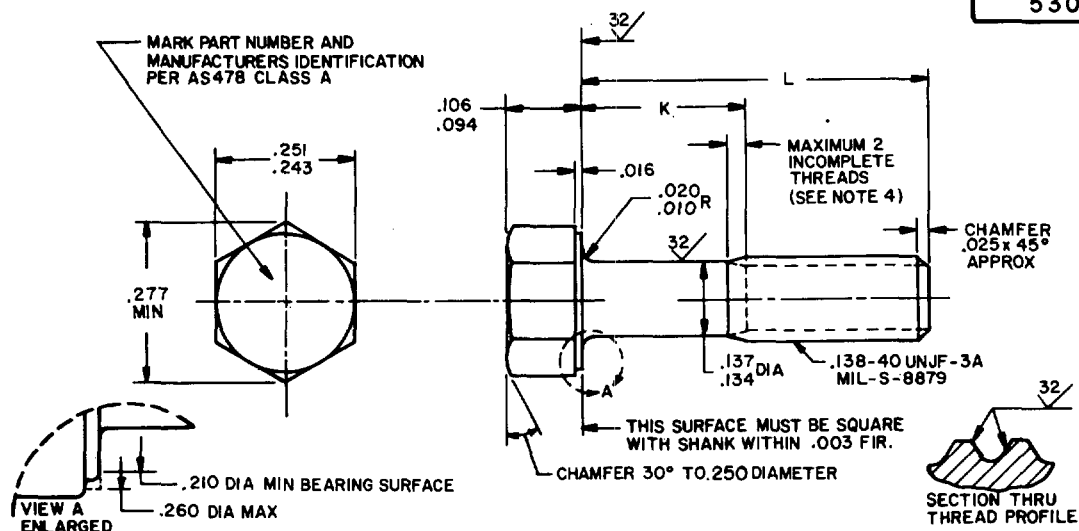


USER ACTIVITIES:

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PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9781-09	.688	.102- .162	.43
MS9781-10	.750	.164- .224	.45
MS9781-11	.812	.226- .286	.48
MS9781-12	.875	.289- .349	.50
MS9781-13	.938	.352- .412	.53
MS9781-14	1.000	.414- .474	.56
MS9781-15	1.062	.476- .536	.58
MS9781-16	1.125	.539- .599	.61
MS9781-17	1.188	.602- .662	.63
MS9781-18	1.250	.664- .724	.66
MS9781-19	1.312	.726- .786	.68
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MS9781-22	1.500	.914- .974	.76
MS9781-23	1.562	.976-1.036	.78
MS9781-24	1.625	1.039-1.099	.81
MS9781-25	1.688	1.102-1.162	.83
MS9781-26	1.750	1.164-1.224	.86
MS9781-27	1.812	1.226-1.286	.88
MS9781-28	1.875	1.289-1.349	.91
MS9781-29	1.938	1.352-1.412	.94
MS9781-30	2.000	1.414-1.474	.96

PART NUMBER	L	K	APPROX WEIGHT LB/100

1. SHANK SHALL BE STRAIGHT WITHIN .003 TOTAL PER INCH OF SCREW 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 .009 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: CORROSION RESISTANT STEEL AMS 5643.
6. HARDNESS: ROCKWELL C32-38.
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 $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
12. DO NOT USE UNASSIGNED PART NUMBERS.

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THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

(B) REINSTATED 9 NOV 84

P. A. (B) AS Other Cust AV 99	INTERNATIONAL INTEREST (B)	TITLE SCREW, MACHINE - HEXAGON HEAD, FULL SHANK, AMS 5643, .138 - 40 UNJF - 3A	MILITARY STANDARD
			MS9781
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	PAGE 1 OF 1	