

MS 9891 (ASG)				FED. SUP CLASS 5306							
<p>MARK PART NUMBER AND MANUFACTURER'S IDENT PER AS 478 CLASS A</p> <p>WRENCHING CONFIGURATION PER AS 870 FOR THIS DISTANCE</p> <p>MAXIMUM 2 INCOMPLETE THREADS (SEE NOTE 4)</p> <p>CHAMFER .0625 x 45° APPROX</p> <p>CHAMFER 28°-32° TO .625 DIA</p> <p>THIS SURFACE MUST BE SQUARE WITH SHANK WITHIN .003 FIR.</p> <p>35° MIN TO ROOT OF DOUBLE HEXAGON</p> <p>SECTION THRU THREAD PROFILE</p>				<p>Review activities: USAF - 82, 85</p> <p>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.</p>							
PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100
MS9891-04	.875	.113-.133	11.56	MS9891-22	2.000	.565-.625	18.58	MS9891-40	4.250	2.815-2.875	33.65
MS9891-05	.938	.113-.133	11.96	MS9891-23	2.125	.690-.750	19.32	MS9891-41	4.375	2.940-3.000	34.44
MS9891-06	1.000	.113-.133	12.34	MS9891-24	2.250	.815-.875	20.12	MS9891-42	4.500	3.065-3.125	35.23
MS9891-07	1.062	.113-.133	12.73	MS9891-25	2.375	.940-1.000	20.91	MS9891-43	4.625	3.190-3.250	36.02
MS9891-08	1.125	.113-.133	13.12	MS9891-26	2.500	1.065-1.125	21.68	MS9891-44	4.750	3.315-3.375	36.81
MS9891-09	1.188	.113-.133	13.49	MS9891-27	2.625	1.190-1.250	22.44	MS9891-45	4.875	3.440-3.500	37.60
MS9891-10	1.250	.113-.133	13.87	MS9891-28	2.750	1.315-1.375	23.13	MS9891-46	5.000	3.565-3.625	38.39
MS9891-11	1.312	.113-.133	14.26	MS9891-29	2.875	1.440-1.500	23.93	MS9891-47	5.125	3.690-3.750	39.18
MS9891-12	1.375	.113-.133	14.65	MS9891-30	3.000	1.565-1.625	24.76	MS9891-48	5.250	3.815-3.875	39.97
MS9891-13	1.438	.113-.133	15.04	MS9891-31	3.125	1.690-1.750	25.55	MS9891-49	5.375	3.940-4.000	40.76
MS9891-14	1.500	.113-.133	15.45	MS9891-32	3.250	1.815-1.875	26.34	MS9891-50	5.500	4.065-4.125	41.55
MS9891-15	1.562	.128-.188	15.84	MS9891-33	3.375	1.940-2.000	28.12	MS9891-51	5.625	4.190-4.250	42.34
MS9891-16	1.625	.190-.250	16.24	MS9891-34	3.500	2.065-2.125	28.91	MS9891-52	5.750	4.315-4.375	43.13
MS9891-17	1.688	.252-.312	16.63	MS9891-35	3.625	2.190-2.250	29.70	MS9891-53	5.875	4.440-4.500	43.92
MS9891-18	1.750	.315-.375	16.99	MS9891-36	3.750	2.315-2.375	30.49	MS9891-54	6.000	4.565-4.625	44.71
MS9891-19	1.812	.378-.438	17.40	MS9891-37	3.875	2.440-2.500	31.28				
MS9891-20	1.875	.440-.500	17.79	MS9891-38	4.000	2.565-2.625	32.07				
MS9891-21	1.938	.502-.562	18.20	MS9891-39	4.125	2.690-2.750	32.86				
<ol style="list-style-type: none"> SHANK SHALL BE STRAIGHT WITHIN .002 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 DOUBLE HEXAGON OD SHALL BE WITHIN .013 FIR. INCOMPLETE THREADS NOT TO ENTER FILLET. MATERIAL: CORROSION RESISTANT STEEL AMS 5616. MANUFACTURING SPECIFICATION: AMS 7470 EXCEPT HEAD SHALL BE UPSET. HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS. HARDNESS: ROCKWELL C32-38. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD. MAGNETIC PARTICLE INSPECTION PER AMS 2640. 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. 											
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<p>P.A. USAF - 11</p> <p>Other Com Navy - AS</p>				<p>TITLE</p> <p>BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, AMS 5616, .5625-18 UNJF-3A</p>				<p>MILITARY STANDARD</p> <p>MS 9891 (ASG)</p>			
<p>PROCUREMENT SPECIFICATION</p>				<p>SUPERSEDES:</p>				<p>SHEET 1 OF 1</p>			