



TABLE I

FIRST DASH NO.	THREAD SIZE	A DIA TO SHARP CORNER	A' ABS MIN. DIA.	D DIA.	H REF.	J MAX.	P DIA.	R RAD.	T REF.	U REF.	N HEAD PROT.	W GAGE DIA.
-2	.1640-32 UNJC-3A	.323-.334	.287	.1640 .1610	.068	.015		.020 .010	.406	.031	.0276 .0238	.2071 .2067
-3	.1900-32 UNJF-3A	.375-.387	.337	.1890 .1860	.080	.016		.020 .010	.406	.031	.0299 .0259	.3147 .3143
-4	.2500-28 UNJF-3A	.496-.510	.452	.2490 .2460	.106	.018		.020 .010	.468	.031	.0353 .0307	.4245 .4241
-5	.3125-24 UNJF-3A	.622-.638	.572	.3115 .3085	.133	.021		.025 .010	.531	.047	.0409 .0357	.5389 .5385
-6	.3750-24 UNJF-3A	.748-.766	.692	.3740 .3710	.159	.023		.030 .015	.625	.047	.0466 .0407	.6532 .6528
-7	.4375-20 UNJF-3A	.874-.894	.812	.4365 .4325	.186	.026		.035 .015	.719	.047	.0522 .0457	.7676 .7672
-8	.5000-20 UNJF-3A	1.022 1.000	.932	.4990 .4950	.213	.028		.040 .020	.750	.047	.0578 .0507	.8820 .8816

1. MATERIAL: ALLOY STEEL PER AMS 6322 (8740).
2. HEAT TREAT: 160,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH.
3. FINISH: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
4. SHEAR REQUIREMENTS PER NAS 498, TABLE II.

INFORMATION ON THIS DOCUMENT IS A TRADE SECRET, PROPRIETARY, AND SHALL NOT BE USED OR REPRODUCED IN WHOLE OR IN PART WITHOUT WRITTEN AUTHORIZATION OF SPS TECHNOLOGIES.

TOLERANCES ±.010 AND ±2'
SURFACE ROUGHNESS 125/
UNLESS OTHERWISE NOTED
DRAWN: BE/MD DATE: 5/11/93
APPROVED: L. KLINE DATE: 7/8/97
APPROVED: RON HUKARI



TITLE
100° FLUSH HEAD BOLT
ALLOY STEEL MATERIAL,
160 KSI, CAD PLATED.

FSCM NO. 56878
CUSTODIAN:
JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS
MIL-S-7839
EXCEPT AS NOTED

PART NUMBER: 125595-()

SHEET 1 OF 2 PROJECT 64A58

5. BASIC PART NUMBER MAY BE OMITTED ON DASH 2 & 3 SIZES DUE TO SPACE LIMITATIONS.
6. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY & SHALL NOT BE AN INSPECTION REQ'MT.
7. RUNOUT: CONICAL SURFACE OF HEAD TO SHANK SHALL BE WITHIN .003 TIR.
RECESS TO SHANK SHALL BE WITHIN .016 TIR FOR SIZES THRU 1/4, .024 TIR FOR SIZES LARGER THAN 1/4.
8. DIMENSIONS APPLY AFTER PLATING.
9. PARTS SHALL BE FREE OF BURRS & SHARP EDGES.

CODE: FIRST DASH NUMBER INDICATES THREAD SIZE OF BOLT IN SIXTEENTH INCH INCREMENTS.
SECOND DASH NUMBER INDICATES GRIP LENGTH IN SIXTEENTH INCH INCREMENTS. LENGTH EQUALS NOMINAL GRIP LENGTH PLUS "T" DIMENSION.

EXAMPLE: 125595-3-16: .1900-32 SIZE SCREW, 1.000 GRIP LENGTH, 1.406 LENGTH, ALLOY STEEL, PLATED.

SECOND DASH NUMBER	GRIP ±.015	LENGTH FOR SIZES INDICATED ±.030-.015						
		.164-32	.190-32	.250-28	.3125-24	.375-24	.4375-20	.500-20
-2	.125	.531	.531					
-3	.188	.594	.594	.656	.719			
-4	.250	.656	.656	.719	.781	.875	.969	
-5	.312	.719	.719	.781	.844	.938	1.031	1.062
-6	.375	.781	.781	.844	.906	1.000	1.093	1.125
-7	.438	.844	.844	.906	.969	1.062	1.156	1.188
-8	.500	.906	.906	.969	1.031	1.125	1.219	1.250
-9	.562	.969	.969	1.031	1.093	1.188	1.281	1.312
-10	.625	1.031	1.031	1.093	1.156	1.250	1.343	1.375
-11	.688	1.093	1.093	1.156	1.219	1.312	1.406	1.438
-12	.750	1.156	1.156	1.219	1.281	1.375	1.468	1.500
-13	.812	1.219	1.219	1.281	1.343	1.438	1.531	1.562
-14	.875	1.281	1.281	1.343	1.406	1.500	1.594	1.625
-15	.938	1.343	1.343	1.406	1.468	1.562	1.656	1.688
-16	1.000	1.406	1.406	1.468	1.531	1.625	1.719	1.750
-17	1.062	1.468	1.468	1.531	1.594	1.688	1.781	1.812
-18	1.125	1.531	1.531	1.594	1.656	1.750	1.844	1.875
-19	1.188	1.594	1.594	1.656	1.719	1.812	1.906	1.938
-20	1.250	1.656	1.656	1.719	1.781	1.875	1.969	2.000
-21	1.312	1.719	1.719	1.781	1.844	1.938	2.031	2.062
-22	1.375	1.781	1.781	1.844	1.906	2.000	2.093	2.125
-23	1.438	1.844	1.844	1.906	1.969	2.062	2.156	2.188
-24	1.500	1.906	1.906	1.969	2.031	2.125	2.219	2.250
-25	1.562	1.969	1.969	2.031	2.093	2.188	2.281	2.312
-26	1.625	2.031	2.031	2.093	2.156	2.250	2.343	2.375
-27	1.688	2.093	2.093	2.156	2.219	2.312	2.406	2.438
-28	1.750	2.156	2.156	2.219	2.281	2.375	2.468	2.500
-29	1.812	2.219	2.219	2.281	2.343	2.438	2.531	2.562
-30	1.875	2.281	2.281	2.343	2.406	2.500	2.594	2.625
-31	1.938	2.343	2.343	2.406	2.468	2.562	2.656	2.688
-32	2.000	2.406	2.406	2.468	2.531	2.625	2.719	2.750