

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NUMBER NICKEL-CADMIUM PLATE /4/	PART NUMBER ZINC-NICKEL PLATE /4/	L	K	APPROX MASS LB/100
MS9317-02	MS9317-02QX	.490- .510	/a/	1.50
MS9317-03	MS9317-03QX	.552- .572	/a/	1.68
MS9317-04	MS9317-04QX	.615- .635	/a/	1.87
MS9317-05	MS9317-05QX	.678- .698	/a/	2.06
MS9317-06	MS9317-06QX	.740- .760	/a/	2.25
MS9317-07	MS9317-07QX	.802- .822	/a/	2.44
MS9317-08	MS9317-08QX	.865- .885	.065-.125	2.62
MS9317-09	MS9317-09QX	.928- .948	.128-.188	2.81
MS9317-10	MS9317-10QX	.990-1.010	.190-.250	3.00
MS9317-12	MS9317-12QX	1.115-1.135	.315-.375	3.37
MS9317-14	MS9317-14QX	1.240-1.260	.440- .500	3.75
MS9317-16	MS9317-16QX	1.365-1.385	.565- .625	4.12
MS9317-18	MS9317-18QX	1.490-1.510	.690- .750	4.50

/a/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

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 /14/.

/1/ FOR PARTS NUMBERS MS9317-02 THRU MS9317-12, DATUM **Z** (THREAD PD) SHALL REPLACE DATUM **Y**.

2. MATERIAL: LOW ALLOY STEEL PER AMS6304 (COMPOSITION SIMILAR TO UNS K14675).

3. PROCUREMENT SPECIFICATION: AS7454.

/4/ FINISH:

- NO FINISH CODE LETTER: DIFFUSED NICKEL-CADMIUM PLATE PER AMS2416. DIMENSIONS ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.
- FINISH CODE LETTER QX: ZINC-NICKEL PLATE PER MIL-PRF-32647, TYPE K16. DIMENSIONS ARE AFTER PLATING. CONTACT POINTS PERMISSIBLE. PD MAY BE REDUCED .0012 MAXIMUM BEFORE PLATING.

5. MAGNETIC PARTICLE INSPECTION PER ASTM E1444/E1444M AFTER PLATING.

/6/ ACCEPTABILITY OF SCREW THREADS SHALL BE DETERMINED BASED ON ASME B1.3M, SYSTEM 22.

7. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.

/8/ FOR PARTS MANUFACTURED PRIOR TO ISSUE OF AS9317 REV. A, PARTS MARKED ONLY WITH THE MATERIAL CODE "E37" ARE ACCEPTABLE.

9. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

10. DIMENSIONS ARE IN INCHES.

11. DIMENSIONING AND TOLERANCING PER ASME Y14.5-2018.

12. DO NOT USE UNASSIGNED PART NUMBERS.

13. UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

/14/ CADMIUM IS AN R1, R2, AND D1 SUBSTANCE IN THE AEROSPACE AND DEFENSE DECLARABLE SUBSTANCE LIST. ZINC-NICKEL PLATE PER MIL-PRF-32647, TYPE K16 IS THE PREFERRED METHOD. ADD "QX" AT THE END OF THE PART NUMBER TO DESIGNATE ZINC-NICKEL PLATING.

	AEROSPACE STANDARD	AS9317™ SHEET 2 OF 3	REV. E
	SCREW, MACHINE - HEXAGON HEAD, SLOTTED, FULL SHANK, ALLOY STEEL, UNS K14675, 135 KSI MIN, .2500-28 UNS-3A		