



PROPRIETARY INFORMATION
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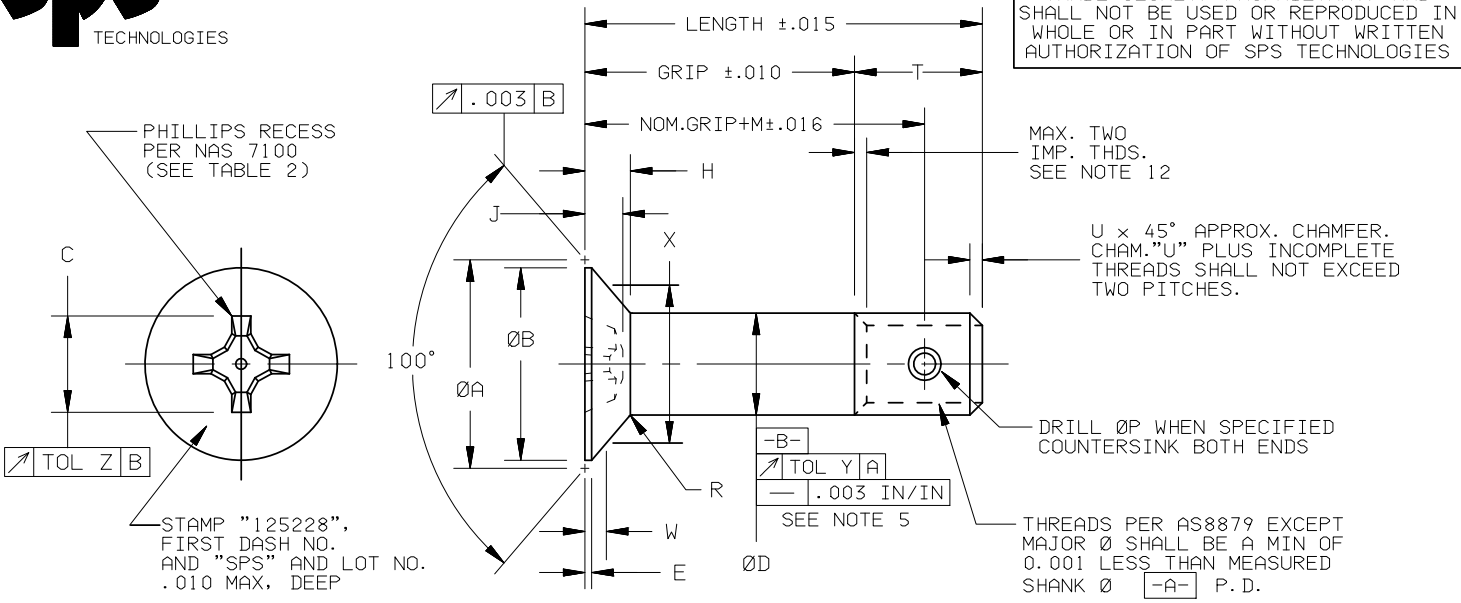


TABLE 1

FIRST DASH NO.	THREAD SIZE UNJF-3A	A MAX. DIA.	B ABS MIN. DIA.	D DIA.	E MAX.	H REF.	M	P DIA.	R RAD.	T REF.	U REF.	W HEAD PROT.	X GAGE DIA.	Y	Z
-3	.1900-32	.303	.266	.1894 .1885	.012	.049	-	-	.020 .010	.267	.04	.0243 .2438	.2440 .2438	.0045	.016
-4	.2500-28	.397	.355	.2492 .2483	.014	.063	.210	.076	.020 .010	.329	.04	.0270 .0240	.3314 .3312	.0045	.016
-5	.3125-24	.477	.429	.3117 .3108	.016	.071	.274	.076	.025 .010	.393	.05	.0297 .0263	.4047 .4045	.0045	.024
-6	.3750-24	.564	.510	.3742 .3733	.018	.081	.307	.106	.030 .015	.442	.05	.0324 .0286	.4854 .4852	.0045	.024
-7	.4375-20	.672	.612	.4367 .4358	.020	.101	.391	.106	.030 .015	.516	.06	.0421 .0379	.5698 .5696	.006	.024
-8	.5000-20	.755	.688	.4991 .4982	.022	.109	.426	.106	.030 .015	.566	.06	.0431 .0385	.6500 .6498	.006	.024
-9	.5625-18	.838	.766	.5616 .5607	.024	.119	.527	.141	.030 .015	.646	.07	.0488 .0438	.7200 .7198	.006	.024
-10	.6250-18	.925	.848	.6240 .6230	.026	.129	.569	.141	.030 .015	.688	.07	.0427 .0373	.8214 .8212	.006	.024

TABLE 2

FIRST DASH NO.	RECESS NO.	C MAX.	J MAX.
-3	2	.169	.101
-4	2	.184	.116
-5	3	.247	.135
-6	4	.317	.168
-7	4	.342	.193
-8	4	.366	.218
-9	4	.393	.245
-10	4	.424	.276

TABLE 3

'X' CODE ONLY-1/64 O'SIZE		
FIRST DASH NO.	H REF.	D DIAMETER
-3	.0425	.2050 .2041
-4	.0565	.2648 .2639
-5	.0645	.3273 .3264
-6	.0745	.3898 .3889
-7	.0945	.4523 .4514
-8	.1025	.5147 .5138
-9	.1125	.5772 .5763
-10	.1225	.6396 .6386

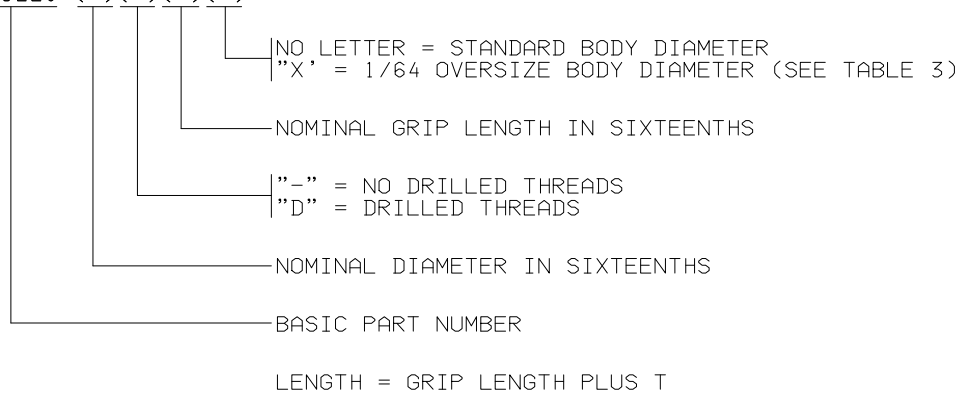
TOLERANCES ±.010 AND ±2° SURFACE ROUGHNESS 125√ UNLESS OTHERWISE NOTED	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	TITLE 100° REDUCED FLUSH HEAD BOLT, ALLOY 718 MATERIAL, 132 KSI SHEAR	STANDARDS AND SPECIFICATIONS SPS-B-640, APP 3.13.1 EXCEPT NOTE 4
DRAFTED IN ACCORDANCE WITH ANSI Y14.5M-1982 DRAWN BY:G.K. DATE:10/30/90 APPROVED:S FOSTER DATE: 4/9/09 APPROVED:L KLINE		PART NUMBER: 125228-() () () ()	SHEET 1 OF 2

DRAWING NUMBER SD. 300. 125228
 ISSUE DATE 10/30/90
 REVISION (3) 5/12/97 REVISED AND REDRAWN (4) 2/5/98 (5) 2/19/09



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REVISION
 (3) 5/12/97 REVISED AND REDRAWN
 (4) 2/5/98
 (5) 2/19/09

1. MATERIAL: ALLOY 718 TO THE CHEMISTRY OF AMS 5662.
2. HEAT TREATMENT: 220,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH, 132,000 PSI MINIMUM SHEAR STRENGTH.
3. FINISH: PASSIVATE PER ASTM A967 OR EQUIVALENT.
4. TENSILE AND FATIGUE REQUIREMENTS SHALL NOT APPLY DUE TO REDUCED HEAD DESIGN.
5. WHEN HELD ON THE PITCH DIAMETER OF FULL THREADS CLOSEST TO BODY AND CHECKED AT A POINT ON THE BODY WITHIN ONE DIAMETER DISTANCE FROM THE THREAD END OF THE GRIP.
6. REQUIREMENTS: HEAD TO BE FORGED.
 THREADS TO BE ROLLED AFTER HEAT TREATMENT
 HEAD TO SHANK FILLET TO BE COLD WORKED.
7. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT AN INSPECTION REQ'MT.
8. DIMENSIONS IN INCHES.
9. DEBURR AND BREAK ALL SHARP EDGES.
10. PART NUMBER: 125228-() () () ()



11. DIMENSIONS A, E, AND H ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION. VALUES A, E, AND H ARE CALCULATED LIMITS RESULTING FROM TOLERANCE ON B, D, W, X, AND THE HEAD ANGLE.
12. FOR "X" CODE - 1/64 OVERSIZE PART, MAX THREAD RUNOUT TO BE 3 IMP. THREADS.

TOLERANCES ±.010 AND ±2°
 SURFACE ROUGHNESS 125
 UNLESS OTHERWISE NOTED

DRAFTED
 IN ACCORDANCE
 WITH ANSI Y14.5M
 1982



PART NUMBER:
 125228-() () () ()
 SHEET 2 OF 2