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REV.
A

AS9631™

RATIONALE

DELETE HARDNESS REQUIREMENT, REVISE GEOMETRIC AND TOLERANCING REQUIREMENTS TO ANSI Y14.5M, REVISE THREAD TO AS8879, ADD AS3062 FOR INCOMPLETE THREAD DEFINITION, REVISE LEAD CHAMFER REQUIREMENTS, ADD SUBSTITUTE DATUM FOR SHORT SHANK LENGTHS, REVISE FPI CALLOUT, ADD SURFACE TEXTURE REQUIREMENTS TO BOLT HEAD AND LEAD END, ADD NEW NOTE FOR DISPOSITION OF EXISTING INVENTORY, GENERAL EDITORIAL UPDATES.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9631B. THIS SAE STANDARD MAY RETAIN THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

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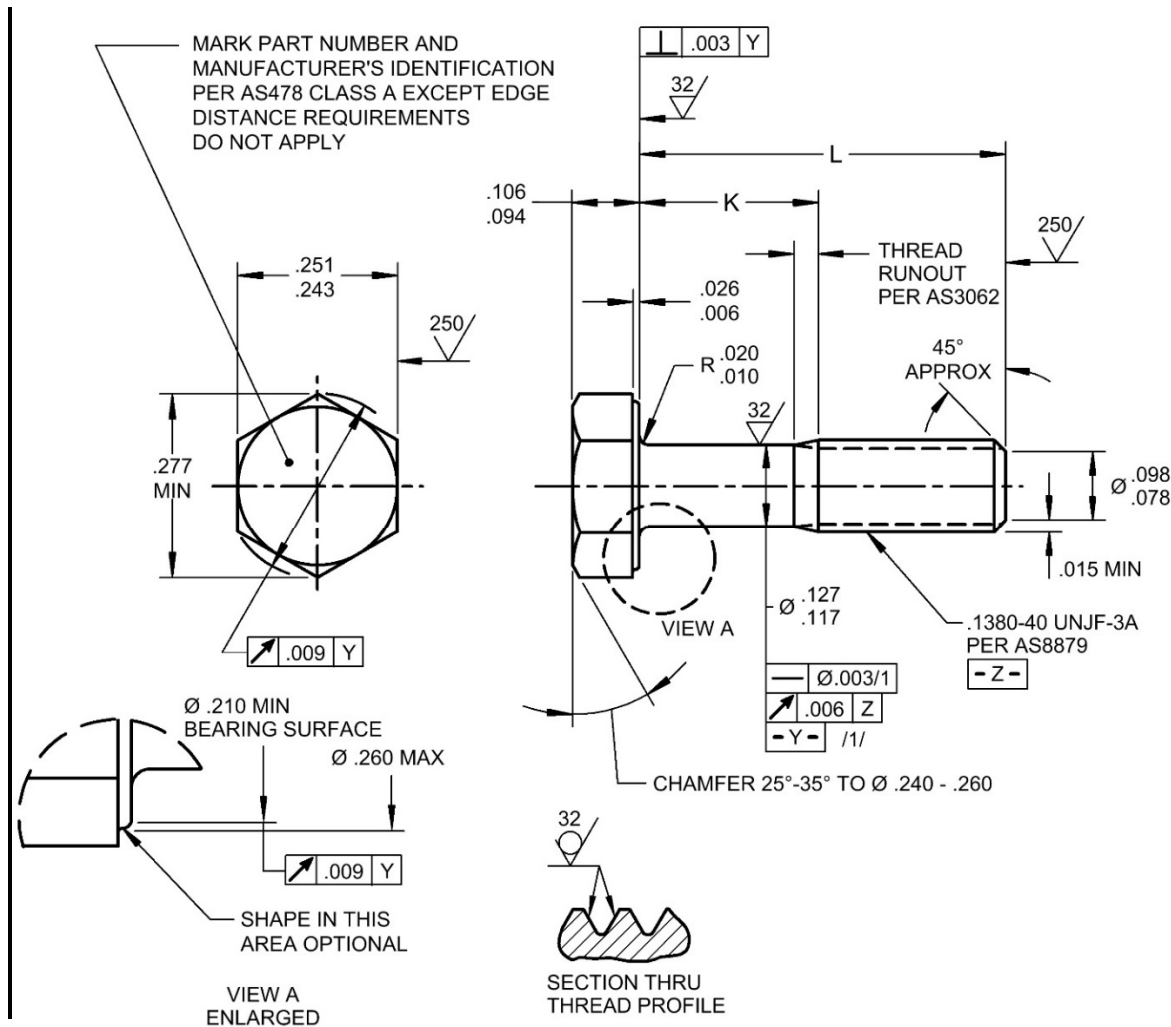
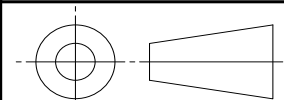


FIGURE 1 - SCREW

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THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7461



AEROSPACE STANDARD

SCREW, MACHINE - HEXAGON HEAD,
PD SHANK, TITANIUM AMS4967 (UNS R56400),
.1380-40 UNJF-3A

AS9631™
SHEET 1 OF 2

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Documents

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TABLE 1 - PART NUMBERS, DIMENSIONS L AND K, AND APPROXIMATE MASS

PART NUMBER	L	K	APPROX MASS LB/100	PART NUMBER	L	K	APPROX MASS LB/100
MS9631-02	.240- .260	.058-.078	.15	MS9631-16	1.115-1.135	.539- .599	.32
MS9631-03	.302- .322	.058-.078	.16	MS9631-17	1.178-1.198	.602- .662	.33
MS9631-04	.365- .385	.058-.078	.18	MS9631-18	1.240-1.260	.664- .724	.35
MS9631-05	.428- .448	.058-.078	.19	MS9631-19	1.302-1.322	.726- .786	.36
				MS9631-20	1.365-1.385	.789- .849	.38
MS9631-06	.490- .510	.058-.078	.20	MS9631-21	1.428-1.448	.852- .912	.39
MS9631-07	.552- .572	.058-.078	.21	MS9631-22	1.490-1.510	.914- .974	.40
MS9631-08	.615- .635	.058-.099	.22	MS9631-23	1.552-1.572	.976-1.036	.41
MS9631-09	.678- .698	.102-.162	.24	MS9631-24	1.615-1.635	1.039-1.099	.42
MS9631-10	.740- .760	.164-.224	.25	MS9631-25	1.678-1.698	1.102-1.162	.44
MS9631-11	.802- .822	.226-.286	.26	MS9631-26	1.740-1.760	1.164-1.224	.45
MS9631-12	.865- .885	.289-.349	.27	MS9631-27	1.802-1.822	1.226-1.286	.46
MS9631-13	.928- .948	.352-.412	.28	MS9631-28	1.865-1.885	1.289-1.349	.47
MS9631-14	.990-1.010	.414-.474	.30	MS9631-29	1.928-1.948	1.352-1.412	.48
MS9631-15	1.052-1.072	.476-.536	.31	MS9631-30	1.990-2.010	1.414-1.474	.50

NOTES:

- /1/ FOR PART NUMBERS MS9631-03 THRU MS9631-21, DATUM Z (THREAD PD) SHALL REPLACE DATUM Y.
2. MATERIAL: TITANIUM AMS4967 (UNS R56400).
3. PROCUREMENT SPECIFICATION: AS7461.
4. FLUORESCENT PENETRANT INSPECTION IN ACCORDANCE WITH ASTM E1417/E1417M BEFORE PLATING, TYPE 1, SENSITIVITY LEVEL 2 MIN.
5. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra, EXCEPT UPSET HEAD.
6. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
7. DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M-1982 (ASME PUBLICATION).
8. DIMENSIONS ARE IN INCHES.
9. DO NOT USE UNASSIGNED PART NUMBERS.
10. UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
11. 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.

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ASME IS AN AMERICAN SOCIETY OF MECHANICAL ENGINEERS PUBLICATION.
ASTM IS AN ASTM INTERNATIONAL PUBLICATION.

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	SCREW, MACHINE - HEXAGON HEAD, PD SHANK, TITANIUM AMS4967 (UNS R56400), .1380-40 UNJF-3A			



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