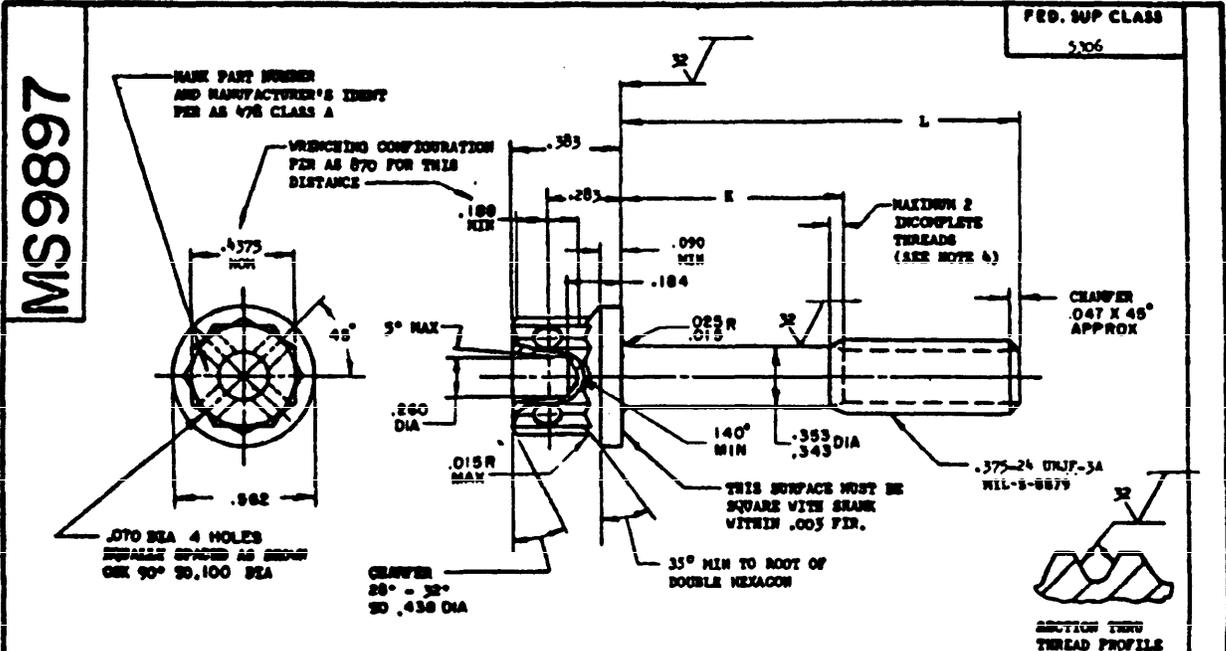


7:55 6



PART NO.	L	K	APPROX WEIGHT LB/100	PART NO.	L	K	APPROX WEIGHT LB/100	PART NO.	L	K	APPROX WEIGHT LB/100
MS9897-03	.742	.084-.108	3.37	MS9897-24	1.875	.815-.875	6.94	MS9897-44	4.290	3.190-3.250	13.40
MS9897-04	.625	.068-.108	3.54	MS9897-25	1.750	.878-.938	7.11	MS9897-45	4.375	3.315-3.375	15.74
MS9897-05	.688	.068-.108	3.71	MS9897-26	2.000	.940-1.000	7.28	MS9897-46	4.500	3.440-3.500	14.08
MS9897-06	.750	.068-.108	3.88	MS9897-27	2.125	1.065-1.125	7.62	MS9897-47	4.625	3.565-3.625	14.42
MS9897-07	.812	.068-.108	4.05	MS9897-28	2.250	1.190-1.250	7.96	MS9897-48	4.750	3.690-3.750	14.76
MS9897-08	.875	.068-.108	4.22	MS9897-29	2.375	1.315-1.375	8.30	MS9897-49	4.875	3.815-3.875	15.10
MS9897-09	.938	.068-.108	4.39	MS9897-30	2.500	1.440-1.500	8.64	MS9897-50	5.000	3.940-4.000	15.44
MS9897-10	1.000	.068-.108	4.56	MS9897-31	2.625	1.565-1.625	8.98	MS9897-51	5.125	4.065-4.125	15.78
MS9897-11	1.062	.068-.108	4.73	MS9897-32	2.750	1.690-1.750	9.32	MS9897-52	5.250	4.190-4.250	16.12
MS9897-12	1.125	.068-.125	4.90	MS9897-33	2.875	1.815-1.875	9.66	MS9897-53	5.375	4.315-4.375	16.46
MS9897-13	1.188	.128-.188	5.07	MS9897-34	3.000	1.940-2.000	10.00	MS9897-54	5.500	4.440-4.500	16.80
MS9897-14	1.250	.190-.250	5.24	MS9897-35	3.125	2.065-2.125	10.34	MS9897-55	5.625	4.565-4.625	16.14
MS9897-15	1.312	.252-.312	5.41	MS9897-36	3.250	2.190-2.250	10.68	MS9897-56	5.750	4.690-4.750	17.48
MS9897-16	1.375	.315-.375	5.58	MS9897-37	3.375	2.315-2.375	11.02	MS9897-57	5.875	4.815-4.875	17.14
MS9897-17	1.438	.378-.438	5.75	MS9897-38	3.500	2.440-2.500	11.36	MS9897-58	6.000	4.940-5.000	18.16
MS9897-18	1.500	.440-.500	5.92	MS9897-39	3.625	2.565-2.625	11.70				
MS9897-19	1.562	.502-.562	6.10	MS9897-40	3.750	2.690-2.750	12.04				
MS9897-20	1.625	.565-.625	6.26	MS9897-41	3.875	2.815-2.875	12.38				
MS9897-21	1.688	.628-.688	6.43	MS9897-42	4.000	2.940-3.000	12.72				
MS9897-22	1.750	.690-.750	6.60	MS9897-43	4.125	3.065-3.125	13.06				
MS9897-23	1.812	.752-.812	6.77								

Review activities MAY - 08, 05

This military standard is approved by the Department of the Air Force and the Navy, Air Systems Command and is mandatory for use by those activities. All other military activities are required to employ this standard where applicable.

1. SHANK SHALL BE STRAIGHT WITHIN .0025 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 GD SHALL BE WITHIN .009 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-.015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS 3.010, ANGULAR DIMENSIONS 3°.
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 AIR AEROSPACE PROPULSION DIVISION.

P.A. USAF - 11	TITLE	MILITARY STANDARD
Other Cost	BOLT, MACHINE-DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, AMS 5616, .375-24 UNJF-3A	MS9897
Navy - AS		
PROCUREMENT SPECIFICATION	SUPERSEDES	SHEET 1 OF 1

APPROVED 21 Apr 67 REVISED