



FIRST DASH NO.	THREAD	A		B		F MIN	H		W	M	N	R		T MIN
		MAX	MIN	MAX	MIN		MAX	MIN				MAX	MIN	
-448	#4-48 UNF-3A	.183	.176	.112	.1075	.051	.112	.108	.0937	.033	.036	.009	.005	.750
-440	#4-40 UNC-3A													
-544	#5-44 UNF-3A	.205	.198	.125	.1202	.057	.125	.121	.0937	.035	.036	.010	.006	.750
-540	#5-40 UNC-3A													
-640	#6-40 UNF-3A	.226	.218	.138	.1329	.064	.138	.134	.1093	.042	.036	.010	.006	.750
-632	#6-32 UNC-3A													
-836	#8-36 UNF-3A	.270	.262	.164	.1585	.077	.164	.159	.1406	.050	.046	.012	.007	.875
-832	#8-32 UNC-3A													
-1032	#10-32 UNF-3A	.312	.303	.190	.1840	.090	.190	.185	.1562	.055	.046	.014	.009	.875
-1024	#10-24 UNC-3A													
-428	1/4-28 UNF-3A	.375	.365	.250	.2435	.120	.250	.244	.1875	.075	.046	.014	.009	1.000
-420	1/4-20 UNC-3A													
-524	5/16-24 UNF-3A	.468	.457	.3125	.3053	.151	.312	.306	.2500	.094	.046	.017	.012	1.125
-518	5/16-18 UNC-3A													
-624	3/8-24 UNF-3A	.562	.550	.375	.3678	.182	.375	.368	.3125	.113	.064	.020	.015	1.250
-616	3/8-16 UNC-3A													
-720	7/16-20 UNF-3A	.656	.642	.4375	.4294	.213	.437	.430	.3750	.131	.064	.023	.018	1.375
-714	7/16-14 UNC-3A													
-820	1/2-20 UNF-3A	.750	.735	.500	.4919	.245	.500	.492	.3750	.150	.064	.026	.020	1.500
-813	1/2-13 UNC-3A													
-918	9/16-18 UNF-3A	.843	.827	.5625	.5538	.265	.562	.554	.4375	.169	.064	.028	.022	1.625
-912	9/16-12 UNC-3A													
-1018	5/8-18 UNF-3A	.937	.921	.625	.6163	.307	.625	.616	.5000	.188	.064	.032	.024	1.750
-1011	5/8-11 UNC-3A													

1. MATERIAL: 410 S/S.
2. HEAT TREATMENT: 38-43 HRC, 170,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH.
3. FINISH: CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 3.
4. CONCENTRICITY: HEAD TO BODY WITHIN 2% OF THE BODY DIAMETER T.I.R. OR .006, WHICHEVER IS GREATER. SOCKET TO BODY WITHIN 3% OF BODY DIAMETER T.I.R. OR .005, WHICHEVER IS GREATER, FOR SIZES THROUGH 1/2" DIAMETER AND 6% T.I.R. FOR SIZES LARGER THAN 1/2" DIAMETER.
5. SQUARENESS: THE PLANE OF THE BEARING SURFACE TO BE PERPENDICULAR TO THE AXIS OF THE BODY WITHIN PLUS OR MINUS ONE DEGREE.
6. LENGTH TOLERANCE:
 - A. $\pm 1/64$ THROUGH ONE INCH.
 - B. $\pm 1/32$, $-1/64$ OVER ONE INCH, THROUGH TWO INCHES.
 - C. $\pm 1/32$ OVER TWO INCHES.
7. HEADS SHALL BE FORGED, HEX SOCKET MACHINED OR FORGED AT MANUFACTURERS OPTION.
8. PARTS LONGER THAN "T MIN" WILL HAVE A MINIMUM THREAD LENGTH AS TABULATED. PARTS EQUAL TO OR SHORTER THAN "T MIN" WILL BE THREADED AS CLOSE TO HEAD AS PRACTICAL, APPROXIMATELY WITHIN TWO THREAD PITCHES FROM BEARING SURFACE.
9. PART NUMBER: 69638-()-()-()

= LENGTH IN SIXTEENTHS
"H" = CROSSDRILLED HEADS
NO LETTER = NO CROSSDRILLED HEADS
= DASH NUMBER PER TABULATION
BASIC PART NUMBER

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TOLERANCES $\pm .010$ AND $\pm 2^\circ$ SURFACE ROUGHNESS 125 UNLESS OTHERWISE NOTED	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M	SPS TECHNOLOGIES	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS SPS-B-178 EXCEPT AS NOTED
DRAWN BY: KATHY SCHWARTZ APPROVED: S FOSTER APPROVED: R HUKARI	DATE: 8/22/01 DATE: 8/29/01	TITLE SHCS, 410 STAINLESS STEEL 170 KSI UTS	PART NUMBER: 69638-()-()-()	SHEET 1 OF 1