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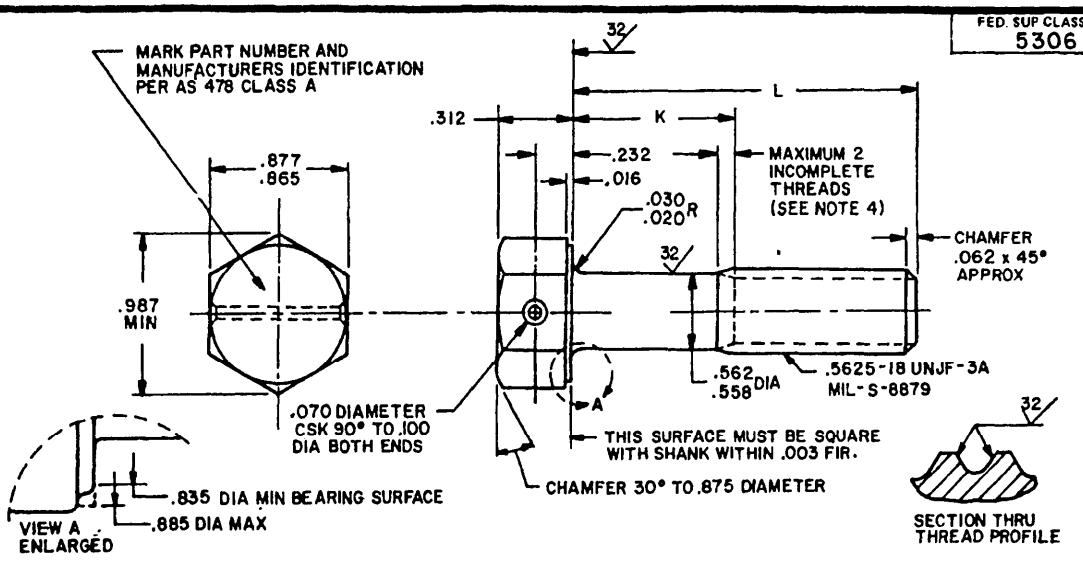

PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9648-15	1.562	.128- .188	8.95
MS9648-16	1.625	.190- .250	9.17
MS9648-17	1.688	.252- .312	9.39
MS9648-18	1.750	.315- .375	9.60
MS9648-19	1.812	.378- .438	9.82
MS9648-20	1.875	.440- .500	10.04
MS9648-21	1.938	.502- .562	10.26
MS9648-22	2.000	.565- .625	10.48
MS9648-23	2.125	.690- .750	10.91
MS9648-24	2.250	.815- .875	11.35
MS9648-25	2.375	.940-1.000	11.78
MS9648-26	2.500	1.065-1.125	12.22
MS9648-27	2.625	1.190-1.250	12.66
MS9648-28	2.750	1.315-1.375	13.09
MS9648-29	2.875	1.440-1.500	13.53
MS9648-30	3.000	1.565-1.625	13.97
MS9648-31	3.125	1.690-1.750	14.40
MS9648-32	3.250	1.815-1.875	14.84
MS9648-33	3.375	1.940-2.000	15.27
MS9648-34	3.500	2.065-2.125	15.71
MS9648-35	3.625	2.190-2.250	16.15

PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9648-36	3.750	2.315-2.375	16.58
MS9648-37	3.875	2.440-2.500	17.02
MS9648-38	4.000	2.565-2.625	17.46
MS9648-39	4.125	2.690-2.750	17.89
MS9648-40	4.250	2.815-2.875	18.33
MS9648-41	4.375	2.940-3.000	18.76
MS9648-42	4.500	3.065-3.125	19.20
MS9648-43	4.625	3.190-3.250	19.64
MS9648-44	4.750	3.315-3.375	20.07
MS9648-45	4.875	3.440-3.500	20.51
MS9648-46	5.000	3.565-3.625	20.94
MS9648-47	5.125	3.690-3.750	21.38
MS9648-48	5.250	3.815-3.875	21.82
MS9648-49	5.375	3.940-4.000	22.25
MS9648-50	5.500	4.065-4.125	22.69
MS9648-51	5.625	4.190-4.250	23.13
MS9648-52	5.750	4.315-4.375	23.56
MS9648-53	5.875	4.440-4.500	24.00
MS9648-54	6.000	4.565-4.625	24.44

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 .026 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 ±.010, ANGULAR DIMENSIONS ±5°.
12. DO NOT USE UNASSIGNED PART NUMBERS.

(B) REINSTATED 9 NOV 84

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.

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

USER ACTIVITIES:

REVIEWER ACTIVITIES:
(B) AIR FORCE - 82
DLA - IS

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.

P.A.	INTERNATIONAL INTEREST	TITLE	
(B) AS Other Cust AV 99	(B)	BOLT, MACHINE-HEXAGON HEAD, DRILLED, 1 HOLE, FULL SHANK, TITANIUM AMS 4967, .5625-18 UNJF-3A	MILITARY STANDARD MS9648
PROCUREMENT SPECIFICATION: NONE	SUPERSEDES:		PAGE 1 OF 1

DD FORM 1 MAY 73 672-1 (COORDINATED) PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE 5306-0919