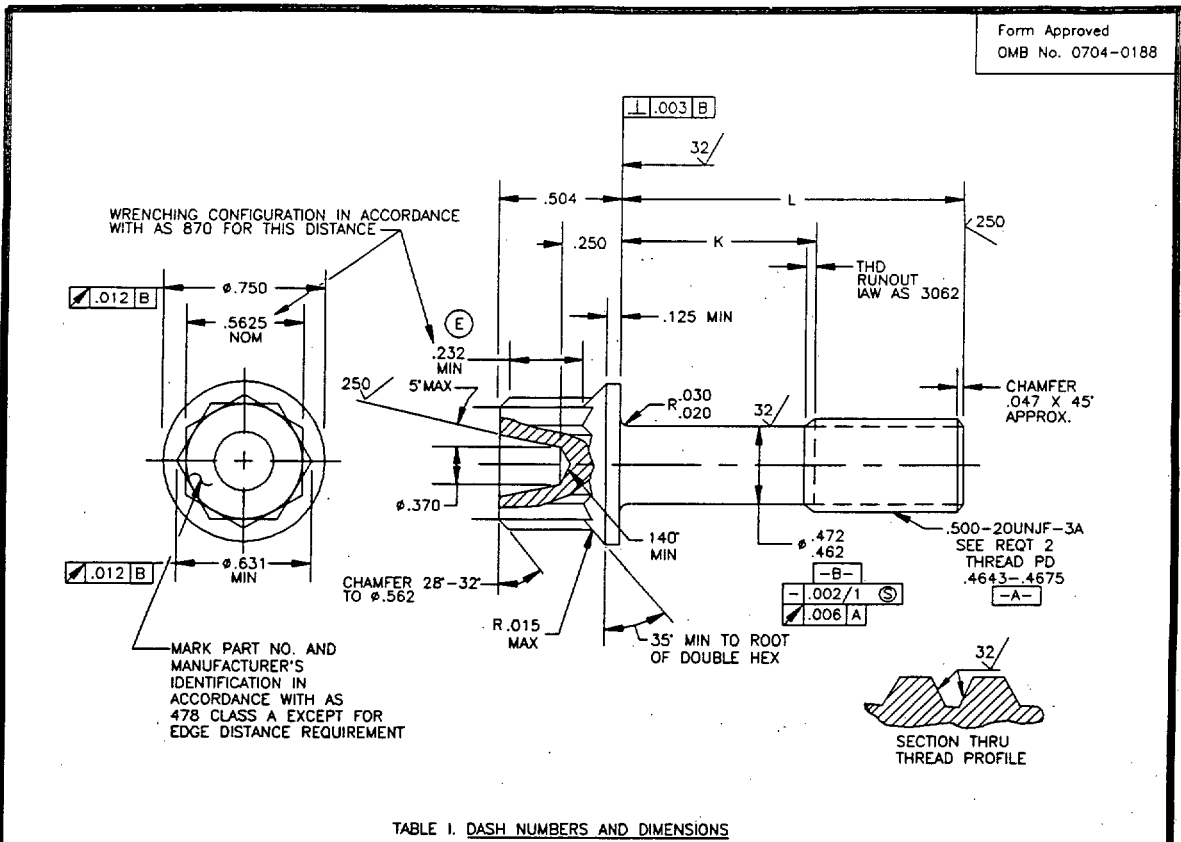


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100	DASH NUMBER	L	K	APPROX WEIGHT LB/100
-03	.750	.105-.125	7.54	-21	2.000	.690-.750	13.41	-39	4.250	2.940-3.000	24.29
-04	.812	.105-.125	7.83	-22	2.125	.815-.875	14.00	-40	4.375	3.065-3.125	24.89
-05	.875	.105-.125	8.12	-23	2.250	.940-1.000	14.61	-41	4.500	3.190-3.250	25.50
-06	.938	.105-.125	8.41	-24	2.375	1.065-1.125	15.21	-42	4.625	3.315-3.375	26.11
-07	1.000	.105-.125	8.70	-25	2.500	1.190-1.250	15.82	-43	4.750	3.440-3.500	26.71
-08	1.062	.105-.125	8.99	-26	2.625	1.315-1.375	16.42	-44	4.875	3.565-3.625	27.32
-09	1.125	.105-.125	9.28	-27	2.750	1.440-1.500	17.01	-45	5.000	3.690-3.750	27.92
-10	1.188	.105-.125	9.57	-28	2.875	1.565-1.625	17.61	-46	5.125	3.815-3.875	28.53
-11	1.250	.105-.125	9.86	-29	3.000	1.690-1.750	18.22	-47	5.250	3.940-4.000	29.13
-12	1.312	.105-.125	10.15	-30	3.125	1.815-1.875	18.83	-48	5.375	4.065-4.125	29.74
-13	1.375	.105-.125	10.45	-31	3.250	1.940-2.000	19.43	-49	5.500	4.190-4.250	30.35
-14	1.438	.128-.188	10.74	-32	3.375	2.065-2.125	20.04	-50	5.625	4.315-4.375	30.95
-15	1.500	.190-.250	11.04	-33	3.500	2.190-2.250	20.65	-51	5.750	4.440-4.500	31.56
-16	1.562	.252-.312	11.33	-34	3.625	2.315-2.375	21.26	-52	5.875	4.565-4.625	32.16
-17	1.625	.315-.375	11.63	-35	3.750	2.440-2.500	21.86	-53	6.000	4.690-4.750	32.77
-18	1.688	.378-.438	11.92	-36	3.875	2.565-2.625	22.47	-54	1.812	.502-.562	12.52
-19	1.750	.440-.500	12.22	-37	4.000	2.690-2.750	23.07	-55	1.938	.628-.688	13.11
-20	1.875	.565-.625	12.81	-38	4.125	2.815-2.875	23.68				

(E) DENOTES CHANGE(S)

INCH - POUND

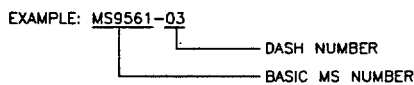
PREPARING ACTIVITY: DLA-IS CUSTODIANS: ARMY-AV      NAVY-AS AIR FORCE-99      DLA- REVIEW: 82 USER: PROJECT NUMBER: 5306-1706	MILITARY SPECIFICATION SHEET TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, .500-20 UNJF-3A	SPECIFICATION SHEET NUMBER <b>MS9561</b> 2 SEP 93 REV E SUPERSEDING MS9561 D    20 APR 93 AMSC-    N/A      FSC 5306
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REQUIREMENTS:

1. **MATERIAL:** CORROSION AND HEAT RESISTANT STEEL IN ACCORDANCE WITH AMS 5731-85.
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. **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 DASH NUMBER SIZES -15 AND SMALLER.
5. **FLUORESCENT PENETRANT INSPECTION:** FLUORESCENT PENETRANT INSPECTION SHALL BE IN ACCORDANCE WITH AMS 2645-83.
6. **SURFACE TEXTURE:** SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES EXCEPT UPSET HEAD IN ACCORDANCE WITH ANSI/ASME B46.1.
7. **TOLERANCE:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5'$ .
8. **EDGES:** BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
9. **PART NUMBER:** THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE.



MS9561-03 INDICATES: BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, .500-20 UNJF-3A, LENGTH .750

NOTES:

1. ALL DIMENSIONS IN INCHES.
2. DO NOT USE UNASSIGNED PART NUMBERS.
3. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
4. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF THE SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH SAE AEROSPACE PROPULSION DIVISION.
6. AS AND AMS ARE SAE PUBLICATIONS.

PREPARING ACTIVITY: DLA-IS CUSTODIANS: ARMY-AV      NAVY-AS AIR FORCE-99      DLA-	<b>MILITARY SPECIFICATION SHEET</b> TITLE BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, CORROSION AND HEAT RESISTANT STEEL, .500-20 UNJF-3A	SPECIFICATION SHEET NUMBER <b>MS9561</b> 2 SEP 93 REV E
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