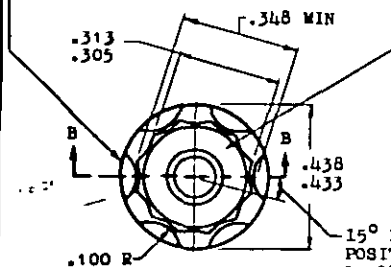


MS9677 (ASG)

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

MARK PART NUMBER AND MANUFACTURERS IDENT PER AS 478 CLASS A

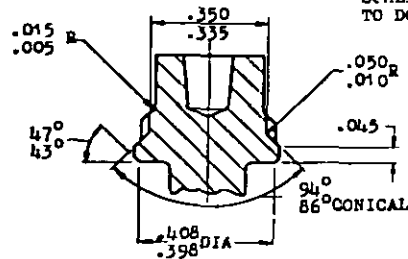


CHAMFER 28°-32° TO .312 DIA

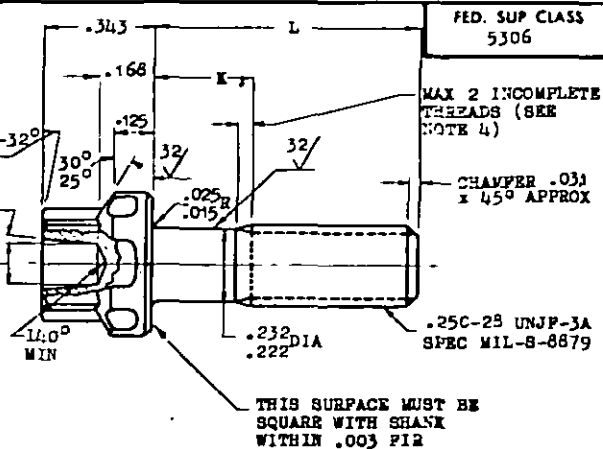
5° MAX

.150 DIA

15° BASIC POSITION OF SCALLOPS RELATIVE TO DOUBLE HEXAGON



SECTION B-B



SECTION THRU THREAD PROFILE

FED. SUP CLASS 5306

MAX 2 INCOMPLETE THREADS (SEE NOTE 4)

CHAMFER .031 x 45° APPROX

Review Activities
AIR FORCE - 82
DLA - IS

(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.

(B) 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 | (B) | BOLT, MACHINE - CRES AMS 5731, DOUBLE HEXAGON EXTENDED WASHER HEAD, CUP WASHER LOCKED .250-28 UNJF-3A | MS9677 (ASG) |
| PROCUREMENT SPECIFICATION | 99 | SUPERSEDES. | PAGE 1 OF 1 |

APPROVED 18 NOV 65
REVISED (A) 21 DEC 83 (B) 27 JUN 84

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.