



PROPRIETARY INFORMATION  
 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

DRAWING NUMBER  
 SD. 300.79034

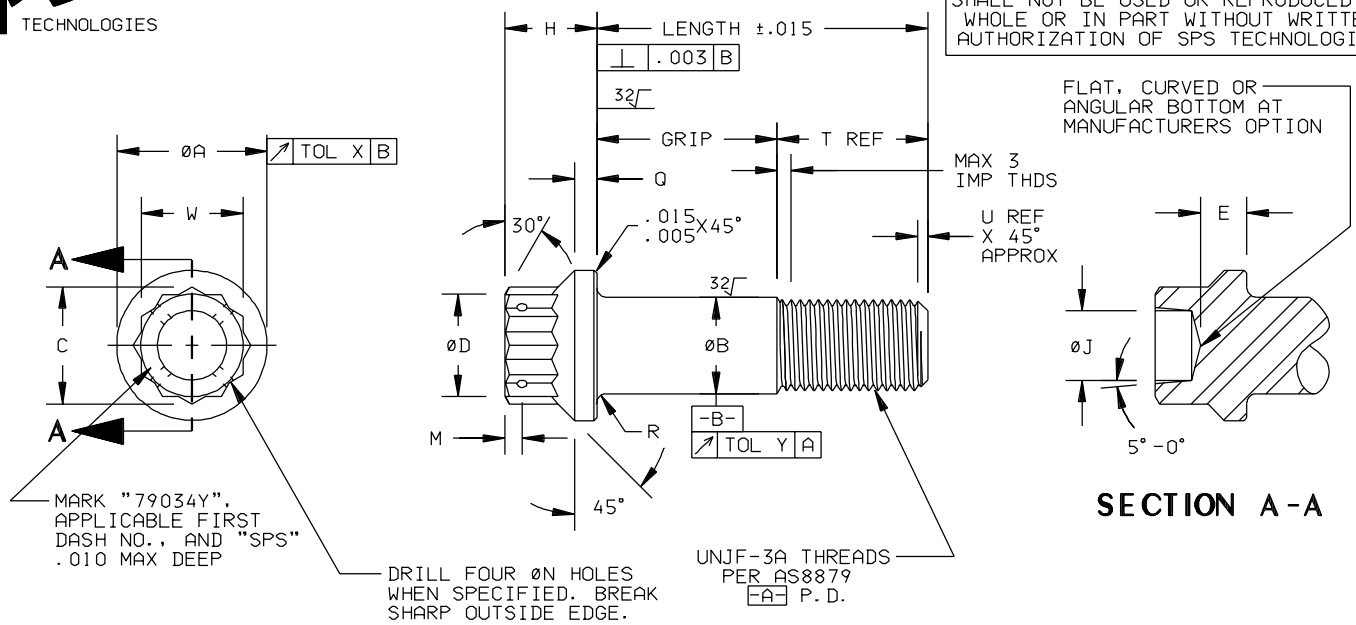
ISSUE DATE  
 4/21/77

REVISION  
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REVISED AND REDRAWN  
 2/19/2001

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6/09/06



MARK "79034Y",  
 APPLICABLE FIRST  
 DASH NO., AND "SPS"  
 .010 MAX DEEP

DRILL FOUR ØN HOLES  
 WHEN SPECIFIED. BREAK  
 SHARP OUTSIDE EDGE.

UNJF-3A THREADS  
 PER AS8879  
 P.D.

SECTION A-A

FIRST DASH NO	THREADS	ØA ±.005	ØB	C MIN	ØD	E MIN	H	ØJ +.010 - .030	M	ØN ±.005	Q	R	T REF	U REF	W	X	Y
-4	.2500-28	.433	.2807 .2797	.347	.312 .297	.135	.300	.180	.062	.037	.069	.041 .031	.492	.031	.313 .304	.005	.0045
-5	.3125-24	.526	.3432 .3422	.419	.375 .360	.162	.348	.215	.070	.055	.082	.041 .031	.579	.047	.376 .367	.006	.0045
-6	.3750-24	.644	.4057 .4047	.491	.437 .422	.197	.388	.260	.070	.055	.091	.057 .047	.625	.047	.439 .430	.008	.0045
-7	.4375-20	.745	.4682 .4672	.561	.500 .485	.228	.435	.320	.070	.055	.099	.057 .047	.721	.047	.502 .492	.009	.006
-8	.5000-20	.823	.5307 .5297	.631	.562 .547	.254	.504	.380	.094	.055	.123	.057 .047	.768	.047	.564 .553	.010	.006
-9	.5625-18	.933	.5927 .5917	.703	.625 .610	.287	.557	.440	.094	.055	.133	.057 .047	.852	.062	.627 .616	.011	.006
-10	.6250-18	1.045	.6552 .6542	.775	.687 .672	.327	.618	.500	.094	.055	.150	.073 .063	.899	.062	.690 .679	.012	.006
-12	.7500-16	1.225	.7802 .7792	.917	.812 .797	.380	.711	.570	.094	.055	.178	.073 .063	1.036	.062	.814 .803	.015	.006
-14	.8750-14	1.433	.9052 .9042	1.059	.937 .922	.438	.808	.650	.125	.055	.198	.073 .063	1.244	.078	.940 .928	.018	.009
-16	1.0000-12	1.620	1.0302 .0292	1.200	1.062 .047	.493	.923	.740	.125	.055	.222	.073 .063	1.479	.078	1.064 .052	.020	.009
-18	1.1250-12	1.870	1.1552 .1537	1.414	1.250 .235	.556	1.051	.840	.125	.055	.258	.073 .063	1.650	.094	1.252 .239	.022	.009
-20	1.2500-12	2.120	1.2802 .2787	1.484	1.312 .297	.636	1.155	.950	.125	.055	.269	.089 .077	1.760	.094	1.314 .301	.025	.009
-22	1.3750-12	2.308	1.4052 .4037	1.628	1.437 .422	.698	1.266	1.070	.188	.055	.274	.089 .077	1.885	.094	1.440 .427	.028	.012
-24	1.5000-12	2.495	1.5302 .5287	1.842	1.625 .610	.750	1.434	1.200	.188	.055	.335	.089 .077	2.010	.094	1.627 .614	.030	.012

- MATERIAL: ALLOY STEEL, AMS 6382(AISI 4140), AMS-S-5000(AISI 4340), AMS 6322(AISI 8740), AMS 6448(AISI 6150).
- HEAT TREATMENT: 180,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH.
- HARDNESS: 39-43 HRC.
- FINISH: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- MAGNETIC PARTICLE INSPECT PER ASTM E 1444.
- SURFACE TEXTURE PER ASME B46.1-UNLESS OTHERWISE SPECIFIED THE SURFACE TEXTURE SHALL NOT EXCEED 125 MICRONS.
- 79034-( ) ( ) ( )  
 DESIGNATES NOMINAL GRIP LENGTH IN SIXTEENTHS  
 NO LETTER = NO CROSSDRILLED HEAD  
 "H" = CROSSDRILLED HEAD  
 DESIGNATES NOMINAL DIAMETER IN SIXTEENTHS  
 BASIC PART NUMBER  
 LENGTH = NOMINAL GRIP + "T"
- FOR MARKING PURPOSES "Y" WILL BE ADDED TO THE BASIC PART NUMBER TO SIGNIFY .0312 OVERSIZE BOLTS.
- CHAMFER "U" PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES.
- REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
- DIMENSIONS IN INCHES.
- FOR FIRST OVERSIZE (0.0156) BOLTS SEE SPS DRAWING SD. 300.79033.

TOLERANCES ±.010 AND ±2°  
 SURFACE ROUGHNESS 125  
 UNLESS OTHERWISE NOTED  
 DRAFTED IN ACCORDANCE WITH ANSI Y14.5M-1982  
 DRAWN BY: KATHY SCHWARTZ DATE: 2/19/01  
 APPROVED: S FOSTER  
 APPROVED: L KLINE DATE: 6/14/06

FSCM NO. 56878  
 CUSTODIAN:  
 JENKINTOWN, PA.  
 TITLE  
 BOLT, DOUBLE HEXAGON, FLANGED, ALLOY STEEL  
 180-220 KSI .0312 OVERSIZE  
 APPLICATIONS TO 450°F.

STANDARDS AND SPECIFICATIONS  
 NASM8831  
 PART NUMBER:  
 79034-( ) ( ) ( )  
 SHEET 1 OF 1