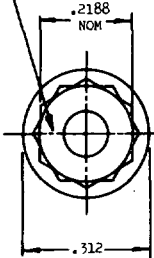


FED. SUP CLASS

5305

MS9931MARK PART NUMBER
AND MANUFACTURER'S IDENT
PER AS 478 CLASS AWRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE

5° MAX

.082
MAX DIA HOLE
OPTIONAL.015R
MAX

32

.221

.030
MIN.112
MIN.080
MIN.020
.010

32

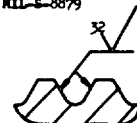
K

G

MIN 1 PITCH
INCOMPLETE
THREADCHAMFER .025
x 45° ± 10°140°
MIN

.162 DIA

.160

.164-36 UNJF-3A
MIL-6-8879THIS SURFACE MUST BE
SQUARE WITH SHANK
WITHIN .003 FIR.35° MIN TO ROOT
OF DOUBLE HEXAGONCHAMFER
28° - 32°
TO .219 DIASECTION THRU
THREAD PROFILE

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9931-10	.750	.052	.172	.672
MS9931-11	.812	.114	.234	.708
MS9931-12	.875	.177	.297	.746
MS9931-13	.938	.240	.360	.783
MS9931-14	1.000	.302	.422	.821
MS9931-15	1.062	.364	.484	.858
MS9931-16	1.125	.427	.547	.895
MS9931-17	1.188	.490	.610	.933
MS9931-18	1.250	.542	.672	.970
MS9931-19	1.312	.614	.734	1.008
MS9931-20	1.375	.677	.797	1.045
MS9931-21	1.438	.740	.860	1.082
MS9931-22	1.500	.802	.922	1.120

PART NO.	L	G MIN	K MAX	APPROX WEIGHT LB/100
MS9931-23	1.562	.864	.984	1.157
MS9931-24	1.625	.927	1.047	1.195
MS9931-25	1.688	.990	1.110	1.232
MS9931-26	1.750	1.052	1.172	1.269
MS9931-27	1.812	1.114	1.234	1.307
MS9931-28	1.875	1.177	1.297	1.344
MS9931-29	1.938	1.240	1.360	1.382
MS9931-30	2.000	1.302	1.422	1.419

- SHANK SHALL BE STRAIGHT WITHIN .003 TOTAL PER INCH OF SCREW 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 SHALL BE WITHIN .005 FIR.
- MATERIAL: STEEL AMS 6322.
- HARDNESS: ROCKWELL C26-32.
- FINISH: CADMIUM PLATE AMS 2400. DIMENSIONS SPECIFIED ARE AFTER PLATING.
- MANUFACTURING SPECIFICATION: AMS 7452 EXCEPT HEAD SHALL BE UPSET.
- HEAD TO SHANK FILLET SHALL BE COLD WORKED.
- MAGNETIC PARTICLE INSPECTION PER AMS 2640 AFTER PLATING.
- 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 ±.010, ANGULAR DIMENSIONS ±5°.
- 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.
AIR FORCE - 11
Other Cost
NAVY - ASTITLE
SCREW, MACHINE - DOUBLE HEXAGON EXTENDED
WASHER HEAD, FULL SHANK, STEEL AMS 6322,
CADMIUM PLATED, .164-36 UNJF-3A

MILITARY STANDARD

MS9931PROCUREMENT SPECIFICATION
AMS-7452

SUPERSEDES:

SHEET 1 OF 1

This military standard is approved by the Department of the Air Force and the Bureau of Naval Weapons and is mandatory for use by those activities. All other military activities are required to employ this standard where applicable.

User activities:
Navy - MC, CGReview activities:
Air Force - 82
Navy - AS

APPROVED 30 Dec 70 REVISED

DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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