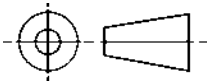


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REV. A	FEDERAL SUPPLY CLASS 5306	
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AS9219	THIRD ANGLE PROJECTION 	
PREPARED BY SAE COMMITTEE E-25, GENERAL STANDARDS FOR AEROSPACE AND PROPULSION SYSTEMS		
	AEROSPACE STANDARD (R) BOLT, MACHINE - STEEL, DIFFUSED NICKEL-CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, UNS K14675, 195 KSI MIN, .3125-24 UNJF-3A	AS9219 SHEET 1 OF 4
		REV. A

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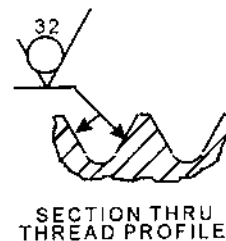


FIGURE 1 - BOLT

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AS9219

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	K	APPROX. MASS LB/100	PART NO.	L	K	APPROX. MASS LB/100
MS9219-04	.500	.088 - .108	2.06	MS9219-34	3.000	2.065 - 2.125	6.58
MS9219-05	.562	.088 - .108	2.17	MS9219-35	3.125	2.190 - 2.250	6.80
MS9219-06	.625	.088 - .108	2.28	MS9219-36	3.250	2.315 - 2.375	7.03
MS9219-07	.688	.088 - .108	2.39	MS9219-37	3.375	2.440 - 2.500	7.27
MS9219-08	.750	.088 - .108	2.51	MS9219-38	3.500	2.565 - 2.625	7.50
MS9219-09	.812	.088 - .108	2.62	MS9219-39	3.625	2.690 - 2.750	7.73
MS9219-10	.875	.088 - .108	2.73	MS9219-40	3.750	2.815 - 2.875	7.95
MS9219-11	.938	.088 - .108	2.85	MS9219-41	3.875	2.940 - 3.000	8.17
MS9219-12	1.000	.125 - .145	2.96	MS9219-42	4.000	3.065 - 3.125	8.40
MS9219-13	1.062	.128 - .188	3.07	MS9219-43	4.125	3.190 - 3.250	8.63
MS9219-14	1.125	.190 - .250	3.19	MS9219-44	4.250	3.315 - 3.375	8.86
MS9219-15	1.188	.252 - .312	3.30	MS9219-45	4.375	3.440 - 3.500	9.08
MS9219-16	1.250	.315 - .375	3.41	MS9219-46	4.500	3.565 - 3.625	9.30
MS9219-17	1.312	.378 - .438	3.52	MS9219-47	4.625	3.690 - 3.750	9.52
MS9219-18	1.375	.440 - .500	3.64	MS9219-48	4.750	3.815 - 3.875	9.74
MS9219-19	1.438	.502 - .562	3.75	MS9219-49	4.875	3.940 - 4.000	9.95
MS9219-20	1.500	.565 - .625	3.87	MS9219-50	5.000	4.065 - 4.125	10.17
MS9219-21	1.562	.628 - .688	3.98	MS9219-51	5.125	4.190 - 4.250	10.40
MS9219-22	1.625	.690 - .750	4.10	MS9219-52	5.250	4.315 - 4.375	10.63
MS9219-23	1.688	.752 - .812	4.22	MS9219-53	5.375	4.440 - 4.500	10.86
MS9219-24	1.750	.815 - .875	4.33	MS9219-54	5.500	4.565 - 4.625	11.10
MS9219-25	1.875	.940 - 1.000	4.55	MS9219-55	5.625	4.690 - 4.750	11.33
MS9219-26	2.000	1.065 - 1.125	4.77	MS9219-56	5.750	4.815 - 4.875	11.56
MS9219-27	2.125	1.190 - 1.250	5.00	MS9219-57	5.875	4.940 - 5.000	11.78
MS9219-28	2.250	1.315 - 1.375	5.23	MS9219-58	6.000	5.065 - 5.125	12.00
MS9219-29	2.375	1.440 - 1.500	5.45				
MS9219-30	2.500	1.565 - 1.625	5.67				
MS9219-31	2.625	1.690 - 1.750	5.90				
MS9219-32	2.750	1.815 - 1.875	6.13				
MS9219-33	2.875	1.940 - 2.000	6.36				

NOTES:

1. MATERIAL: LOW ALLOY STEEL AMS 6304 (UNS K14675).
2. PROCUREMENT SPECIFICATION: AS7459.
3. HARDNESS: 42-46 HRC.
4. FINISH: DIFFUSED NICKEL-CADMIUM PLATE AMS 2416. DIMENSIONS ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
5. MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 BEFORE PLATING.
6. INCOMPLETE THREADS NOT TO ENTER FILLET.
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.
8. BREAK SHARP EDGES .003-.015, UNLESS OTHERWISE SPECIFIED.
9. DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982 (ASME PUBLICATION).
10. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
11. DO NOT USE UNASSIGNED PART NUMBERS.

AEROSPACE STANDARD

(R)

BOLT, MACHINE - STEEL, DIFFUSED NICKEL-
CADMIUM PLATED, DOUBLE HEXAGON
EXTENDED WASHER HEAD, DRILLED, UNS K14675,
195 KSI MIN, .3125-24 UNJF-3A

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