

MS9678 (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 .375 DIA

5° MAX

15° BASIC POSITION OF SCALLOPS RELATIVE TO DOUBLE HEXAGON

THIS SURFACE MUST BE SQUARE WITH SHANK WITHIN .003 FIR.

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
MS9678-03	.438	.088-.108	1.94	MS9678-20	1.500	.565-.625	3.88	MS9678-41	3.875	2.940-3.000	8.22
MS9678-04	.500	.088-.108	2.05	MS9678-21	1.562	.628-.688	3.99	MS9678-42	4.000	3.065-3.125	8.45
MS9678-05	.562	.088-.108	2.16	MS9678-22	1.625	.690-.750	4.11	MS9678-43	4.125	3.190-3.250	8.68
MS9678-06	.625	.088-.108	2.27	MS9678-23	1.688	.752-.812	4.23	MS9678-44	4.250	3.315-3.375	8.91
MS9678-07	.688	.088-.108	2.39	MS9678-24	1.750	.815-.875	4.35	MS9678-45	4.375	3.440-3.500	9.13
MS9678-08	.750	.088-.108	2.51	MS9678-25	1.875	.940-1.000	4.57	MS9678-46	4.500	3.565-3.625	9.35
MS9678-09	.812	.088-.108	2.62	MS9678-26	2.000	1.065-1.125	4.79	MS9678-47	4.625	3.690-3.750	9.57
MS9678-10	.875	.088-.108	2.73	MS9678-27	2.125	1.190-1.250	5.02	MS9678-48	4.750	3.815-3.875	9.79
MS9678-11	.938	.088-.108	2.85	MS9678-28	2.250	1.315-1.375	5.26	MS9678-49	4.875	3.940-4.000	10.00
MS9678-12	1.000	.088-.125	2.96	MS9678-29	2.375	1.440-1.500	5.48	MS9678-50	5.000	4.065-4.125	10.22
MS9678-13	1.062	.128-.168	3.07	MS9678-30	2.500	1.565-1.625	5.70	MS9678-51	5.125	4.190-4.250	10.45
MS9678-14	1.125	.190-.250	3.19	MS9678-31	2.625	1.690-1.750	5.93	MS9678-52	5.250	4.315-4.375	10.68
MS9678-15	1.188	.252-.312	3.30	MS9678-32	2.750	1.815-1.875	6.16	MS9678-53	5.375	4.440-4.500	10.91
MS9678-16	1.250	.315-.375	3.42	MS9678-33	2.875	1.940-2.000	6.40	MS9678-54	5.500	4.565-4.625	11.15
MS9678-17	1.312	.378-.438	3.53	MS9678-34	3.000	2.065-2.125	6.62	MS9678-55	5.625	4.690-4.750	11.38
MS9678-18	1.375	.440-.500	3.65	MS9678-35	3.125	2.190-2.250	6.84	MS9678-56	5.750	4.815-4.875	11.61
MS9678-19	1.438	.502-.562	3.76	MS9678-36	3.250	2.315-2.375	7.07	MS9678-57	5.875	4.940-5.000	11.83
				MS9678-37	3.375	2.440-2.500	7.32	MS9678-58	6.000	5.065-5.125	12.05
				MS9678-38	3.500	2.565-2.625	7.55				
				MS9678-39	3.625	2.690-2.750	7.78				
				MS9678-40	3.750	2.815-2.875	8.00				

- 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 WITH .008 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.

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THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER UTILITY PARTS COMMITTEE OF THE SAE.

REINSTATED AFTER 27 JUN 84

P.A.	AS	TITLE	MILITARY STANDARD
Other Cust	(B)	BOLT, MACHINE-CRES AMS 5731, DOUBLE HEXAGON EXTENDED WASHER HEAD, CUPWASHER LOCKED, .3125-24 UNJP-3A	MS9678 (ASG)
99			
PROCUREMENT SPECIFICATION	SUPERSEDES:		PAGE 1 OF 1

Review activities:
AIR FORCE - 82
DLA - 15

This standard has been approved by the Department of the Air Force and the Department of the Navy, and is mandatory for use by that activity. All other military activities are required to employ this standard where suitable.