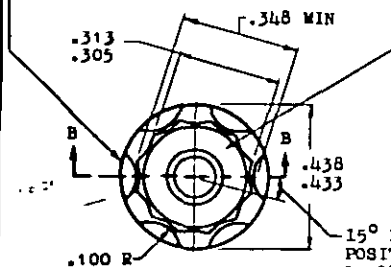


**MS9677 (ASG)**

6 SCALLOPS EQUALLY  
SPACED AND LOCATED  
WITHIN .010 EITHER  
SIDE OF TRUE POSITION

MARK PART NUMBER  
AND MANUFACTURERS IDENT  
PER AS 478 CLASS A

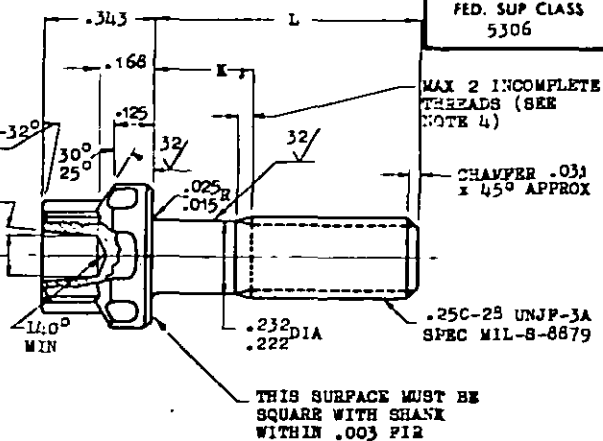


CHAMFER 28°-32°  
TO .312 DIA

5° MAX

.150 DIA

15° BASIC  
POSITION OF  
SCALLOPS RELATIVE  
TO DOUBLE HEXAGON



SECTION THRU  
THREAD PROFILE

SECTION B-B

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9677-04	.375	.079-.099	1.21	MS9677-22	1.500	.690-.750	2.52	MS9677-43	3.875	3.065-3.125	5.24
MS9677-05	.438	.079-.099	1.28	MS9677-23	1.562	.752-.812	2.59	MS9677-44	4.000	3.190-3.250	5.38
MS9677-06	.500	.079-.099	1.36	MS9677-24	1.625	.815-.875	2.66	MS9677-45	4.125	3.315-3.375	5.53
MS9677-07	.562	.079-.099	1.44	MS9677-25	1.688	.878-.938	2.73	MS9677-46	4.250	3.440-3.500	5.67
MS9677-08	.625	.079-.099	1.52	MS9677-26	1.750	.940-1.000	2.81	MS9677-47	4.375	3.565-3.625	5.82
MS9677-09	.688	.079-.099	1.59	MS9677-27	1.875	1.065-1.125	2.95	MS9677-48	4.500	3.690-3.750	5.96
MS9677-10	.750	.079-.099	1.66	MS9677-28	2.000	1.190-1.250	3.09	MS9677-49	4.625	3.815-3.875	6.11
MS9677-11	.812	.079-.099	1.73	MS9677-29	2.125	1.315-1.375	3.23	MS9677-50	4.750	3.940-4.000	6.25
MS9677-12	.875	.079-.125	1.80	MS9677-30	2.250	1.440-1.500	3.39	MS9677-51	4.875	4.065-4.125	6.40
MS9677-13	.938	.128-.188	1.87	MS9677-31	2.375	1.565-1.625	3.53	MS9677-52	5.000	4.190-4.250	6.54
MS9677-14	1.000	.190-.250	1.94	MS9677-32	2.500	1.690-1.750	3.67	MS9677-53	5.125	4.315-4.375	6.67
MS9677-15	1.062	.252-.312	2.01	MS9677-33	2.625	1.815-1.875	3.81	MS9677-54	5.250	4.440-4.500	6.81
MS9677-16	1.125	.315-.375	2.08	MS9677-34	2.750	1.940-2.000	3.95	MS9677-55	5.375	4.565-4.625	6.95
MS9677-17	1.188	.378-.438	2.16	MS9677-35	2.875	2.065-2.125	4.10	MS9677-56	5.500	4.690-4.750	7.10
MS9677-18	1.250	.440-.500	2.23	MS9677-36	3.000	2.190-2.250	4.24	MS9677-57	5.625	4.815-4.875	7.24
MS9677-19	1.312	.502-.562	2.30	MS9677-37	3.125	2.315-2.375	4.40	MS9677-58	5.750	4.940-5.000	7.39
MS9677-20	1.375	.565-.625	2.37	MS9677-38	3.250	2.440-2.500	4.54	MS9677-59	5.875	5.065-5.125	7.53
MS9677-21	1.438	.628-.688	2.45	MS9677-39	3.375	2.565-2.625	4.69	MS9677-60	6.000	5.190-5.250	7.68
				MS9677-40	3.500	2.690-2.750	4.83				
				MS9677-41	3.625	2.815-2.875	4.96				
				MS9677-42	3.750	2.940-3.000	5.10				

- SHANK SHALL BE STRAIGHT WITHIN .003 FIR PER INCH OF BOLT 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 .007 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5731.
- FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
- MANUFACTURING SPECIFICATION: AMS 7477.
- SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
- BREAK SHARP EDGES .003 TO .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.

ⓑ REINSTATED AFTER 27 JUN 84

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.	AS	TITLE	MILITARY STANDARD
Other Cust	ⓑ	BOLT, MACHINE - CRES AMS 5731, DOUBLE HEXAGON EXTENDED WASHER HEAD, CUP WASHER LOCKED .250-28 UNJF-3A	<b>MS9677 (ASG)</b>
PROCUREMENT SPECIFICATION	99	SUPERSEDES.	PAGE 1 OF 1

27 JUN 84

21 DEC 83

REVISED

18 NOV 65

APPROVED

Review activities:  
AIR FORCE - 82  
DLA - IS

This standard has been approved by the 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.