SPS TECHNOLOGIES

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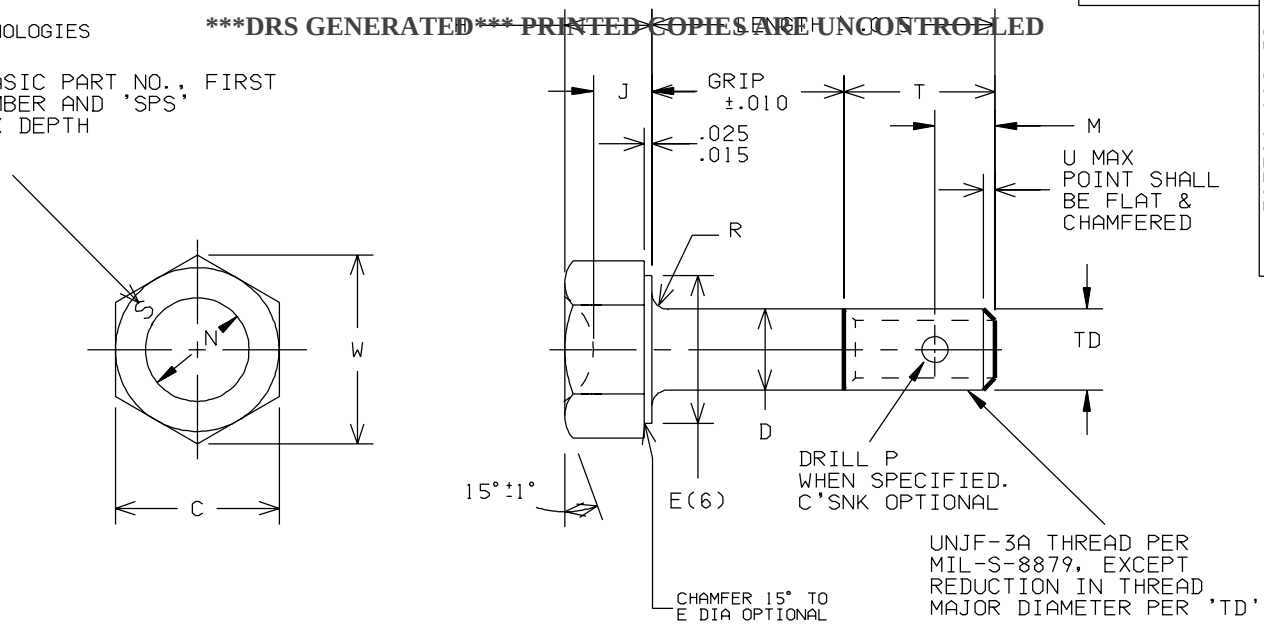
DRAWING NUMBER SD.300.802282

REVISION 1 12/18/00 2 1/24/01



FIRST DASH NO	NOM THREAD SIZE	C	D DIA	E DIA MIN	H	J	N	R RAD	T REF	TD DIA	U MAX	W MIN	AA	BB	CC	M	P
-3	.1900-32	.376 .367	.1895 .1885	.335	.125 .110	.088 .073	.20 .18	.020 .010	.323	.1840 .1810	.039	.410	.0045	.0040	.005	.174 .154	.080 .070
-4	.2500-28	.439 .429	.2495 .2485	.398	.140 .125	.098 .083	.26 .24	.020 .010	.370	.2440 .2410	.045	.480	.0045	.0030	.006	.180 .160	.086 .076
-5	.3125-24	.502 .492	.3120 .3110	.460	.171 .156	.119 .104	.32 .30	.020 .010	.438	.3060 .3020	.052	.552	.0045	.0030	.008	.192 .182	.086 .076
-6	.3750-24	.564 .554	.3745 .3735	.523	.203 .188	.140 .125	.39 .37	.025 .015	.454	.3680 .3640	.052	.623	.0045	.0025	.009	.193 .173	.116 .106
-7	.4375-20	.690 .678	.4370 .4360	.648	.234 .219	.161 .146	.45 .43	.025 .015	.528	.4310 .4260	.062	.764	.0060	.0025	.010	.209 .189	.116 .106
-8	.5000-20	.752 .741	.4995 .4985	.710	.265 .250	.182 .167	.51 .49	.030 .020	.528	.4930 .4880	.068	.836	.0060	.0020	.011	.208 .188	.116 .106

MATERIAL: H-11 ALLOY STEEL PER AMS6487.

HEAT TREATMENT: 220 KSI MIN UTS PER AMS2759.

FINISH: CADMIUM FLUOBORATE PLATE PER NAS672. MAX RECOMMENDED SERVICE TEMPERATURE 450 DEG F.

NOTES:

(1). GRIP LENGTH OF BOLTS SHALL BE MEASURED FROM UNDERSIDE OF HEAD TO THE END OF THE FULL CYLINDRICAL PORTION OF THE SHANK.

(2) REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY, NOT AN INSPECITON REQUIREMENT.

(3). BEARING SURFACE SQUARENESS: WITHIN .003 FIM OF SHANK DIAMETER.

(4). CONCENTRICITY: "D" DIAMETER TO THREAD PITCH DIAMETER WITHING "AA" VALUES: "D" AND "E" DIAMETERS WITHIN "CC" VLAUES FIM.

(5). SHANK STRAIGHTNESS: WITHIN "BB" VALUES FIM PER INCH OF LENGTH.

(6). WASHER FACE DIAMETER: MAX NOT TO EXCEED ACTUAL WIDTH ACROSS FLATS, MIN AS TABLULATED.

(7). SURFACE TEXTURE: PER ASME B46.1, "D" DIAMETER, BEARING SURFACE OF HEAD THREAD FLANKS AND ROOTS 32; OTHER SURFACES 125.

(8). DIMENSIONS IN INCHES. DIMENSIONS TO BE MET AFTER PLATING.

(9). COTTER PIN HOLE CENTERLINE: WITHIN .010 AND NORMAL WITHIN 2° OF BOLT CENTERLINE.

(10). 100% MAGNETIC PARTICLE INSPECTION PER ASTM1444 REQUIRED.

(11). SAMPLE PART NO: 802282-4-10 = HEX HEAD BOLT,.2500-28 THREAD,.625 GRIP,CAD FLUOBORATE PLATE,UNDRILLED.
802282-4-10D = HEX HEAD BOLT,.2500-28 THREAD,.625 GRIP,CAD FLUOBORATE PLATE, DRILLED.

TOLERANCES± .010 AND ±2° UNLESS OTHERWISE SPECIFIED REF: NAS6203-NAS6220

STANDARDS AND SPECIFICATIONS SPS-B-640, APPENDIX 5.2 EXCEPT AS NOTED	TITLE BOLT, TENSION, HEX HEAD, ALLOY STEEL, SHORT THREAD, REDUCED MAJOR THREAD DIA.,220 KSI FTU	DRAWN BY mpm DATE 6/2/00
		APPROVED MPM DATE 7/25/00
CAGE IDENT. NO. OPTK6		BASIC PART NUMBER 802282
CUSTODIAN: SALT LAKE,UT.		