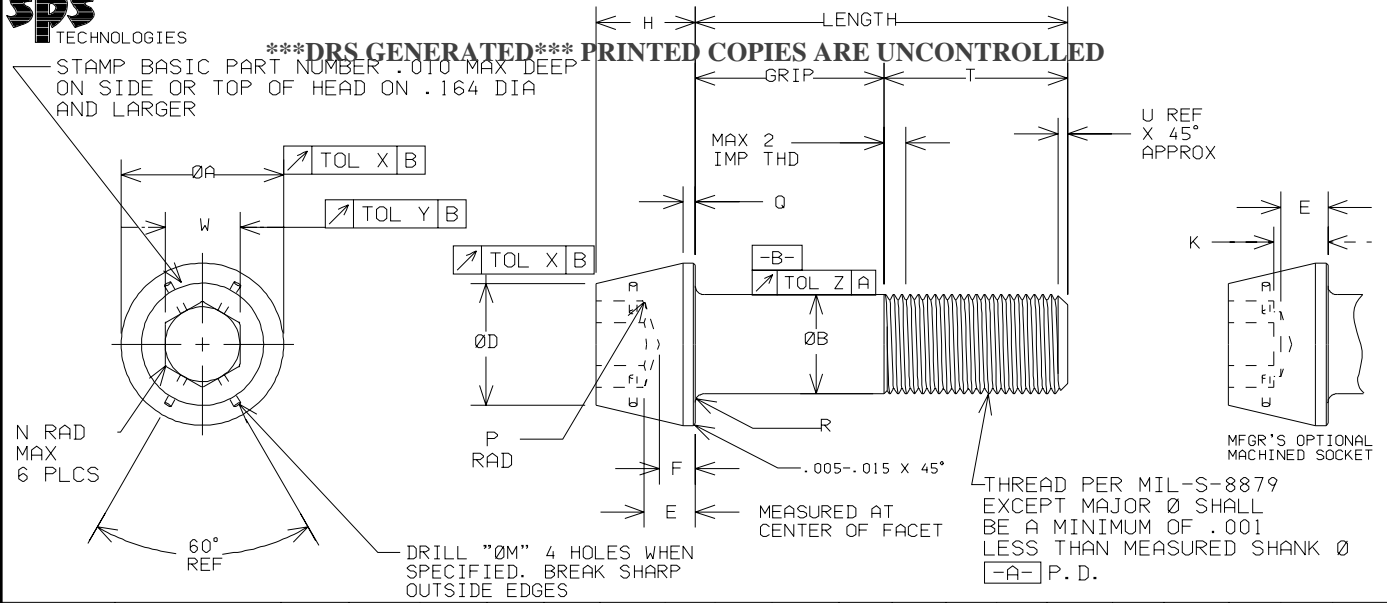


STAMP BASIC PART NUMBER .010 MAX DEEP ON SIDE OR TOP OF HEAD ON .164 DIA AND LARGER



BASIC PART NUMBER	THREAD SIZE MIL-S-8879 3A	ØA MAX	ØB MIN	ØD	E	F MIN	H	J	K	ØM +.005 -.000	N MAX R	P RAD	Q RAD	R REF	T REF	U REF	W	X TIR	Y TIR	Z TIR
HITI 200	.112-40 UNJC	.203 .193	.1112 .1097	.154	.052	.034	.112	.039	.072 .062	.037	.010	.020 .010	.031	.020 .010	.312	.030	.0801 .0781	.010	.010	.003
HITI 201	.138-32 UNJC	.250 .240	.1372 .1357	.191	.064	.042	.138	.043	.087 .077	.037	.010	.020 .010	.031	.020 .010	.375	.040	.0957 .0937	.010	.010	.003
HITI 202	.164-32 UNJC	.281 .271	.1632 .1617	.217	.078	.049	.164	.051	.103 .093	.037	.010	.020 .010	.047	.025 .015	.438	.040	.1270 .1250	.010	.010	.003
HITI 203	.190-32 UNJF	.328 .318	.1892 .1877	.252	.088	.057	.190	.058	.118 .108	.037	.010	.020 .010	.047	.030 .020	.438	.040	.1582 .1562	.010	.010	.003
HITI 204	.250-28 UNJF	.438 .428	.2492 .2477	.342	.112	.068	.250	.078	.152 .142	.037	.010	.020 .010	.063	.041 .031	.500	.040	.1900 .1880	.010	.010	.0045
HITI 205	.312-24 UNJF	.531 .521	.3117 .3102	.394	.144	.094	.312	.094	.184 .174	.055	.010	.020 .010	.063	.041 .031	.562	.050	.2210 .2190	.010	.010	.0045
HITI 206	.375-24 UNJF	.649 .639	.3742 .3727	.520	.183	.116	.375	.125	.223 .213	.055	.011	.020 .010	.063	.057 .047	.688	.050	.3150 .3130	.010	.010	.0045
HITI 207	.437-20 UNJF	.750 .740	.4367 .4347	.534	.208	.141	.438	.156	.248 .238	.055	.011	.020 .010	.063	.057 .047	.812	.060	.3150 .3130	.010	.011	.006
HITI 208	.500-20 UNJF	.828 .818	.4991 .4971	.625	.247	.169	.500	.172	.287 .277	.055	.011	.020 .010	.063	.057 .047	.812	.060	.3785 .3755	.010	.012	.006
HITI 209	.562-18 UNJF	.938 .928	.5616 .5596	.723	.279	.190	.562	.203	.319 .209	.055	.011	.020 .010	.094	.057 .047	.875	.070	.4410 .4380	.011	.014	.006
HITI 210	.625-18 UNJF	1.050 .040	.6240 .6220	.826	.317	.216	.625	.234	.357 .347	.055	.019	.020 .010	.094	.073 .063	.938	.070	.5035 .5005	.012	.016	.006
HITI 212	.750-16 UNJF	1.230 .220	.7488 .7468	.921	.385	.273	.750	.281		.055	.022	.030 .015	.094	.073 .063	1.062	.080	.5660 .5630	.015	.018	.006
HITI 214	.875-14 UNJF	1.438 .428	.8737 .8707	1.083	.450	.327	.875	.344		.055	.022	.030 .015	.094	.073 .063	1.188	.090	.6295 .6257	.018	.022	.009
HITI 216	1.000-12 UNJF	1.625 .615	.9985 .9955	1.249	.527	.381	1.000	.391		.055	.022	.030 .015	.094	.073 .063	1.312	.100	.7547 .7507	.020	.025	.009

- MATERIAL: 6AL-4V TITANIUM ALLOY PER AMS 4928 OR AMS 4967.
- PROCUREMENT SPECIFICATION NAS 621 EXCEPT .562 DIAMETER AND LARGER BOLTS SHALL MEET 150,000 PSI UTS. SHEAR AND FATIGUE TEST DO NOT APPLY TO SIZES SMALLER THAN .1900 DIAMETER. TENISLE REQUIREMENTS FOR THESE DIAMETERS SHALL BE 150,000 PSI MINIMUM.
- FINISH: ANODIZE PER AMS 2488, TYPE 2. ALUMINUM PIGMENTED COATING PER NAS 4006. SEE NOTE 7.
- SHANK TO BE STRAIGHT WITHIN .003 T.I.R. PER INCH OF LENGTH.
- BOLTS SHALL BE FREE FROM BURRS AND SHARP EDGES.
- SURFACE TEXTURE: ASME B46.1-HEAD TO SHANK FILLET, THREAD ROOT, SIDES AND RUNOUT NOT TO EXCEED 16 MICROINCHES. BEARING SURFACE OF HEAD NOT TO EXCEED 63 MICROINCHES.
- PART NUMBER: HITI 205 V H 14 T2 = .3125-24 BOLT, .875 GRIP, 1.438 LENGTH, 6AL-4V TITANIUM ALLOY, CROSSDRILLED HEAD.
 - "T2" = ANODIZE PER AMS 2488, TYPE 2
 - "A" = ALUMINUM PIGMENTED COATING PER NAS 4006
 - = GRIP LENGTH IN SIXTEENTHS
 - "H" = CROSSDRILLED HEAD
 - NO LETTER = UNDRILLED HEAD
 - "V" = TITANIUM MATERIAL
 - = THREAD SIZE PER TABULATION
 - BASIC PART NUMBER
 - LENGTH = GRIP + T REF
- CHAMFER "U" PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES.
- REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT AN INSPECTION REQUIREMENT.
- DIMENSIONS IN INCHES.

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 ±.010 AND ±2°	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M		FSCM NO. 56878	STANDARDS AND SPECIFICATIONS NAS 621 EXCEPT AS NOTED
SURFACE ROUGHNESS 125	UNLESS OTHERWISE NOTED		CUSTODIAN: JENKINTOWN, PA.	PART NUMBER: HITI 200 THRU 216
DRAWN BY: STEVE FOSTER	DATE: 9/28/98	TITLE: BOLT, TENSION, INTERNAL WRENCHING 6AL-4V TITANIUM ALLOY	SHEET 1 OF 1	
APPROVED: L. KLINE	DATE: 9/28/98			
APPROVED: S. HUTCHINSON				

DRAWING NUMBER: **SPS-B-51253**
 ISSUE DATE: 3/30/61
 REVISION: 11
 REVISED AND REDRAWN: 9/8/87 (12), 12/27/90 (13), 1/16/91 (14), 9/28/98 (15)