

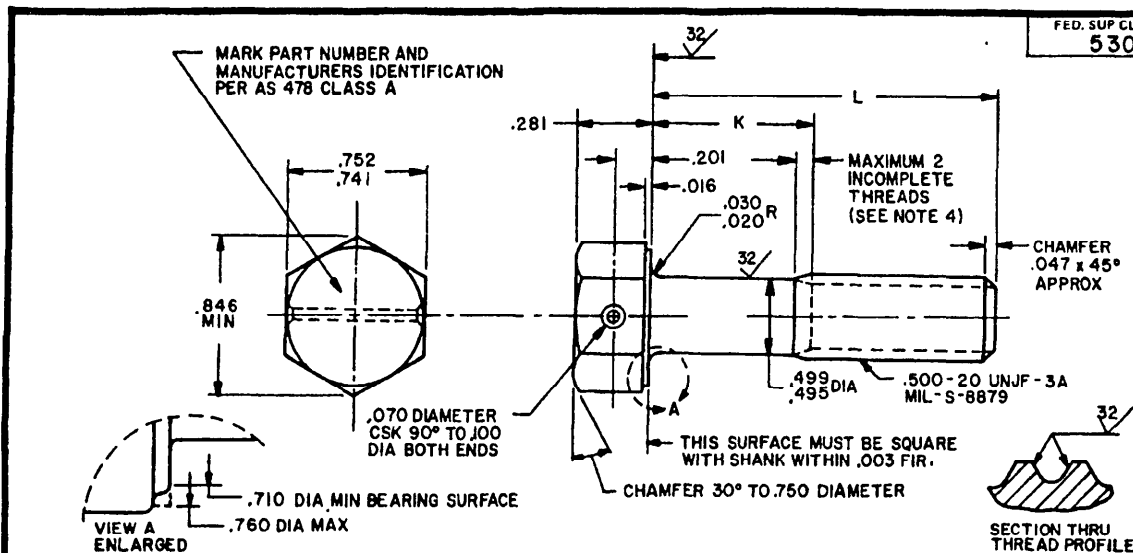
USER ACTIVITIES:

REVIEWER ACTIVITIES:

(B) AIR FORCE - 82

DLA-1S

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



PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9647-14	1.438	.128-.188	6.37
MS9647-15	1.500	.190-.250	6.54
MS9647-16	1.562	.252-.312	6.71
MS9647-17	1.625	.315-.375	6.88
MS9647-18	1.688	.378-.438	7.06
MS9647-19	1.750	.440-.500	7.23
MS9647-20	1.812	.502-.562	7.40
MS9647-21	1.875	.565-.625	7.57
MS9647-22	1.938	.628-.688	7.74
MS9647-23	2.000	.690-.750	7.92
MS9647-24	2.125	.815-.875	8.26
MS9647-25	2.250	.940-1.000	8.61
MS9647-26	2.375	1.065-1.125	8.96
MS9647-27	2.500	1.190-1.250	9.30
MS9647-28	2.625	1.315-1.375	9.64
MS9647-29	2.750	1.440-1.500	9.98
MS9647-30	2.875	1.565-1.625	10.36
MS9647-31	3.000	1.690-1.750	10.63
MS9647-32	3.125	1.815-1.875	11.02
MS9647-33	3.250	1.940-2.000	11.36
MS9647-34	3.375	2.065-2.125	11.71
MS9647-35	3.500	2.190-2.250	12.05

PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9647-36	3.625	2.315-2.375	12.39
MS9647-37	3.750	2.440-2.500	12.74
MS9647-38	3.875	2.565-2.625	13.08
MS9647-39	4.000	2.690-2.750	13.42
MS9647-40	4.125	2.815-2.875	13.77
MS9647-41	4.250	2.940-3.000	14.12
MS9647-42	4.375	3.065-3.125	14.46
MS9647-43	4.500	3.190-3.250	14.80
MS9647-44	4.625	3.315-3.375	15.14
MS9647-45	4.750	3.440-3.500	15.49
MS9647-46	4.875	3.565-3.625	15.84
MS9647-47	5.000	3.690-3.750	16.18
MS9647-48	5.125	3.815-3.875	16.52
MS9647-49	5.250	3.940-4.000	16.86
MS9647-50	5.375	4.065-4.125	17.21
MS9647-51	5.500	4.190-4.250	17.55
MS9647-52	5.625	4.315-4.375	17.90
MS9647-53	5.750	4.440-4.500	18.24
MS9647-54	5.875	4.565-4.625	18.58
MS9647-55	6.000	4.690-4.750	18.93

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 .023 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.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.

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

(B) REINSTATED 9 NOV 84

P.A. Other Cust	(B) AS AV 99	INTERNATIONAL INTEREST	TITLE BOLT, MACHINE-HEXAGON HEAD, DRILLED, 1 HOLE, FULL SHANK, TITANIUM AMS 4967, 500-20 UNJF-3A	MILITARY STANDARD MS9647
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:			PAGE 1 OF 1

DD FORM 1 MAY 72 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0918

APPROVED 4 MAY 70 REVISED (A) 21 DEC 83 (B) 9 NOV 84