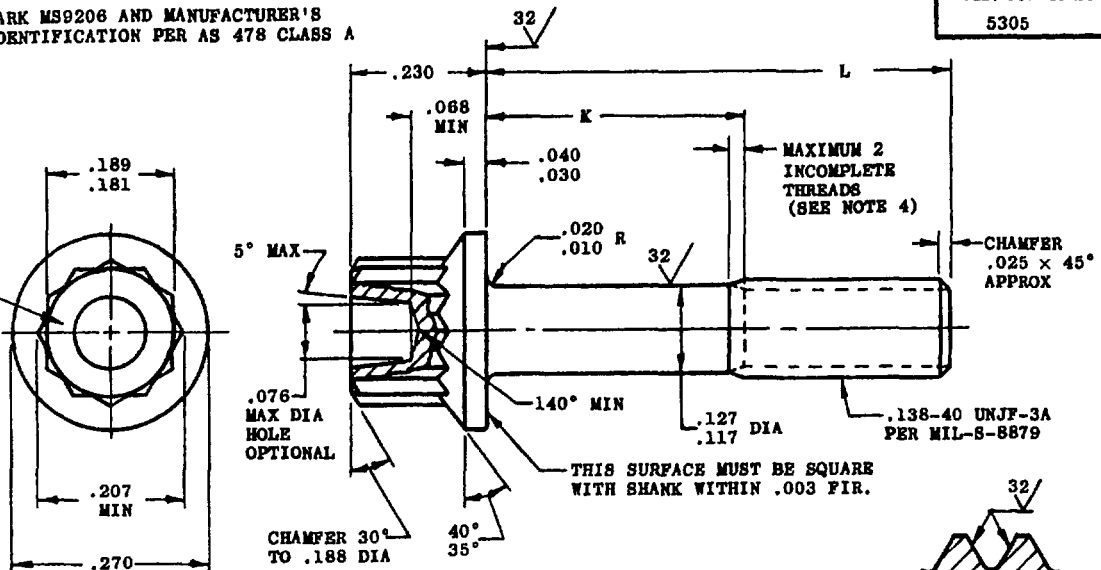


**MS9206 (ASG)**

MARK MS9206 AND MANUFACTURER'S IDENTIFICATION PER AS 478 CLASS A

FED. SUP CLASS  
5305



SECTION THRU  
THREAD PROFILE

PART NO.	L	K	APPROX WEIGHT LB/100	PART NO.	L	K	APPROX WEIGHT LB/100
MS9206-02	.250	.058-.078	.297	MS9206-13	.938	.352-.412	.539
MS9206-03	.312	.058-.078	.318	MS9206-14	1.000	.414-.474	.561
MS9206-04	.375	.058-.078	.340	MS9206-15	1.062	.476-.536	.583
MS9206-05	.438	.058-.078	.363	MS9206-16	1.125	.539-.599	.605
MS9206-06	.500	.058-.078	.386	MS9206-17	1.188	.602-.662	.627
MS9206-07	.562	.058-.078	.406	MS9206-18	1.250	.664-.724	.649
MS9206-08	.625	.058-.078	.429	MS9206-19	1.312	.726-.786	.671
MS9206-09	.688	.102-.162	.451	MS9206-20	1.375	.789-.849	.693
MS9206-10	.750	.164-.224	.473	MS9206-21	1.438	.852-.912	.715
MS9206-11	.812	.226-.286	.495	MS9206-22	1.500	.914-.974	.737
MS9206-12	.875	.289-.349	.517				

- SHANK SHALL BE STRAIGHT WITHIN .003 FIR. PER INCH OF SCREW LENGTH.
- THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .009 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- MATERIAL: STEEL AMS 6304.
- HARDNESS: ROCKWELL C42-46.
- FINISH: DIFFUSED NICKEL-CADMIUM PLATE AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
- MANUFACTURING SPECIFICATION: AMS 7459. PARTS SUBJECT TO MAGNETIC PARTICLE INSPECTION PER AMS 2640 BEFORE PLATING.
- SURFACE ROUGHNESS: AS 291 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
- BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
- DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS  
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER UTILITY PARTS COMMITTEE OF THE SAE.

P.A. USAF - ASD Other Cust Navy - Weps	TITLE SCREW, MACHINE - STEEL AMS 6304, DIFFUSED NICKEL-CADMIUM PLATED, DOUBLE HEXAGON EXTENDED WASHER HEAD, .138-40 UNJF-3A	<b>MILITARY STANDARD</b> <b>MS9206 (ASG)</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1

Reviewers and Users: USAF - ASD  
Navy - Weps

This standard has been approved by the ASD (Department of the Air Force) and the Department of the Navy, and is mandatory for use by their activity. All other military activities are required to employ this standard where suitable.

APPROVED 10 Dec 63 REVISED