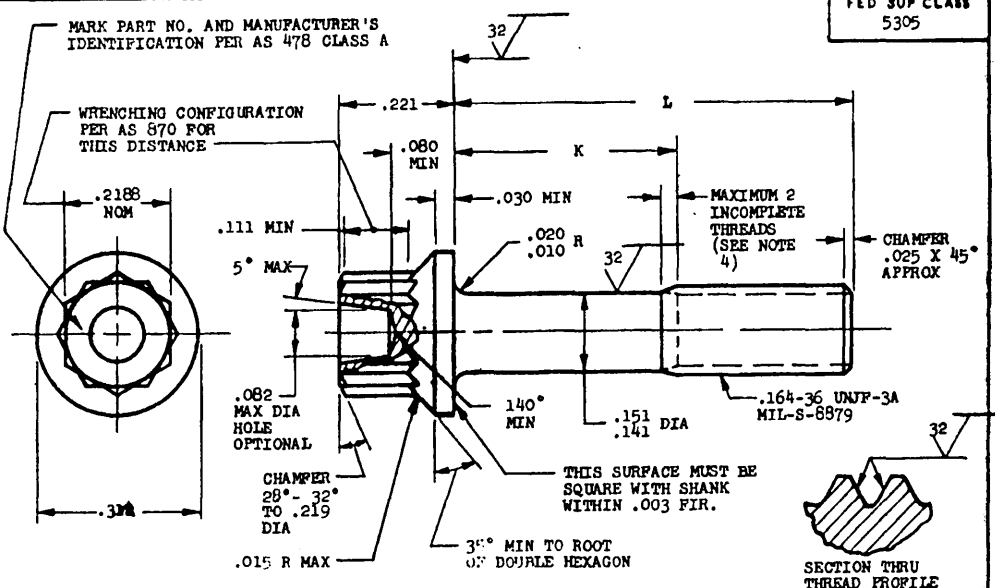


MARK PART NO. AND MANUFACTURER'S
IDENTIFICATION PER AS 478 CLASS A

WRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE _____



SECTION THRU
THREAD PROFILE

PART NO.	L	K	APPROX WEIGHT LB/100	PART NO.	L	K	APPROX WEIGHT LB/100
MS9731-02	.250	.062-.082	.42	MS9731-17	1.188	.550-.610	.86
MS9731-03	.312	.062-.082	.45	MS9731-18	1.250	.612-.672	.89
MS9731-04	.375	.062-.082	.46	MS9731-19	1.312	.674-.734	.92
MS9731-05	.435	.062-.082	.51	MS9731-20	1.375	.737-.797	.95
MS9731-06	.500	.062-.082	.55	MS9731-21	1.438	.800-.860	.96
MS9731-07	.562	.062-.082	.57	MS9731-22	1.500	.862-.922	1.01
MS9731-08	.625	.062-.082	.60	MS9731-23	1.562	.924-.984	1.04
MS9731-09	.688	.062-.110	.63	MS9731-24	1.625	.987-1.047	1.06
MS9731-10	.750	.112-.172	.66	MS9731-25	1.688	1.050-1.110	1.10
MS9731-11	.812	.174-.234	.68	MS9731-26	1.750	1.112-1.172	1.12
MS9731-12	.875	.237-.297	.71	MS9731-27	1.812	1.174-1.234	1.15
MS9731-13	.938	.300-.360	.74	MS9731-28	1.875	1.237-1.297	1.18
MS9731-14	1.000	.362-.422	.77	MS9731-29	2.000	1.362-1.422	1.24
MS9731-15	1.062	.424-.484	.80				
MS9731-16	1.125	.487-.547	.83				

Review activities:

58 - 42. 85

This military standard is approved by the Department of the Air Force and the Naval Air Systems Command and is mandatory for use by these activities. All other military activities are required to employ this standard where suitable.

1. SHANK SHALL BE STRAIGHT WITHIN .003 PER INCH OF SCREW LENGTH.
2. THE RUNOUT OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
3. THE RUNOUT OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .005 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: CRES AMS 5643.
6. HARDNESS: ROCKWELL C32-33.
7. MANUFACTURING SPECIFICATION: AMS 7474.
8. FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
9. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
10. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
12. 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 DIV.

P.A. USAF - 11		TITLE	MILITARY STANDARD
Other Cust		SCREW, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, PD SHANK, CRES AMS 5643, .164-36 UNJF-3A	MS9731 (ASG)
Navy - AS			
PROCUREMENT SPECIFICATION	SUPERSEDES:		SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)
1 APR 57

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5305 - P012
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APPROVED	3 Mar 69	REVISED