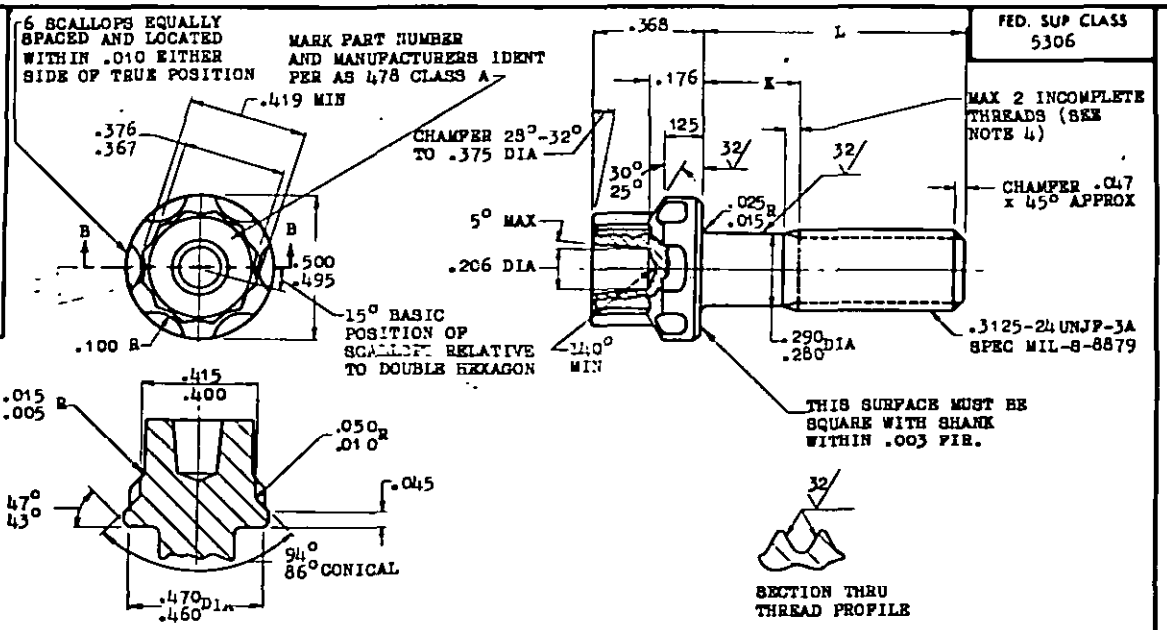
MS9678 (ASG)

FED. SUP CLASS 5306



PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
				MS9678-20	1.500	.565- .625	3.88	MS9678-41	3.875	2.940-3.000	8.22
				MS9678-21	1.562	.628- .688	3.99	MS9678-42	4.000	3.065-3.125	8.45
				MS9678-22	1.625	.690- .750	4.11	MS9678-43	4.125	3.190-3.250	8.68
				MS9678-23	1.688	.752 - .812	4.23	MS9678-44	4.250	3.315-3.375	8.91
MS9678-03	.438	.088- .108	1.94	MS9678-24	1.750	.815- .875	4.35	MS9678-45	4.375	3.440-3.500	9.13
MS9678-04	.500	.088- .108	2.05	MS9678-25	1.875	.940-1.000	4.57	MS9678-46	4.500	3.565-3.625	9.35
MS9678-05	.562	.088- .108	2.16	MS9678-26	2.000	1.065-1.125	4.79	MS9678-47	4.625	3.690-3.750	9.57
MS9678-06	.625	.088- .108	2.27	MS9678-27	2.125	1.190-1.250	5.02	MS9678-48	4.750	3.815-3.875	9.79
MS9678-07	.688	.088- .108	2.39	MS9678-28	2.250	1.315-1.375	5.26	MS9678-49	4.875	3.940-4.000	10.00
MS9678-08	.750	.088- .108	2.51	MS9678-29	2.375	1.440-1.500	5.48	MS9678-50	5.000	4.065-4.125	10.22
MS9678-09	.812	.088- .108	2.62	MS9678-30	2.500	1.565-1.625	5.70	MS9678-51	5.125	4.190-4.250	10.45
MS9678-10	.875	.088- .108	2.73	MS9678-31	2.625	1.690-1.750	5.93	MS9678-52	5.250	4.315-4.375	10.68
MS9678-11	.938	.088- .108	2.85	MS9678-32	2.750	1.815-1.875	6.16	MS9678-53	5.375	4.440-4.500	10.91
MS9678-12	1.000	.088- .125	2.96	MS9678-33	2.875	1.940-2.000	6.40	MS9678-54	5.500	4.565-4.625	11.15
MS9678-13	1.062	.128 - .188	3.07	MS9678-34	3.000	2.065-2.125	6.62	MS9678-55	5.625	4.690-4.750	11.38
MS9678-14	1.125	.190- .250	3.19	MS9678-35	3.125	2.190-2.250	6.84	MS9678-56	5.750	4.815-4.875	11.61
MS9678-15	1.188	.252- .312	3.30	MS9678-36	3.250	2.315-2.375	7.07	MS9678-57	5.875	4.940-5.000	11.83
MS9678-16	1.250	.315- .375	3.42	MS9678-37	3.375	2.440-2.500	7.32	MS9678-58	6.000	5.065-5.125	12.05
MS9678-17	1.312	.378- .438	3.53	MS9678-38	3.500	2.565-2.625	7.55				
MS9678-18	1.375	.440- .500	3.65	MS9678-39	3.625	2.690-2.750	7.78				
MS9678-19	1.438	.502- .562	3.76	MS9678-40	3.750	2.815-2.875	8.00				

1. SHANK SHALL BE STRAIGHT WITHIN .003 FIR 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 DOUBLE HEXAGON OD SHALL BE WITH .008 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5731.
6. FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
7. MANUFACTURING SPECIFICATION: AMS 7477.
8. SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
9. BREAK SHARP EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
10. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± .010, ANGULAR DIMENSIONS ± 5°.
11. DO NOT USE UNASSIGNED PART NUMBERS.

Ⓑ REINSTATED AFTER 27 JUN 84

AN & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER UTILITY PARTS COMMITTEE OF THE SAE.

APPROVED 18 Nov 65 REVISED Ⓐ 21 DEC 83 Ⓑ 27 JUN 84

Review activities: Ⓑ AIR FORCE - 82 DLA-1S

P.A. AS Ⓑ
Other Cust
99

TITLE: BOLT, MACHINE-CRES AMS 5731, DOUBLE HEXAGON EXTENDED WASHER HEAD, CUPWASHER LOCKED, .3125-24 UNJF-3A

MILITARY STANDARD
MS9678 (ASG)

PROCUREMENT SPECIFICATION NOTE

SUPERSEDES:

PAGE 1 OF 1

DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0861