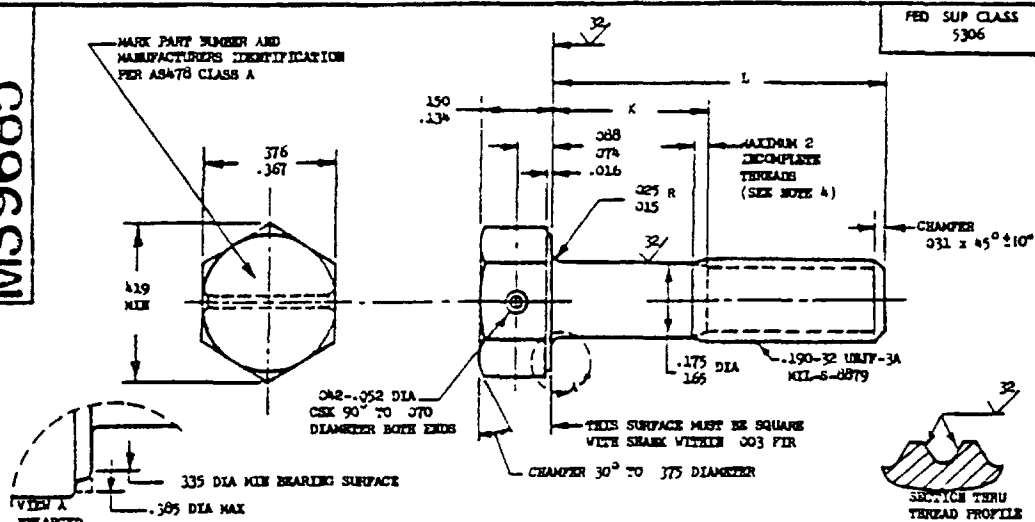


MS9685



PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9685-03	312	.072-.092	.70	MS9685-31	2.125	1.435-1.495	1.86
MS9685-04	.775	.072-.092	.74	MS9685-32	2.250	1.560-1.620	1.94
MS9685-05	.438	.072-.092	.78	MS9685-33	2.375	1.685-1.745	2.02
MS9685-06	.500	.072-.092	.82	MS9685-34	2.500	1.810-1.870	2.10
MS9685-07	.562	.072-.092	.86	MS9685-35	2.625	1.935-1.995	2.18
MS9685-08	.625	.072-.092	.90	MS9685-36	2.750	2.060-2.120	2.26
MS9685-09	.688	.072-.092	.94	MS9685-37	2.875	2.185-2.245	2.34
MS9685-10	.750	.072-.120	.98	MS9685-38	3.000	2.310-2.370	2.42
MS9685-11	.812	.122-.182	1.02	MS9685-39	3.125	2.435-2.495	2.50
MS9685-12	.875	.125-.245	1.06	MS9685-40	3.250	2.560-2.620	2.58
MS9685-13	.938	.248-.308	1.10	MS9685-41	3.375	2.685-2.745	2.66
MS9685-14	1.000	.310-.370	1.15	MS9685-42	3.500	2.810-2.870	2.74
MS9685-15	1.062	.372-.432	1.19	MS9685-43	3.625	2.935-2.995	2.82
MS9685-16	1.125	.435-.495	1.23	MS9685-44	3.750	3.060-3.120	2.90
MS9685-17	1.188	.498-.558	1.27	MS9685-45	3.875	3.185-3.245	2.98
MS9685-18	1.250	.560-.620	1.31				
MS9685-19	1.312	.622-.682	1.35				
MS9685-20	1.375	.685-.745	1.38				
MS9685-21	1.438	.748-.808	1.42				
MS9685-22	1.500	.810-.870	1.46				
MS9685-23	1.562	.872-.932	1.50				
MS9685-24	1.625	.935-.995	1.54				
MS9685-25	1.688	.998-1.058	1.58				
MS9685-26	1.750	1.060-1.120	1.62				
MS9685-27	1.812	1.122-1.182	1.66				
MS9685-28	1.875	1.185-1.245	1.70				
MS9685-29	1.938	1.248-1.308	1.74				
MS9685-30	2.000	1.310-1.370	1.78				

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 .011 FIR.
4. INCOMPLETE THREADS NOT TO EXCEED FILLET.
5. MATERIAL: STEEL AMS 6304.
6. HARDNESS: ROCKWELL C42-46.
7. FINISH: DIFFUSED NICKEL CADMIUM PLATE AMS 2416. DIMENSIONS SPECIFIED ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE.
8. MANUFACTURING SPECIFICATION: AMS 7459.
9. MAGNETIC PARTICLE INSPECTION PER AMS 2640 BEFORE PLATING.
10. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
11. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
13. DO NOT USE UNASSIGNED PART NUMBERS.

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.

P.A. Air Force - 11 Other Cust Navy - AS	INTERNATIONAL TITLE INTEREST ASCC AIR STD 17/2	BOLT, MACHINE - HEXAGON HEAD, DRILLED, 1 BOLT, PD SHANK STEEL AMS 6304, DIFFUSED NICKEL CADMIUM PLATE, .390-32 UNF-3A	MILITARY STANDARD MS9685
PROCUREMENT SPECIFICATION: SUPERSEDES: AMS7459			SHEET 1 OF 1

FORM 672-1 (Limited reproduction)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

Standard has been approved by the Department of Air Force and the
Department of the Navy, and is mandatory for use by
any activity which is required to comply with the standard
unless the standard is otherwise indicated.

APPROVED 8 JUL 71 REVISED