

MARK PART NUMBER AND MANUFACTURERS IDENTIFICATION PER AS478 CLASS A				FED SUP CLASS 5306	
VIEW A ENLARGED		CHAMFER 30° TO .438 DIAMETER		SECTION THRU THREAD PROFILE	

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9634-04	.375	.079-.099	.78	MS9634-33	2.375	1.565-1.625	2.08
MS9634-05	.438	.079-.099	.82	MS9634-34	2.500	1.690-1.750	2.16
MS9634-06	.500	.079-.099	.86	MS9634-35	2.625	1.815-1.875	2.25
MS9634-07	.562	.079-.099	.90	MS9634-36	2.750	1.940-2.000	2.33
MS9634-08	.625	.079-.099	.94	MS9634-37	2.875	2.065-2.125	2.41
MS9634-09	.688	.079-.099	.98	MS9634-38	3.000	2.190-2.250	2.49
MS9634-10	.750	.079-.099	1.02	MS9634-39	3.125	2.315-2.375	2.57
MS9634-11	.812	.079-.099	1.06	MS9634-40	3.250	2.440-2.500	2.65
MS9634-12	.875	.079-.125	1.10	MS9634-41	3.375	2.565-2.625	2.73
MS9634-13	.938	.128-.188	1.14	MS9634-42	3.500	2.690-2.750	2.82
MS9634-14	1.000	.190-.250	1.18	MS9634-43	3.625	2.815-2.875	2.90
MS9634-15	1.062	.252-.312	1.22	MS9634-44	3.750	2.940-3.000	2.98
MS9634-16	1.125	.315-.375	1.27	MS9634-45	3.875	3.065-3.125	3.06
MS9634-17	1.188	.378-.438	1.31	MS9634-46	4.000	3.190-3.250	3.14
MS9634-18	1.250	.440-.500	1.35	MS9634-47	4.125	3.315-3.375	3.23
MS9634-19	1.312	.502-.562	1.39	MS9634-48	4.250	3.440-3.500	3.31
MS9634-20	1.375	.565-.625	1.43	MS9634-49	4.375	3.565-3.625	3.39
MS9634-21	1.438	.628-.688	1.47	MS9634-50	4.500	3.690-3.750	3.47
MS9634-22	1.500	.690-.750	1.51	MS9634-51	4.625	3.815-3.875	3.55
MS9634-23	1.562	.752-.812	1.55	MS9634-52	4.750	3.940-4.000	3.63
MS9634-24	1.625	.815-.875	1.59	MS9634-53	4.875	4.065-4.125	3.71
MS9634-25	1.688	.878-.938	1.63	MS9634-54	5.000	4.190-4.250	3.79
MS9634-26	1.750	.940-1.000	1.67	MS9634-55	5.125	4.315-4.375	3.88
MS9634-27	1.812	1.002-1.062	1.72	MS9634-56	5.250	4.440-4.500	3.96
MS9634-28	1.875	1.065-1.125	1.76	MS9634-57	5.375	4.565-4.625	4.04
MS9634-29	1.938	1.128-1.188	1.80	MS9634-58	5.500	4.690-4.750	4.12
MS9634-30	2.000	1.190-1.250	1.84	MS9634-59	5.625	4.815-4.875	4.20
MS9634-31	2.125	1.315-1.375	1.92	MS9634-60	5.750	4.940-5.000	4.29
MS9634-32	2.250	1.440-1.500	2.00	MS9634-61	5.875	5.065-5.125	4.37
				MS9634-62	6.000	5.190-5.250	4.45

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 .013 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: TITANIUM AMS 4967.
6. HARDNESS: ROCKWELL C36-42.
7. MANUFACTURING SPECIFICATION: AMS 7461, EXCEPT MATERIAL AS NOTED.
8. FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
9. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES, EXCEPT UPSET HEAD.
10. BREAK SHARP EDGES .003 - .015 UNLESS OTHERWISE SPECIFIED.
11. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
12. DO NOT USE UNASSIGNED PART NUMBERS.

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

(B) REINSTATED 9 NOV 84

P.A. (B) AS	INTERNATIONAL INTEREST (B)	TITLE BOLT, MACHINE-HEXAGON HEAD, PD SHANK, TITANIUM AMS 4967 .250-28 UNJF-3A	MILITARY STANDARD MS9634
Other Cust AV 99			
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	PAGE	OF