

SAE Executive Standards Committee Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

REV.
D

AS91111™

FEDERAL SUPPLY CLASS
5306

RATIONALE

REVISE LEAD THREAD CHAMFER TO AS1132, REVISE MAJOR DIA RUNOUT TO A POSITION REQUIREMENT (ADD DATUM U) PER AS1132, UPDATE TO ASME Y14.5-2018, GENERAL EDITORIAL UPDATES.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9111, NOTICE 1. THIS SAE STANDARD RETAINS THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

ANY REQUIREMENTS ASSOCIATED WITH QUALIFIED PRODUCTS LISTS (QPL'S) MAY CONTINUE TO BE MANDATORY FOR DoD CONTRACTS. REQUIREMENTS RELATING TO QPL'S HAVE NOT BEEN ADOPTED BY THE SAE FOR THIS STANDARD AND ARE NOT PART OF THIS SAE DOCUMENT.

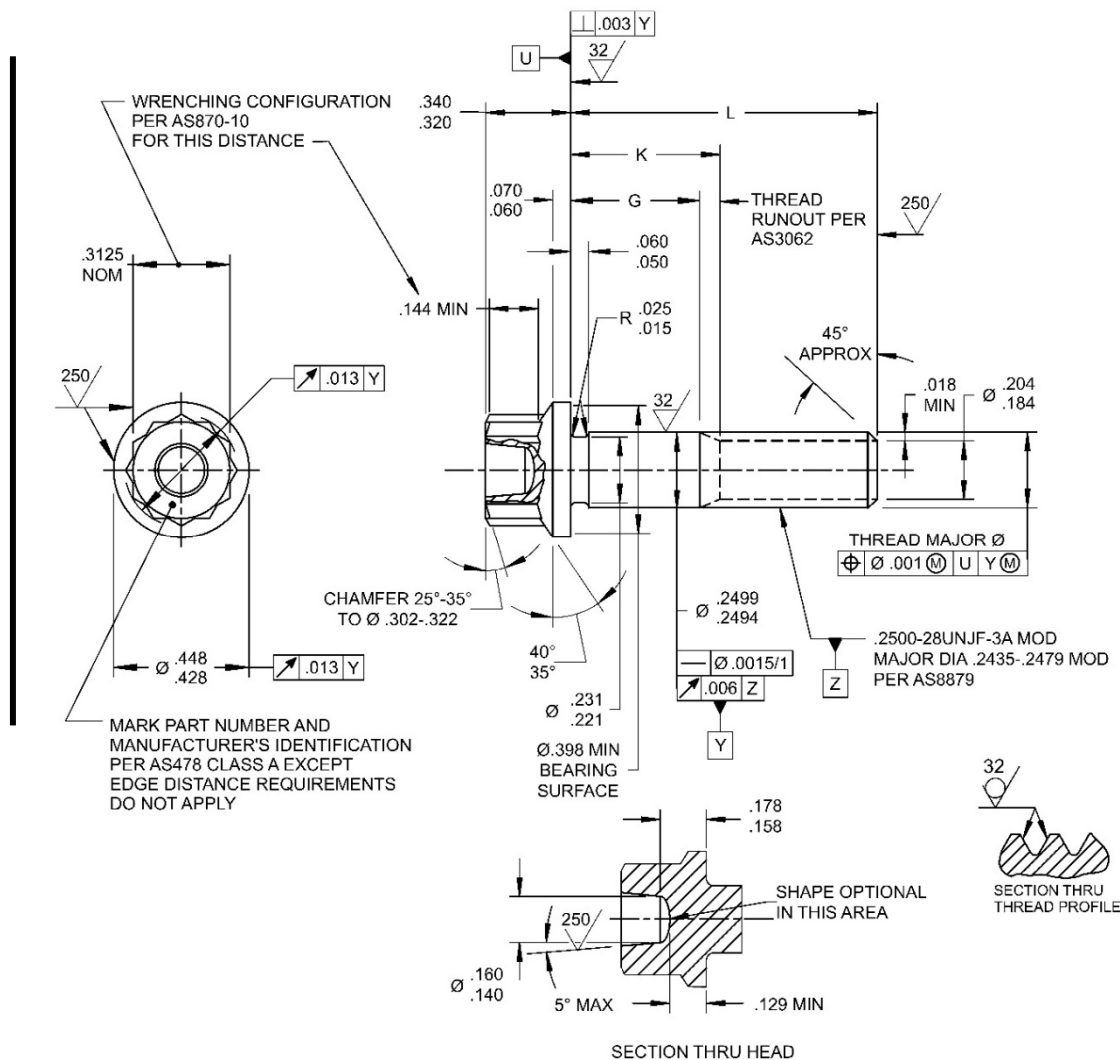


FIGURE 1 - BOLT

For more information on this standard, visit
<https://www.sae.org/standards/content/AS91111D/>

CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7477



AEROSPACE STANDARD

BOLT, MACHINE - DOUBLE HEXAGON EXTENDED
WASHER HEAD, CLOSE TOLERANCE SHANK
UNS S66286, 130 KSI MIN, .2500-28 UNJF-3A

AS91111™
SHEET 1 OF 2

REV.
D

Documents

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	G GRIP	L LENGTH	K MAX	APPROX MASS LB/100	PART NO.	G GRIP	L LENGTH	K MAX	APPROX MASS LB/100
MS9111-01	.115-.135	.552-.572	.206	1.51	MS9111-16	.865-.885	1.490-1.510	.956	2.78
MS9111-02	.115-.135	.615-.635	.206	1.58	MS9111-17	.928-.948	1.552-1.572	1.019	2.87
MS9111-03	.115-.135	.678-.698	.206	1.66	MS9111-18	.990-1.010	1.615-1.635	1.081	2.96
MS9111-04	.115-.135	.740-.760	.206	1.73	MS9111-19	1.115-1.135	1.740-1.760	1.206	3.13
MS9111-05	.178-.198	.802-.822	.269	1.82	MS9111-20	1.240-1.260	1.865-1.885	1.331	3.31
MS9111-06	.240-.260	.865-.885	.331	1.90	MS9111-21	1.365-1.385	1.990-2.010	1.456	3.48
MS9111-07	.302-.322	.928-.948	.393	1.99	MS9111-22	1.490-1.510	2.115-2.135	1.581	3.66
MS9111-08	.365-.385	.990-1.010	.456	2.08	MS9111-23	1.615-1.635	2.240-2.260	1.706	3.84
MS9111-09	.428-.448	1.052-1.072	.519	2.17	MS9111-24	1.740-1.760	2.365-2.385	1.831	4.01
MS9111-10	.490-.510	1.115-1.135	.581	2.26	MS9111-25	1.865-1.885	2.490-2.510	1.956	4.19
MS9111-11	.552-.572	1.178-1.198	.643	2.34	MS9111-26	1.990-2.010	2.615-2.635	2.081	4.36
MS9111-12	.615-.635	1.240-1.260	.706	2.43	MS9111-27	2.115-2.135	2.740-2.760	2.206	4.54
MS9111-13	.678-.698	1.302-1.322	.769	2.52	MS9111-28	2.240-2.260	2.865-2.885	2.331	4.71
MS9111-14	.740-.760	1.365-1.385	.831	2.61	MS9111-29	2.365-2.385	2.990-3.010	2.456	4.89
MS9111-15	.802-.822	1.428-1.448	.893	2.69					

NOTES:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS5731 (COMPOSITION SIMILAR TO UNS S66286).
2. PROCUREMENT SPECIFICATION: AS7477.
3. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
4. FLUORESCENT PENETRANT INSPECTION PER ASTM E1417/E1417M, TYPE 1, SENSITIVITY LEVEL 2 MINIMUM.
5. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
6. DIMENSIONING AND TOLERANCING PER ASME Y14.5-2018.
7. DIMENSIONS ARE IN INCHES.
8. UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
9. DO NOT USE UNASSIGNED PART NUMBERS.
10. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

AS AND AMS ARE SAE INTERNATIONAL PUBLICATIONS.
ASME IS AN AMERICAN SOCIETY OF MECHANICAL ENGINEERS PUBLICATION.
ASTM IS AN ASTM INTERNATIONAL PUBLICATION.

	AEROSPACE STANDARD	AS91111™ SHEET 2 OF 2	REV. D
	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, CLOSE TOLERANCE SHANK UNS S66286, 130 KSI MIN, .2500-28 UNJF-3A		