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REV.
C

AS9685™

RATIONALE

FIGURE REDRAWN TO ASME Y14.5-2018, LEAD CHAMFERS TO ASII32, SPECS UPDATED.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS9685, NOTICE 1. THIS SAE STANDARD MAY RETAIN 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.

FEDERAL SUPPLY CLASS
5306

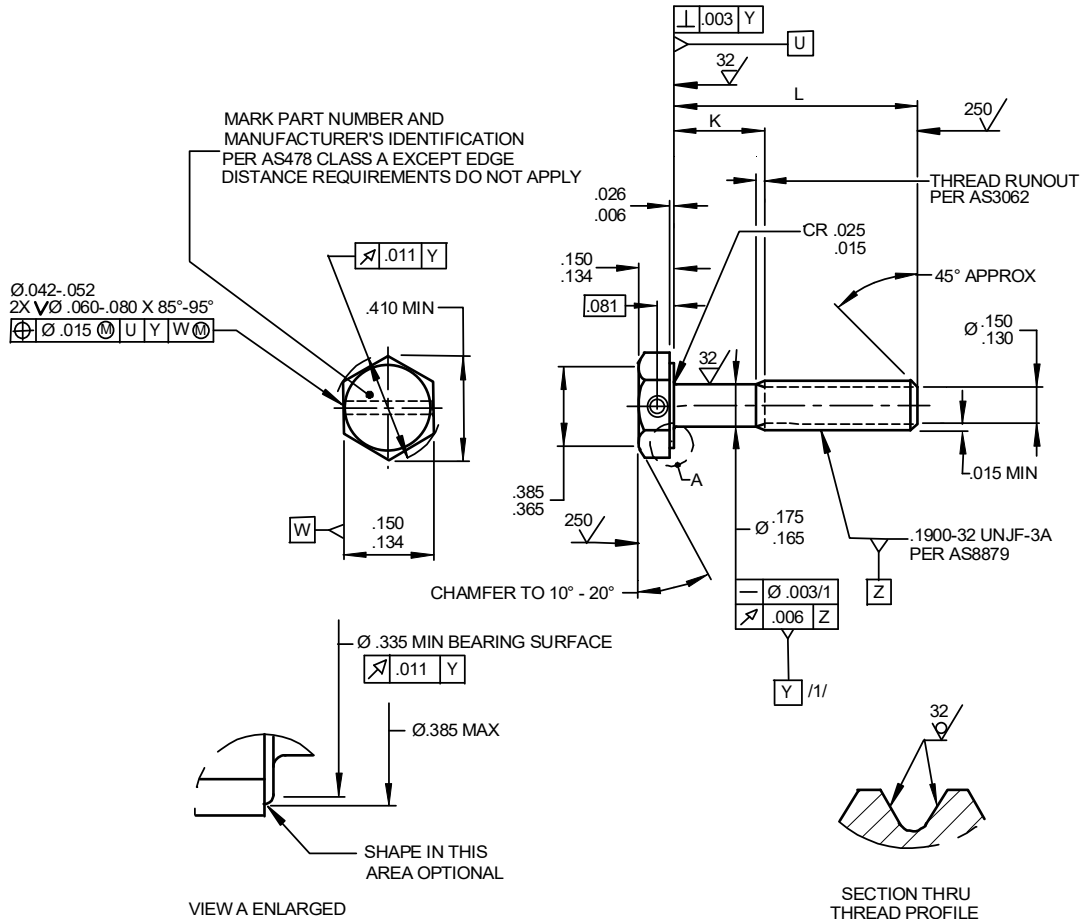
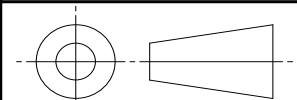


FIGURE 1 - BOLT

For more information on this standard, visit
<https://www.sae.org/standards/content/AS9685C/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7459



AEROSPACE STANDARD

BOLT, MACHINE - HEXAGON HEAD, DRILLED, 1 HOLE,
PD SHANK, STEEL, UNS K14675, DIFFUSED
NICKEL-CADMIUM PLATE, 195 KSI MIN, .1900-32 UNJF-3A

AS9685™
SHEET 1 OF 2

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Documents

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	K	APPROX MASS LB/100	PART NO.	L	K	APPROX MASS LB/100
MS9685-03	.302 - .322	.072 - .092	.70	MS9685-25	1.678 - 1.698	.998 - 1.058	1.58
MS9685-04	.365 - .385	.072 - .092	.74	MS9685-26	1.740 - 1.760	1.060 - 1.120	1.62
MS9685-05	.428 - .448	.072 - .092	.78	MS9685-27	1.802 - 1.822	1.122 - 1.182	1.66
MS9685-06	.490 - .510	.072 - .092	.82	MS9685-28	1.865 - 1.885	1.185 - 1.245	1.70
MS9685-07	.552 - .572	.072 - .092	.86	MS9685-29	1.928 - 1.948	1.248 - 1.308	1.74
MS9685-08	.615 - .635	.072 - .092	.90	MS9685-30	1.990 - 2.010	1.310 - 1.370	1.78
MS9685-09	.678 - .698	.072 - .092	.94	MS9685-31	2.115 - 2.135	1.435 - 1.495	1.86
MS9685-10	.740 - .760	.072 - .120	.98	MS9685-32	2.240 - 2.260	1.560 - 1.620	1.94
MS9685-11	.802 - .822	.122 - .182	1.02	MS9685-33	2.365 - 2.385	1.685 - 1.745	2.02
MS9685-12	.865 - .885	.185 - .245	1.06	MS9685-34	2.490 - 2.510	1.810 - 1.870	2.10
MS9685-13	.928 - .948	.248 - .308	1.10	MS9685-35	2.615 - 2.635	1.935 - 1.995	2.18
MS9685-14	.990 - 1.010	.310 - .370	1.15	MS9685-36	2.740 - 2.760	2.060 - 2.120	2.26
MS9685-15	1.052 - 1.072	.372 - .432	1.19	MS9685-37	2.865 - 2.885	2.185 - 2.245	2.34
MS9685-16	1.115 - 1.135	.435 - .495	1.23	MS9685-38	2.990 - 3.010	2.310 - 2.370	2.42
MS9685-17	1.178 - 1.198	.498 - .558	1.27	MS9685-39	3.115 - 3.135	2.435 - 2.495	2.50
MS9685-18	1.240 - 1.260	.560 - .620	1.31	MS9685-40	3.240 - 3.260	2.560 - 2.620	2.58
MS9685-19	1.302 - 1.322	.622 - .682	1.35	MS9685-41	3.365 - 3.385	2.685 - 2.745	2.66
MS9685-20	1.365 - 1.385	.685 - .745	1.38	MS9685-42	3.490 - 3.510	2.810 - 2.870	2.74
MS9685-21	1.428 - 1.448	.748 - .808	1.42	MS9685-43	3.615 - 3.635	2.935 - 2.995	2.82
MS9685-22	1.490 - 1.510	.810 - .870	1.46	MS9685-44	3.740 - 3.760	3.060 - 3.120	2.90
MS9685-23	1.552 - 1.572	.872 - .932	1.50	MS9685-45	3.865 - 3.885	3.185 - 3.245	2.98
MS9685-24	1.615 - 1.635	.935 - .995	1.54				

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/1/ FOR PART NUMBERS MS9685-03 THROUGH MS9685-14, DATUM **Z** SHALL REPLACE DATUM **Y**.

2. MATERIAL: LOW ALLOY STEEL AMS6304 (COMPOSITION SIMILAR TO UNS K14675).
3. PROCUREMENT SPECIFICATION: AS7459.
4. FINISH: DIFFUSED NICKEL-CADMIUM PLATE AMS2416. DIMENSIONS APPLY AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
5. MAGNETIC PARTICLE INSPECTION PER ASTM E1444/E1444M BEFORE PLATING.
6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
7. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
8. DIMENSIONING AND TOLERANCING PER ASME Y14.5-2018.
9. DIMENSIONS ARE IN INCHES.
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. DO NOT USE UNASSIGNED PART NUMBERS.
12. 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		AS9685™ SHEET 2 OF 2	REV. C
	BOLT, MACHINE - HEXAGON HEAD, DRILLED, 1 HOLE, PD SHANK, STEEL, UNS K14675, DIFFUSED NICKEL-CADMIUM PLATE, 195 KSI MIN, .1900-32 UNJF-3A			



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