

MS9745 (ASG)

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

WRENCHING CONFIGURATION PER AS 470 FOR THIS DISTANCE

SECTION THRU THREAD PROFILE

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

35° MIN TO ROOT OF DOUBLE HEXAGON

CHAMFER 28°-32° TO .500 DIA

CHAMFER .047 X 45° APPROX

MAXIMUM 2 INCOMPLETE THREADS (SEE NOTE 4)

.030 R .020

.110 MIN

.212

.351

.454

.32

.32

.410 DIA

.4375-20 UNWF-3A MIL-S-8879

.140° MIN

.310 DIA

.5000 NOM

.688

.070 DIA 4 HOLES EQUALLY SPACED AS SHOWN CSK 50° TO .100 DIA

5° MAX

45°

FED SUP CLASS 5306

PART NO.	L	K	APPROX WEIGHT LB/100
MS9745-04	.688	.105-.125	5.51
MS9745-05	.750	.105-.125	5.74
MS9745-06	.812	.105-.125	5.96
MS9745-07	.875	.105-.125	6.19
MS9745-08	.938	.105-.125	6.41
MS9745-09	1.000	.105-.125	6.64
MS9745-10	1.062	.105-.125	6.86
MS9745-11	1.125	.105-.125	7.09
MS9745-12	1.188	.105-.125	7.32
MS9745-13	1.250	.105-.125	7.54
MS9745-14	1.312	.125-.150	7.77
MS9745-15	1.375	.150-.250	8.00
MS9745-16	1.438	.252-.312	8.22
MS9745-17	1.500	.315-.375	8.45
MS9745-18	1.562	.375-.438	8.67
MS9745-19	1.625	.440-.500	8.90
MS9745-20	1.688	.502-.562	9.13
MS9745-21	1.750	.565-.625	9.35
MS9745-22	1.812	.628-.688	9.58
MS9745-23	1.875	.690-.750	9.80
MS9745-24	2.000	.815-.875	10.26
MS9745-25	2.125	.940-1.000	10.71
MS9745-26	2.250	1.065-1.125	11.16
MS9745-27	2.375	1.190-1.250	11.61
MS9745-28	2.500	1.315-1.375	12.06
MS9745-29	2.625	1.440-1.500	12.52
MS9745-30	2.750	1.565-1.625	12.97
MS9745-31	2.875	1.690-1.750	13.42
MS9745-32	3.000	1.815-1.875	13.87
MS9745-33	3.125	1.940-2.000	14.32
MS9745-34	3.250	2.065-2.125	14.75
MS9745-35	3.375	2.190-2.250	15.23
MS9745-36	3.500	2.315-2.375	15.65
MS9745-37	3.625	2.440-2.500	16.13
MS9745-38	3.750	2.565-2.625	16.56
MS9745-39	3.875	2.690-2.750	17.00
MS9745-40	4.000	2.815-2.875	17.49
MS9745-41	4.125	2.940-3.000	17.94
MS9745-42	4.250	3.065-3.125	18.39
MS9745-43	4.375	3.190-3.250	18.84
MS9745-44	4.500	3.315-3.375	19.30
MS9745-45	4.625	3.440-3.500	19.75
MS9745-46	4.750	3.565-3.625	20.20
MS9745-47	4.875	3.690-3.750	20.65
MS9745-48	5.000	3.815-3.875	21.10
MS9745-49	5.125	3.940-4.000	21.56
MS9745-50	5.250	4.065-4.125	22.01
MS9745-51	5.375	4.190-4.250	22.46
MS9745-52	5.500	4.315-4.375	22.91
MS9745-53	5.625	4.440-4.500	23.36
MS9745-54	5.750	4.565-4.625	23.82
MS9745-55	5.875	4.690-4.750	24.27
MS9745-56	6.000	4.815-4.875	24.72

- SHANK SHALL BE STRAIGHT WITHIN .0025 PER INCH OF BOLT LENGTH.
- THE RUNOUT OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
- THE RUNOUT OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .010 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- MATERIAL: CRES AMS 5643.
- HARDNESS: ROCKWELL C32-38.
- MANUFACTURING SPECIFICATION: AMS 7474.
- FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
- SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPPER HEAD.
- BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
- 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	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER	MS9745 (ASG)
Navy - AN	HEAD, DRILLED, PD SHANK, CRES AMS 5643, .4375-20 UNWF-3A	
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672-1 (limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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Review activities:
USAF - 02, 05

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.

REVISED
3 MAY 69
APPROVED