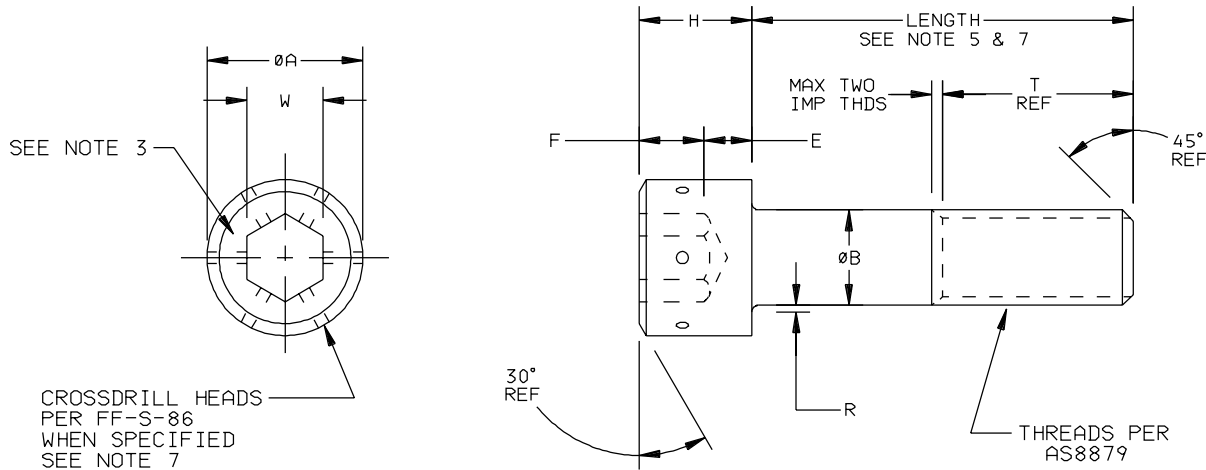




PROPRIETARY INFORMATION
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AUTHORIZATION OF SPS TECHNOLOGIES

DRAWING NUMBER
SD-300-94800
ISSUE DATE
11/09/96
REVISION
① 3/07/03



DASH NUMBER	THREADS CLASS 3A	ØA	ØB	E MIN	F MIN	H	R FILLET EXT	T REF	W NOM
440	.112-40 UNJC	.183	.112	.038	.051	.112	.009	.750	.0937
448	.112-48 UNJF	.176	.1075	.038	.051	.108	.005	.750	.0937
540	.125-40 UNJC	.205	.125	.043	.057	.125	.010	.750	.0937
544	.125-44 UNJF	.198	.1202	.043	.057	.121	.006	.750	.0937
632	.138-32 UNJC	.226	.138	.047	.064	.138	.010	.750	.1093
640	.138-40 UNJF	.218	.1329	.047	.064	.134	.006	.750	.1093
832	.164-32 UNJC	.270	.164	.056	.077	.164	.012	.875	.1406
836	.164-36 UNJF	.262	.1585	.056	.077	.159	.007	.875	.1406
1024	.190-24 UNJC	.312	.190	.065	.090	.190	.014	.875	.1562
1032	.190-32 UNJF	.303	.184	.065	.090	.185	.009	.875	.1562
420	.250-20 UNJC	.375	.250	.095	.120	.250	.014	1.000	.1875
428	.250-28 UNJF	.365	.2435	.095	.120	.244	.009	1.000	.1875
518	.312-18 UNJC	.469	.3125	.119	.151	.312	.017	1.125	.2500
524	.312-24 UNJF	.457	.3053	.119	.151	.306	.012	1.125	.2500
616	.375-16 UNJC	.562	.375	.143	.182	.375	.020	1.250	.3125
624	.375-24 UNJF	.550	.3678	.143	.182	.368	.015	1.250	.3125
714	.437-14 UNJC	.656	.4375	.166	.213	.438	.023	1.375	.3750
720	.437-20 UNJF	.642	.4294	.166	.213	.430	.018	1.375	.3750
813	.500-13 UNJC	.750	.500	.190	.245	.500	.026	1.500	.3750
820	.500-20 UNJF	.735	.4919	.190	.245	.492	.020	1.500	.3750
1011	.625-11 UNJC	.938	.625	.238	.307	.625	.032	1.750	.5000
1018	.625-18 UNJF	.921	.6163	.238	.307	.616	.024	1.750	.5000

1. MATERIAL: 410 STAINLESS STEEL.
2. HEAT TREAT: 38-43 HRC.
3. MARK SPS' MANUFACTURER'S IDENTIFICATION, LOCATION OPTIONAL ON TOP OR SIDE OF HEAD.
4. DIMENSIONS AND GEOMETRIC TOLERANCING PER ASME/ANSI 18.3.
5. LENGTH TOLERANCE:

DIAMETER	UP TO 1" INCL.	OVER 1" TO 2-1/2" INCL.	OVER 2-1/2" TO 6" INCL.	OVER 6"
.112 THRU .375	-.030	-.040	-.060	-.120
.437 THRU .625	-.030	-.060	-.080	-.120

6. PARTS LONGER THAN "T REF" WILL HAVE A MINIMUM THREAD LENGTH AS TABULATED. PARTS EQUAL TO OR SHORTER THAN "T REF" WILL BE THREADED TO HEAD.
7. PART NUMBER: 94800-836H3-8

= LENGTH IN SIXTEENTHS
CROSSDRILL HEADS = H1 - 1 HOLE THRU
H2 - 2 HOLES THRU
H3 - 3 HOLES THRU
= DASH NUMBER PER TABULATION
= BASIC PART NUMBER

TOLERANCES ±.010 AND 12°	FSCM NO. 56878
SURFACE ROUGHNESS 125/	CUSTODIAN: JENKINTOWN, PA.
UNLESS OTHERWISE NOTED	
DRAFTED IN ACCORDANCE WITH ASME Y14.5M	
DRAWN BY: STEVE FOSTER	DATE: 11/09/96
APPROVED: S FOSTER	
APPROVED: L KLINE	DATE: 3/12/03

TITLE

SCREW, SOCKET HEAD CAP
STAINLESS STEEL, 170 KSI

STANDARDS AND SPECIFICATIONS
FF-S-86
EXCEPT AS NOTED

PART NUMBER:

94800-() () -()

SHEET 1 OF 1