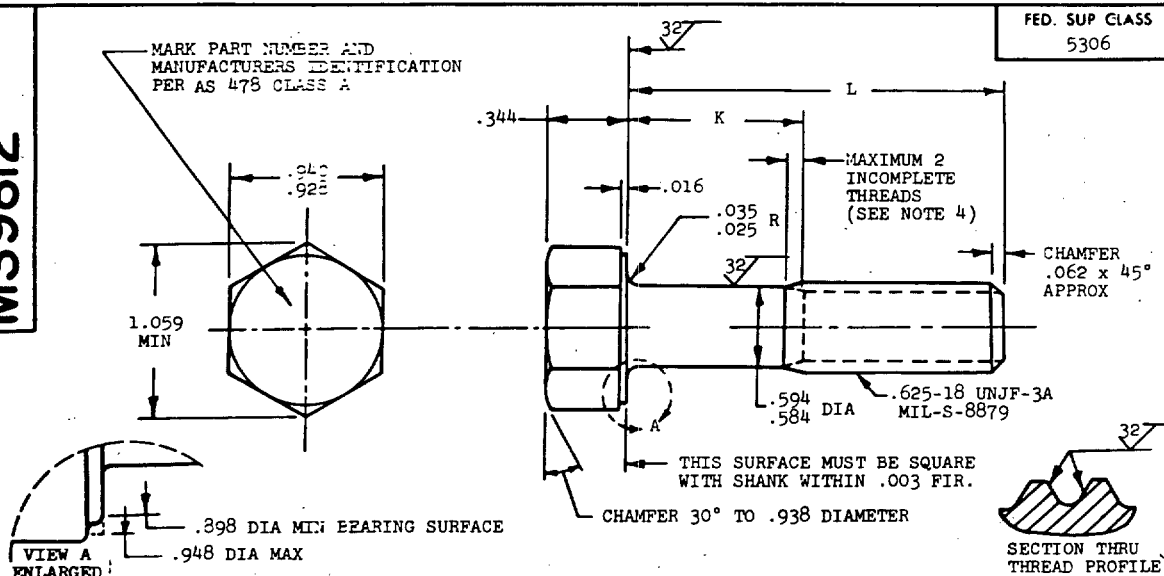


MS9812

Review activities:
AIR FORCE - 82
DLA - 15

ⓑ

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

PART NUMBER	L	K	APPROX WEIGHT LB/100	PART NUMBER	L	K	APPROX WEIGHT LB/100
MS9812-03	.938	.118-.138	14.47	MS9812-31	3.375	1.815-1.875	33.07
MS9812-04	1.000	.118-.138	14.95	MS9812-32	3.500	1.940-2.000	34.02
MS9812-05	1.062	.118-.138	15.43	MS9812-33	3.625	2.065-2.125	34.97
MS9812-06	1.125	.118-.138	15.91	MS9812-34	3.750	2.190-2.250	35.93
MS9812-07	1.188	.118-.138	16.38	MS9812-35	3.875	2.315-2.375	36.88
MS9812-08	1.250	.118-.138	16.86	MS9812-36	4.000	2.440-2.500	37.83
MS9812-09	1.312	.118-.138	17.34	MS9812-37	4.125	2.565-2.625	38.78
MS9812-10	1.375	.118-.138	17.82	MS9812-38	4.250	2.690-2.750	39.74
MS9812-11	1.438	.118-.138	18.29	MS9812-39	4.375	2.815-2.875	40.70
MS9812-12	1.500	.118-.138	18.77	MS9812-40	4.500	2.940-3.000	41.64
MS9812-13	1.562	.118-.138	19.24	MS9812-41	4.625	3.065-3.125	42.60
MS9812-14	1.625	.118-.138	19.72	MS9812-42	4.750	3.190-3.250	43.56
MS9812-15	1.688	.128-.188	20.20	MS9812-43	4.875	3.315-3.375	44.50
MS9812-16	1.750	.190-.250	20.68	MS9812-44	5.000	3.440-3.500	45.46
MS9812-17	1.812	.252-.312	21.16	MS9812-45	5.125	3.565-3.625	46.41
MS9812-18	1.875	.315-.375	21.62	MS9812-46	5.250	3.690-3.750	47.36
MS9812-19	1.938	.378-.438	22.10	MS9812-47	5.375	3.815-3.875	48.32
MS9812-20	2.000	.440-.500	22.58	MS9812-48	5.500	3.940-4.000	49.27
MS9812-21	2.125	.565-.625	23.54	MS9812-49	5.625	4.065-4.125	50.23
MS9812-22	2.250	.690-.750	24.49	MS9812-50	5.750	4.190-4.250	51.18
MS9812-23	2.375	.815-.875	25.44	MS9812-51	5.875	4.315-4.375	52.13
MS9812-24	2.500	.940-1.000	26.39	MS9812-52	6.000	4.440-4.500	53.09
MS9812-25	2.625	1.065-1.125	27.35				
MS9812-26	2.750	1.190-1.250	28.30				
MS9812-27	2.875	1.315-1.375	29.25				
MS9812-28	3.000	1.440-1.500	30.21				
MS9812-29	3.125	1.565-1.625	31.16				
MS9812-30	3.250	1.690-1.750	32.11				

- SHANK SHALL BE STRAIGHT WITHIN .002 TOTAL PER INCH OF BOLT LENGTH.
- THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
- THE CONCENTRICITY OF THE SHANK IN RELATION TO THE WASHER FACE DIAMETER AND HEXAGON SHALL BE WITHIN .028 FIR.
- INCOMPLETE THREADS NOT TO ENTER FILLET.
- MATERIAL: CORROSION RESISTANT STEEL 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 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.

ⓑ REINSTATED 31 OCT 84

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.	AS	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other	Cust		BOLT, MACHINE - HEXAGON HEAD,	
ⓑ	AV	ⓑ	PD SHANK, AMS 5643, .625-18 UNJF-3A	MS9812
99				
PROCUREMENT SPECIFICATION	SUPERSEDES:		PAGE	1 OF 1
NONE				

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5306-0884

APPROVED 11 MAR 70 REVISED 21 DEC 83 31 OCT 84