



DRAWING NUMBER
SD. 300. 67559

ISSUE DATE
2/11/66

REVISION
⑥ REVISED AND REDRAWN 8/22/00
⑦ 10/16/01
⑧ 8/28/02

BASIC PART NUMBER	UNJ-3A THREADS	ØA	ØB	ØD	E	F MIN	H	J MIN	K MAX	ØL	M	N MAX R	P RAD	Q	R RAD	T REF	U	W	X TIR	Y TIR	Z TIR
67559-02	.086-56	.156 .146	.0852 .0842	.122	.044	.026	.086 .083	.011	.047	-	-	.003	.005 .003	.016	.015 .005	.212	.02	.0791 .0781	.005	.006	.0045
67559-03	.099-48	.172 .162	.0982 .0972	.122	.048	.030	.099 .095	.021	.059	-	-	.003	.005 .003	.016	.016 .010	.241	.03	.0791 .0781	.005	.006	.0045
67559-04	.112-40	.203 .193	.1112 .1102	.141	.056	.034	.112 .108	.024	.066	.026	.028	.005	.010 .005	.031	.016 .010	.292	.03	.0952 .0937	.005	.006	.0045
67559-05	.125-40	.219 .209	.1242 .1232	.141	.060	.038	.125 .121	.038	.072	.026	.032	.005	.010 .005	.031	.016 .010	.292	.04	.0952 .0937	.005	.006	.0045
67559-06	.138-32	.250 .240	.1372 .1362	.159	.067	.041	.138 .134	.041	.087	.033	.036	.008	.010 .005	.031	.016 .010	.346	.04	.0952 .0937	.005	.006	.0045
67559-08	.164-32	.297 .287	.1632 .1622	.196	.082	.049	.164 .159	.049	.103	.033	.041	.008	.010 .005	.031	.031 .021	.409	.04	.1426 .1406	.005	.006	.0045
67559-3	.190-32	.328 .318	.1895 .1885	.252	.088	.057	.200 .180	.057	.118	.037	.058	.010	.020 .010	.047	.030 .020	.429	.04	.1582 .1562	.005	.007	.0045
67559-4	.250-28	.438 .428	.2495 .2485	.342	.112	.068	.260 .240	.068	.152	.037	.078	.010	.020 .010	.063	.041 .031	.524	.05	.1900 .1880	.005	.007	.0045
67559-5	.312-24	.531 .521	.3120 .3110	.394	.144	.094	.322 .302	.094	.184	.055	.094	.010	.020 .010	.063	.041 .031	.579	.05	.2210 .2190	.006	.008	.0045
67559-6	.375-24	.649 .639	.3745 .3735	.520	.183	.116	.385 .365	.116	.223	.055	.125	.011	.020 .010	.063	.057 .047	.683	.06	.3150 .3130	.008	.010	.0045
67559-7	.437-20	.750 .740	.4370 .4360	.534	.208	.141	.448 .428	.141	.248	.055	.156	.011	.020 .010	.063	.057 .047	.720	.06	.3150 .3130	.009	.011	.0060
67559-8	.500-20	.828 .818	.4995 .4985	.625	.247	.169	.510 .490	.169	.287	.055	.172	.011	.020 .010	.063	.057 .047	.859	.07	.3785 .3755	.010	.012	.0060

- MATERIAL: A286 PER AMS 5732.
- HEAT TREATMENT: 160 KSI MINIMUM ULTIMATE TENSILE STRENGTH.
- FINISH: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 3. PASSIVATE PER AMS-QQ-P-35.
- FLUORESCENT PENETRANT INSPECT PER ASTM E 1417.
- MANUFACTURING REQUIREMENTS: HEAD TO BE FORGED. SOCKET TO BE FORGER OR MACHINED. THREADS TO BE ROLLED AFTER HEAT TREATMENT. HEAD TO SHANK FILLET TO BE COLD WORKED.
- MARKING MAY BE OMITTED FOR SIZES Ø.164 AND SMALLER WHEN THE HEADS ARE CROSSDRILLED.
- REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
- BREAK ALL SHARP EDGES .003-.015.
- PART NUMBER: 67559 - () () () ()

NO LETTER = PASSIVATE
 "P" = CADMIUM PLATE
 = NOMINAL GRIP LENGTH IN SIXTEENTHS
 "H" = CROSSDRILLED HEAD
 "-" = NO CROSSDRILLED HEAD
 = NOMINAL DIAMETER PER TABULATION
 BASIC PART NUMBER
 LENGTH = GRIP + T REF

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TOLERANCES ±.010 AND ±2" SURFACE ROUGHNESS 125 UNLESS OTHERWISE NOTED	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M DATE: 8/22/00	SPS TECHNOLOGIES	FSCM NO. 56878	STANDARDS AND SPECIFICATIONS NASM7838
DRAWN BY: STEVE FOSTER APPROVED: L. KLINE APPROVED: S. FOSTER	DATE: 10/07/02		CUSTODIAN: JENKINTOWN, PA.	PART NUMBER: 67559-() () () () SHEET 1 OF 1
TITLE BOLT, TENSION, INTERNAL WRENCHING A286, 160 KSI UTS			ER-020	