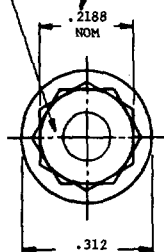


MARK PART NUMBER
AND MANUFACTURER'S IDENT
PER AS 478 CLASS A

- WRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE



ENT

G CONFIGURATION
70 FOR
TANCE

.111
MIN

5° MAX

.082
MAX DIA
HOLE
OPTIONAL

.015R
MAX

CHAMFER
28° - 32°
TO .219 DIA

.221

L

K

.030 MIN

.080
MIN

.020^R

.010^R

32

MAXIMUM 2
INCOMPLETE
THREADS
(SEE NOTE 4)

CHAMFER
.025 x 45°
APPROX

140°
MIN

.151
DIA

.141

.164-36 UNJF-3A
MIL-S-6879

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

35° MIN TO ROOT
OF DUBLE HEXAGON

32

CROSS SECTION

SECTION THRU
THREAD PROFILE

PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100
MS9884-02	.250	.062-.082	.425	MS9884-16	1.125	.487-.547	.840
MS9884-03	.312	.062-.082	.454	MS9884-17	1.188	.550-.610	.869
				MS9884-18	1.250	.612-.672	.900
MS9884-04	.375	.062-.082	.484	MS9884-19	1.312	.674-.734	.928
MS9884-05	.438	.062-.082	.515	MS9884-20	1.375	.737-.797	.957
MS9884-06	.500	.062-.082	.544	MS9884-21	1.438	.800-.860	.986
MS9884-07	.562	.062-.082	.573	MS9884-22	1.500	.862-.922	1.018
MS9884-08	.625	.062-.082	.603	MS9884-23	1.562	.924-.984	1.047
MS9884-09	.688	.062-.110	.634	MS9884-24	1.625	.987-1.047	1.077
MS9884-10	.750	.112-.172	.662	MS9884-25	1.688	1.050-1.110	1.104
MS9884-11	.812	.174-.234	.691	MS9884-26	1.750	1.112-1.172	1.135
MS9884-12	.875	.237-.297	.722	MS9884-27	1.812	1.174-1.234	1.167
MS9884-13	.938	.300-.360	.751	MS9884-28	1.875	1.237-1.297	1.196
MS9884-14	1.000	.362-.422	.780	MS9884-29	1.938	1.300-1.360	1.226
MS9884-15	1.062	.424-.484	.811	MS9884-30	2.000	1.362-1.422	1.254

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 DOUBLE HEXAGON OD SHALL BE WITHIN .005 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: CORROSION RESISTANT STEEL AMS 5616.
6. MANUFACTURING SPECIFICATION: AMS 7470 EXCEPT HEAD SHALL BE UPSET.
7. HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
8. HARDNESS: ROCKWELL C32-38.
9. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICRONCHES EXCEPT UPSET HEAD.
10. MAGNETIC PARTICLE INSPECTION PER AMS 2640.
11. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
13. 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 DIVISION.

P.A. USAF - 11 Other Cust Navy - AS	TITLE SCREW, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, AMS 5616, .164-36 UNJF-3A	MILITARY STANDARD
		MS9884 (ASG)
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 1 OF 1

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.

APPROVED 3 Mar 69 REVISED

DD FORM 672-1 (Limited coordination)
1 SEP 87
AGC use only

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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