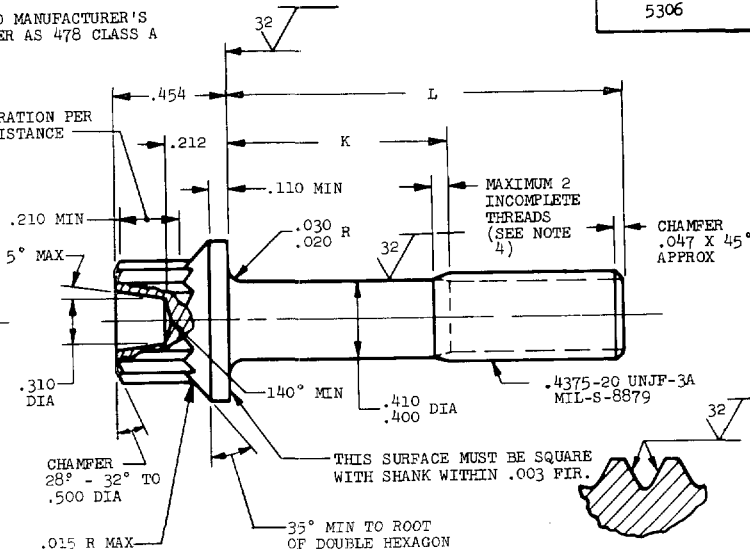
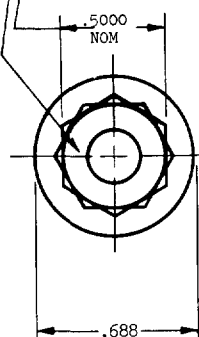


MS9754 (ASG)

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	PART NO.	L	K	APPROX WEIGHT LB/100
MS9754-04	.688	.105-.125	3.15	MS9754-22	1.812	.628-.688	5.45	MS9754-40	4.000	2.815-2.875	9.93
MS9754-05	.750	.105-.125	3.28	MS9754-23	1.875	.690-.750	5.58	MS9754-41	4.125	2.940-3.000	10.19
MS9754-06	.812	.105-.125	3.40	MS9754-24	2.000	.815-.875	5.84	MS9754-42	4.250	3.065-3.125	10.44
MS9754-07	.875	.105-.125	3.53	MS9754-25	2.125	.940-1.000	6.09	MS9754-43	4.375	3.190-3.250	10.70
MS9754-08	.938	.105-.125	3.66	MS9754-26	2.250	1.065-1.125	6.35	MS9754-44	4.500	3.315-3.375	10.96
MS9754-09	1.000	.105-.125	3.79	MS9754-27	2.375	1.190-1.250	6.60	MS9754-45	4.625	3.440-3.500	11.21
MS9754-10	1.062	.105-.125	3.92	MS9754-28	2.500	1.315-1.375	6.86	MS9754-46	4.750	3.565-3.625	11.47
MS9754-11	1.125	.105-.125	4.04	MS9754-29	2.625	1.440-1.500	7.12	MS9754-47	4.875	3.690-3.750	11.72
MS9754-12	1.188	.105-.125	4.17	MS9754-30	2.750	1.565-1.625	7.37	MS9754-48	5.000	3.815-3.875	11.98
MS9754-13	1.250	.105-.125	4.30	MS9754-31	2.875	1.690-1.750	7.63	MS9754-49	5.125	3.940-4.000	12.24
MS9754-14	1.312	.128-.188	4.43	MS9754-32	3.000	1.815-1.875	7.88	MS9754-50	5.250	4.065-4.125	12.49
MS9754-15	1.375	.190-.250	4.56	MS9754-33	3.125	1.940-2.000	8.14	MS9754-51	5.375	4.190-4.250	12.75
MS9754-16	1.438	.252-.312	4.68	MS9754-34	3.250	2.065-2.125	8.40	MS9754-52	5.500	4.315-4.375	13.00
MS9754-17	1.500	.315-.375	4.81	MS9754-35	3.375	2.190-2.250	8.65	MS9754-53	5.625	4.440-4.500	13.26
MS9754-18	1.562	.378-.438	4.94	MS9754-36	3.500	2.315-2.375	8.91	MS9754-54	5.750	4.565-4.625	13.52
MS9754-19	1.625	.440-.500	5.07	MS9754-37	3.625	2.440-2.500	9.16	MS9754-55	5.875	4.690-4.750	13.77
MS9754-20	1.688	.502-.562	5.20	MS9754-38	3.750	2.565-2.625	9.42	MS9754-56	6.000	4.815-4.875	14.03
MS9754-21	1.750	.565-.625	5.32	MS9754-39	3.875	2.690-2.750	9.68				

- 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: TITANIUM AMS 4967.
- HARDNESS: ROCKWELL C36-42.
- MANUFACTURING SPECIFICATION: AMS 7461, EXCEPT MATERIAL AS NOTED.
- FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
- SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
- BREAK SHARP EDGES .003-.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.

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 Cost	Navy - AS	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, PD SHANK, TITANIUM AMS 4967, .4375-20 UNJF-3A	MS9754 (ASG)
PROCUREMENT SPECIFICATION	SUPERSEDES:		SHEET 1 OF 1

DD FORM 872-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

Project No. 5306-FO61
☆ U. S. GOVERNMENT PRINTING OFFICE: 1969-34-1518/A-541

Review activities: USAP-82, 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 those activities. All other military activities are required to employ this standard where suitable.

REVISED
APPROVED 3 Mar 69