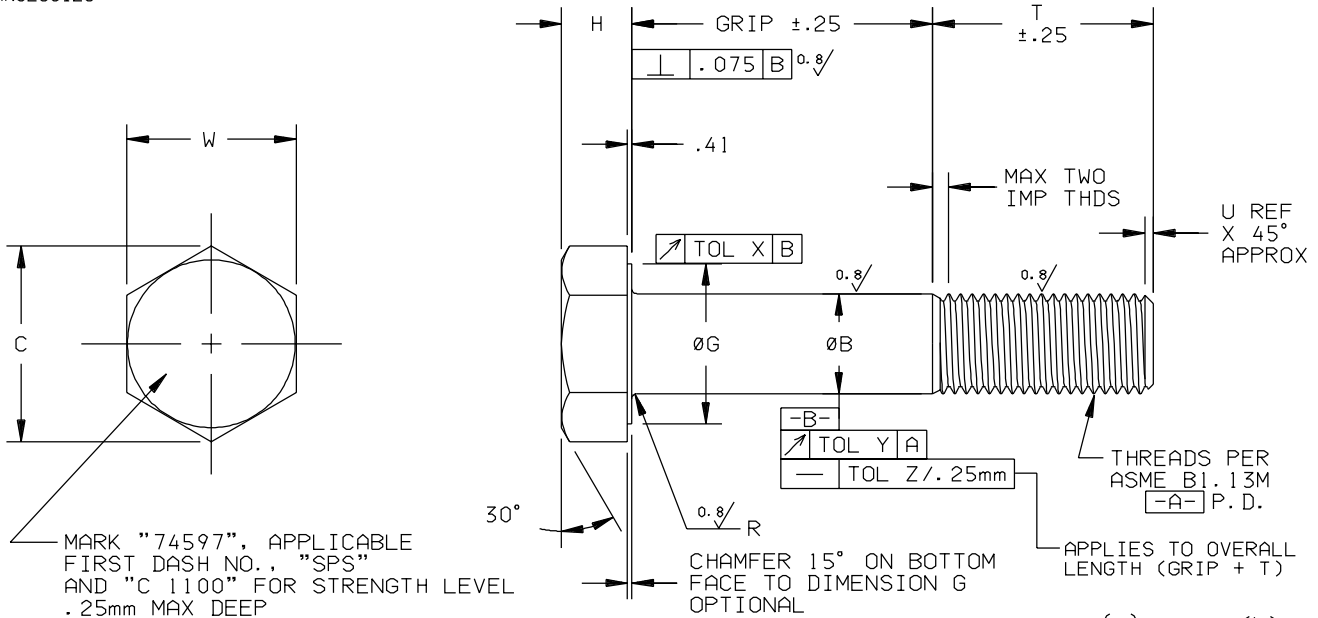




DRAWING NUMBER
SD. 300. 74597
ISSUE DATE
9/18/72
REVISION
4
REVISED AND REBRAN 4/25/02



MARK "74597", APPLICABLE FIRST DASH NO., "SPS" AND "C 1100" FOR STRENGTH LEVEL .25mm MAX DEEP

FIRST DASH NO.	NOMINAL BOLT Ø AND THREAD PITCH	ØB	C MIN	ØG MIN	H	R	T ±.25	U REF	W	X	Y	Z MIN	(a) (b)	
													ULTIMATE TENSILE STRENGTH MIN kN	DOUBLE SHEAR STRENGTH MIN kN
M508	M5 X 0.8-4h	5.000 4.988	8.87	7	3.65 3.35	0.45 0.2	12	1.6	8.00 7.85	.18	.12	.035	15.6	25.7
M610	M6 X 1-4h	6.000 5.988	11.05	9	4.15 3.85	0.5 0.25	14	1.6	10.00 9.78	.18	.12	.035	22.1	37.0
M8125	M8 X 1.25-4h	8.000 7.985	14.38	12	5.65 5.35	0.65 0.4	18	1.6	13.00 12.73	.22	.15	.035	40.3	65.9
M1015	M10 X 1.5-4h	10.000 9.985	18.90	16	7.18 6.82	0.6 0.4	22	1.6	17.00 16.74	.22	.15	.035	63.8	103
M1215	M12 X 1.5-4h	12.000 11.982	21.10	18	8.18 7.82	0.8 0.6	24	1.6	19.00 18.67	.27	.18	.025	96.9	148
M1615	M16 X 1.5-4h	16.000 15.982	26.75	23	10.18 9.82	1.0 0.6	28	2.0	24.00 23.67	.27	.18	.025	184	263
M2015	M20 X 1.5-4h	20.000 19.979	33.53	29	13.21 12.79	1.2 0.8	34	2.4	30.00 29.67	.33	.21	.025	299	412
M242	M24 X 2-4h	24.000 23.979	39.98	35	15.21 14.79	1.2 0.8	41	2.4	36.00 35.38	.33	.21	.025	422	592
M302	M30 X 2-4h	30.000 29.979	51.28	45	19.26 18.74	1.4 1.0	51	2.8	46.00 45.38	.39	.21	.025	683	926
M363	M36 X 3-4h	36.000 35.975	61.31	54	23.26 22.74	1.4 1.0	61	2.8	55.00 54.26	.39	.25	.025	952	1300
M423	M42 X 3-4h	42.000 41.975	72.61	64	26.26 25.74	1.6 1.2	71	2.8	65.00 64.26	.39	.25	.025	1331	1800

a) ULTIMATE TENSILE STRENGTH BASED ON TENSILE STRESS AREA OF ASME B1.13M X 1100 MPa.
b) DOUBLE SHEAR STRENGTH BASED ON TENSILE STRESS AREA OF ASME B1.13M X 655 MPa.

1. MATERIAL: A286 PER THE CHEMISTRY OF AMS 5732 OR AMS 5737.
2. HEAT TREATMENT: 1100 MPa ULTIMATE TENSILE STRENGTH.
3. FINISH: PASSIVATE PER AMS-QQ-P-35.
4. FILLET AND THREADS TO BE FORMED AFTER HEAT TREATMENT.
5. SURFACE TEXTURE PER ISO R468.
6. THREAD INSPECTION - PER ISO RECOMMENDATION R 1502 EXCEPT GAGE WEAR BEYOND THE LIMITS OF THE THREAD NOT PERMITTED.
7. DIMENSIONS ARE IN MILLIMETERS.
8. USE ASME B18.2.3.1M ONLY FOR DIMENSIONAL REFERENCE - MANUFACTURE PART TO THE TABULATED VALUES HEREIN THIS DRAWING.
9. PART NUMBER: 74597 - () - ()



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 ±0.25 AND ±2*	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M		FSCM NO. 56878	STANDARDS AND SPECIFICATIONS NAS 4003 EXCEPT AS NOTED
SURFACE ROUGHNESS 3.2√ UNLESS OTHERWISE NOTED	DATE: 4/25/02		CUSTODIAN: JENKINTOWN, PA.	PART NUMBER: 74597-()-()
DRAWN BY: KATHY SCHWARTZ	DATE: 5/01/02	TITLE	BOLT, HEXAGON, A286, 1100MPa UTS MAX OPERATING TEMP. 538°C	
APPROVED: S FOSTER			SHEET 1 OF 1 ER-020	
APPROVED: M ZATAVESKI				