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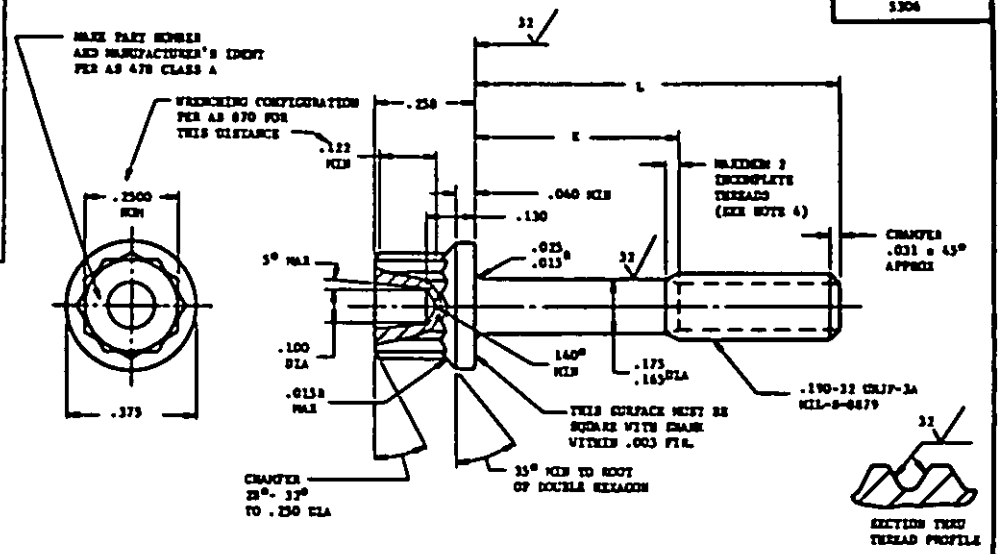
MS9885 (ASG)

FED. SUP CLASS 5306



PART NO.	L	K	APPROX. WEIGHT LB/100
MS9885-03	.312	.072- .092	.70
MS9885-04	.375	.072- .092	.74
MS9885-05	.438	.072- .092	.78
MS9885-06	.500	.072- .092	.82
MS9885-07	.562	.072- .092	.86
MS9885-08	.625	.072- .092	.90
MS9885-09	.688	.072- .092	.94
MS9885-10	.750	.072- .120	.98
MS9885-11	.812	.122- .182	1.02
MS9885-12	.875	.185- .245	1.06
MS9885-13	.938	.244- .308	1.10
MS9885-14	1.000	.310- .370	1.14
MS9885-15	1.062	.372- .432	1.18
MS9885-16	1.125	.433- .495	1.22
MS9885-17	1.188	.496- .558	1.26
MS9885-18	1.250	.560- .620	1.30
MS9885-19	1.312	.622- .682	1.34
MS9885-20	1.375	.685- .745	1.38
MS9885-21	1.438	.748- .808	1.43
MS9885-22	1.500	.810- .870	1.47
MS9885-23	1.562	.872- .932	1.50
MS9885-24	1.625	.935- .995	1.54
MS9885-25	1.688	.998-1.058	1.58
MS9885-26	1.750	1.060-1.120	1.62
MS9885-27	1.812	1.122-1.182	1.66
MS9885-28	1.875	1.185-1.245	1.70
MS9885-29	1.938	1.248-1.308	1.74
MS9885-30	2.000	1.310-1.370	1.78
MS9885-31	2.125	1.435-1.495	1.86
MS9885-32	2.250	1.560-1.620	1.94
MS9885-33	2.375	1.685-1.745	2.02
MS9885-34	2.500	1.810-1.870	2.11
MS9885-35	2.625	1.935-1.995	2.19
MS9885-36	2.750	2.060-2.120	2.27
MS9885-37	2.875	2.185-2.245	2.35
MS9885-38	3.000	2.310-2.370	2.44
MS9885-39	3.125	2.435-2.495	2.51
MS9885-40	3.250	2.560-2.620	2.58
MS9885-41	3.375	2.685-2.745	2.67
MS9885-42	3.500	2.810-2.870	2.75
MS9885-43	3.625	2.935-2.995	2.83
MS9885-44	3.750	3.060-3.120	2.91
MS9885-45	3.875	3.185-3.245	2.99

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 DOUBLE HEXAGON OD SHALL BE WITHIN .006 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 MICROINCHES EXCEPT UPSET HEAD.
10. MAGNETIC PARTICLE INSPECTION PER AMS 2640.
11. BREAK SHARP EDGES .003-.013 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± .010, ANGULAR DIMENSIONS ± 5°.
13. DO NOT USE UNASSIGNED PART NUMBERS.

AS 6 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.	TITLE	MILITARY STANDARD
CAF- 11 Other Cust Navy - AS	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, AMS 5616, .190-32 UNJF-3A	MS9885 (ASG)
PROCUREMENT SPECIFICATION	SUPERSEDES	SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)
ASD use only

Project No. 5306-F035

APPROVED 3 Mar 69 REVISED

Active activities: NAV - AS, 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 apply this standard where suitable.