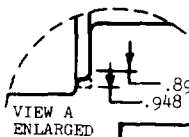
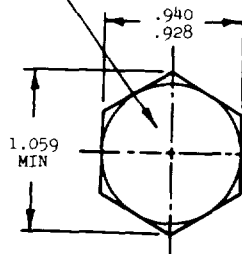
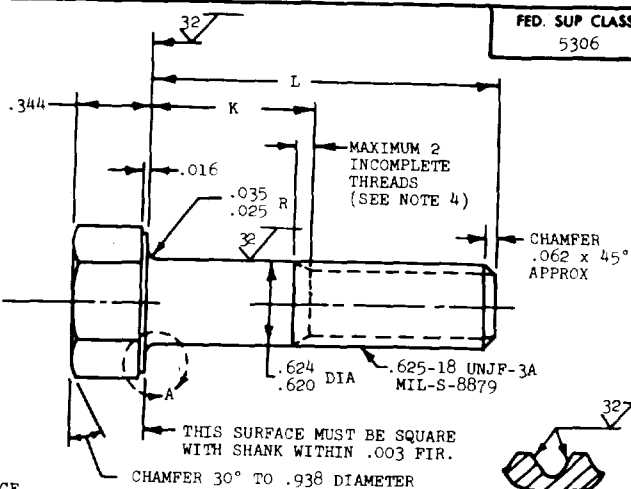


MS9790

MARK PART NUMBER AND
MANUFACTURERS IDENTIFICATION
PER AS 478 CLASS A



.898 DIA MIN BEARING SURFACE
.948 DIA MAX



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

CHAMFER 30° TO .938 DIAMETER

SECTION THRU
THREAD PROFILE

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9790-15	1.688	.128-.188	21.80	MS9790-31	3.375	1.815-1.875	36.26
MS9790-16	1.750	.190-.250	22.33	MS9790-32	3.500	1.940-2.000	37.33
MS9790-17	1.812	.252-.312	22.87	MS9790-33	3.625	2.065-2.125	38.39
MS9790-18	1.875	.315-.375	23.40	MS9790-34	3.750	2.190-2.250	39.47
MS9790-19	1.938	.378-.438	23.93	MS9790-35	3.875	2.315-2.375	40.54
MS9790-20	2.000	.440-.500	24.47	MS9790-36	4.000	2.440-2.500	41.61
MS9790-21	2.125	.565-.625	25.54	MS9790-37	4.125	2.565-2.625	42.68
MS9790-22	2.250	.690-.750	26.61	MS9790-38	4.250	2.690-2.750	43.75
MS9790-23	2.375	.815-.875	27.69	MS9790-39	4.375	2.815-2.875	44.82
MS9790-24	2.500	.940-1.000	28.75	MS9790-40	4.500	2.940-3.000	45.90
MS9790-25	2.625	1.065-1.125	29.83	MS9790-41	4.625	3.065-3.125	46.96
MS9790-26	2.750	1.190-1.250	30.90	MS9790-42	4.750	3.190-3.250	48.04
MS9790-27	2.875	1.315-1.375	31.97	MS9790-43	4.875	3.315-3.375	49.11
MS9790-28	3.000	1.440-1.500	33.04	MS9790-44	5.000	3.440-3.500	50.18
MS9790-29	3.125	1.565-1.625	34.12	MS9790-45	5.125	3.565-3.625	51.25
MS9790-30	3.250	1.690-1.750	35.18	MS9790-46	5.250	3.690-3.750	52.33
				MS9790-47	5.375	3.815-3.875	53.39
				MS9790-48	5.500	3.940-4.000	54.47
				MS9790-49	5.625	4.065-4.125	55.54
				MS9790-50	5.750	4.190-4.250	56.61
				MS9790-51	5.875	4.315-4.375	57.68
				MS9790-52	6.000	4.440-4.500	58.76

1. SHANK SHALL BE STRAIGHT WITHIN .002 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 .028 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.

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. USAP-II	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cust ARMY-AV NAVY-AS	ASCC AIR STD 17/2	BOLT, MACHINE - HEXAGON HEAD, FULL SHANK, AMS 5643, .625-18 UNJF-3A	MS9790
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1	

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

Review Activities:
USAF-82

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

REVISED
11 MAR 70
APPROVED