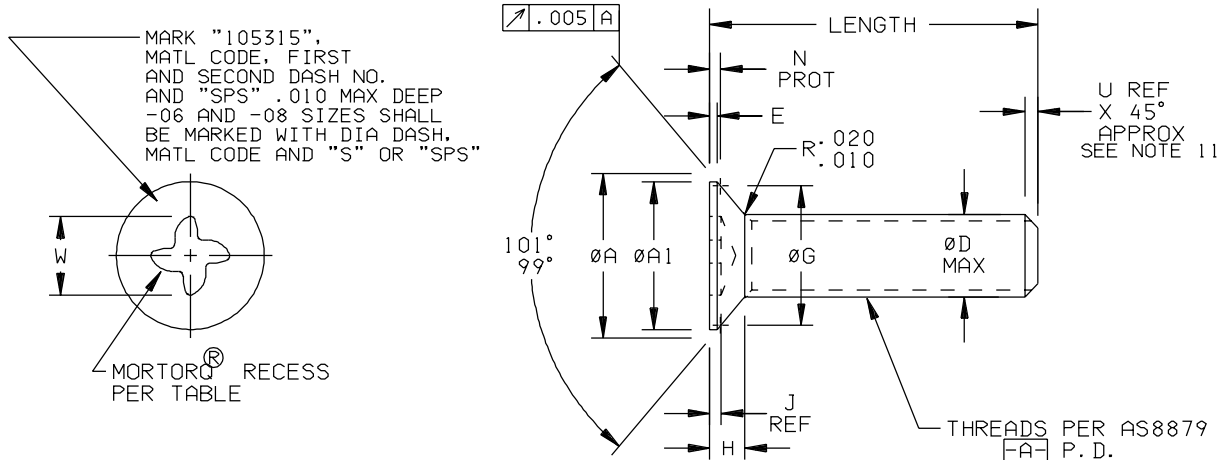




PROPRIETARY INFORMATION
 INFORMATION ON THIS DOCUMENT IS A
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DRAWING NUMBER
SPS-B-105315
 ISSUE DATE
 1/22/04
 REVISION



FIRST DASH NUMBER	THREAD	RECESS SIZE	ØA MAX 1/	ØA1 MIN. 2/	ØD MAX	E	ØG GAGE	H REF	J	N PROT	U REF	W REF	TENSILE STRENGTH LBS. MIN.
06	.1380-32 UNJC-3A	00	.279	.231	.138	.015 .005	-	.057	.030 .021	-	.016	.121	1,200
08	.1640-32 UNJC-3A	0	.332	.270	.164	.020 .010	.2671 .2667	.068	.032 .023	.0268 .0240	.016	.170	1,950
3	.1900-32 UNJF-3A	1	.385	.322	.190	.020 .010	.3147 .3143	.080	.034 .025	.0290 .0263	.016	.240	2,860
4	.2500-28 UNJF-3A	1	.507	.442	.250	.020 .010	.4245 .4241	.106	.039 .030	.0342 .0316	.018	.240	5,520
5	.3125-24 UNJF-3A	1	.635	.568	.312	.020 .010	.5389 .5285	.133	.050 .041	.0395 .0370	.021	.240	9,200
6	.3750-24 UNJF-3A	2	.762	.694	.375	.020 .010	.6532 .6528	.160	.062 .053	.0450 .0426	.021	.308	14,000

1/ TO THEORETICAL SHARP CORNER 2/ ABSOLUTE MINIMUM WITH FLAT

LENGTH TOLERANCE			
DIAMETER	TO 1"	OVER 1" TO 2"	OVER 2"
ALL	+ .000 - .031	+ .000 - .062	+ .000 - .094

- MATERIAL: ALLOY STEEL 4140 PER AMS 6382, 4340 PER AMS 6415 OR 8740 PER AMS 6322.
 TITANIUM 6AL-4V PER AMS 4928 OR AMS 4967.
 A286 PER AMS 5731, AMS 5732, AMS 5737 OR AMS 5853.
- HEAT TREATMENT: ALLOY STEEL - 160-180 KSI TENSILE STRENGTH PER AMS-H-6875.
 TITANIUM 6AL-4V - 160 KSI MINIMUM TENSILE STRENGTH PER AMS 4928 OR AMS 4967.
 A286 - 160 KSI MINIMUM TENSILE STRENGTH. PRECIPITATION HARDEN PER AMS 5853.
- FINISH: ALLOY STEEL - CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.
 TITANIUM 6AL-4V - PLAIN OR ALUMINUM PIGMENTED COATING PER NAS4006.
 A286 - PASSIVATE PER AMS-QQ-P-35.
- PART NUMBER: 105315()-()-()-()
 FINISH - NO LETTER = CADMIUM PLATE FOR ALLOY STEEL, PASSIVATE FOR A286, PLAIN FOR TITANIUM.
 "A" = ALUMINUM COAT FOR TITANIUM.
 LENGTH IN SIXTEENTHS
 NOMINAL THREAD DIAMETER IN SIXTEENTHS
 MATERIAL - A = ALLOY STEEL
 C = A286
 V = TITANIUM 6AL-4V
 BASIC PART NUMBER
- PROCUREMENT SPECIFICATION: NAS4002 FOR ALLOY STEEL, NAS4003 FOR A286 AND NAS4004 FOR TITANIUM. TENSILE STRENGTH AS TABULATED HEREIN. COLD WORKING OF HEAD TO SHANK FILLET AND FATIGUE REQUIREMENTS ARE NOT APPLICABLE. RECESS TORQUE PER PROCUREMENT SPECIFICATIONS EXCEPT USING APPLICABLE MORTORQ® DRIVER.
- DIAMETER OF UNTHREADED PORTION OF SCREWS SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.
- FOR SCREWS TWO INCHES LONG OR SHORTER, COMPLETE THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD. SCREWS OF LONGER LENGTH SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH OF 1.750 INCHES.
- REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
- SCREWS SHALL BE FREE FROM BURRS AND SHARP EDGES.
- SURFACE TEXTURE: "D" DIAMETER, UNDERSIDE OF HEAD, FLANK AND ROOT OF THREAD - 32 MICROINCHES. OTHER SURFACES 125 MICROINCHES PER ASME B46.1
- CHAMFER "U" PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES.
- DIMENSIONS ARE IN INCHES AND APPLY AFTER PLATE OR COATING (WHEN REQUIRED).

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TOLERANCES ±.010 AND ±2°	FSCM NO. 56878	TITLE	STANDARDS AND SPECIFICATIONS
SURFACE ROUGHNESS 125	CUSTODIAN: JENKINTOWN, PA.	BOLT, FLUSH, 100° HEAD, MORTORQ® RECESS, FULL THREAD 160 KSI	SEE NOTE
UNLESS OTHERWISE NOTED	DATE: 1/22/04		PART NUMBER: 105315()-()-()-()-()
DRAFTED IN ACCORDANCE WITH ASME Y14.5M	APPROVED: M MARSHALL		SHEET 1 OF 1
APPROVED: L KLINE	DATE: 2/5/04		