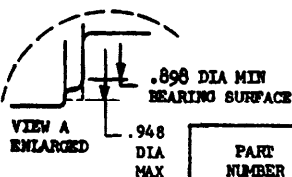
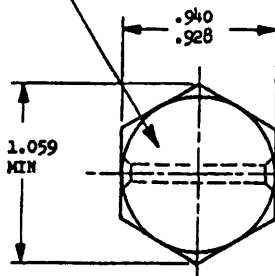
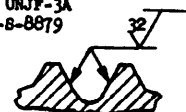


FED. SUP CLASS
5306**MS9507**MARK PART NUMBER AND MANUFACTURERS
IDENTIFICATION PER AS 478 CLASS A.070 DIAMETER
CSK 90° TO .100
DIA BOTH ENDS

CHAMFER 30° TO .938 DIAMETER

THIS SURFACE MUST BE SQUARE
WITH SHANK WITHIN .003 FIR

SECTION THROUGH THREAD PROFILE

CHAMFER .062 X 45°
APPROXMAXIMUM 2
INCOMPLETE
THREADS
(SEE NOTE 4)

.344

32°

K

.264

.016

.035 R

.025

32°

L

.624

.620

.625-18

UNJF-3A

MIL-8-8879

32°

.070

CSK 90°

TO .100

DIA BOTH ENDS

CHAMFER 30°

TO .938

DIAMETER

THIS SURFACE

MUST BE SQUARE

WITH SHANK

WITHIN .003

FIR

SECTION THROUGH

THREAD PROFILE

CHAMFER .062

X 45°

APPROX

MAXIMUM 2

INCOMPLETE

THREADS

(SEE NOTE 4)

.624 DIA

.620

.625-18

UNJF-3A

MIL-8-8879

32°

32°

32°

32°

User activities:

Review activities:
AIR FORCE-82
DLA - IS

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military standard is approved for use by all Departments and Agencies of the Department of Defense
tion for all new engineering and design applications and for repetitive use shall be made from this
ment when applicable.

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9507-03	.938	.118-.138	15.49	MS9507-31	3.500	1.940-2.000	37.76
MS9507-04	1.000	.118-.138	16.03	MS9507-32	3.625	2.065-2.125	38.86
MS9507-05	1.062	.118-.138	16.57	MS9507-33	3.750	2.190-2.250	39.93
MS9507-06	1.125	.118-.138	17.11	MS9507-34	3.875	2.315-2.375	41.02
MS9507-07	1.188	.118-.138	17.66	MS9507-35	4.000	2.440-2.500	42.10
MS9507-08	1.250	.118-.138	18.20	MS9507-36	4.125	2.565-2.625	43.19
MS9507-09	1.312	.118-.138	18.74	MS9507-37	4.250	2.690-2.750	44.27
MS9507-10	1.375	.118-.138	19.29	MS9507-38	4.375	2.815-2.875	45.36
MS9507-11	1.438	.118-.138	19.83	MS9507-39	4.500	2.940-3.000	46.45
MS9507-12	1.500	.118-.138	20.47	MS9507-40	4.625	3.065-3.125	47.53
MS9507-13	1.562	.118-.138	20.91	MS9507-41	4.750	3.190-3.250	48.62
MS9507-14	1.625	.118-.138	21.46	MS9507-42	4.875	3.315-3.375	49.71
MS9507-15	1.688	.128-.188	22.01	MS9507-43	5.000	3.440-3.500	50.79
MS9507-16	1.750	.190-.250	22.55	MS9507-44	5.125	3.565-3.625	51.88
MS9507-17	1.812	.252-.312	23.09	MS9507-45	5.250	3.690-3.750	52.97
MS9507-18	1.875	.315-.375	23.63	MS9507-46	5.375	3.815-3.875	54.05
MS9507-19	2.000	.440-.500	24.72	MS9507-47	5.500	3.940-4.000	55.14
MS9507-20	2.125	.565-.625	25.80	MS9507-48	5.625	4.065-4.125	56.23
MS9507-21	2.250	.690-.750	26.89	MS9507-49	5.750	4.190-4.250	57.31
MS9507-22	2.375	.815-.875	27.98	MS9507-50	5.875	4.315-4.375	58.40
MS9507-23	2.500	.940-1.000	29.06	MS9507-51	6.000	4.440-4.500	59.49
MS9507-24	2.625	1.065-1.125	30.15	MS9507-52	1.938	.378-.438	24.18
MS9507-25	2.750	1.190-1.250	31.24				
MS9507-26	2.875	1.315-1.375	32.32				
MS9507-27	3.000	1.440-1.500	33.41				
MS9507-28	3.125	1.565-1.625	34.50				
MS9507-29	3.250	1.690-1.750	35.58				
MS9507-30	3.375	1.815-1.875	36.67				

1. SHANK SHALL BE STRAIGHT WITHIN .002 TOTAL PER INCH OF BOLT LENGTH
2. THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
3. THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND HEXAGON SHALL BE WITHIN .028 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5731.
6. MANUFACTURING SPECIFICATION: AMS 7477.
7. FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
8. SURFACE TEXTURE: USAS B46.1-1962 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEXAGON
9. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
10. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
11. DO NOT USE UNASSIGNED PART NUMBERS.

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THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION

P.A. AS Other Cust AV 99	INTERNATIONAL INTEREST ©	TITLE BOLT, MACHINED - HEXAGON HEAD, DRILLED, 1 HOLE, FULL SHANK, AMS 5731, .625-18 UNJF-3A	MILITARY STANDARD MS9507
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	PAGE 1	OF 1

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0904

APPROVED 5 MAY 1965

REVISED (A) 17 NOV 69 (R) 21 DEC 82 (C) 23 NOV 84