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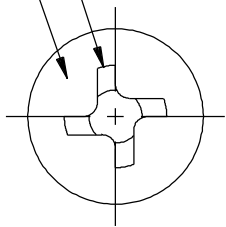
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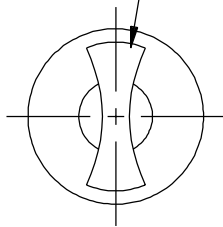
7/21/06

STAMP SFT22 OR SFH22
AND APPLICABLE DASH NUMBER
AND "SPS" AND LOT NUMBER
.010 MAXIMUM DEEP

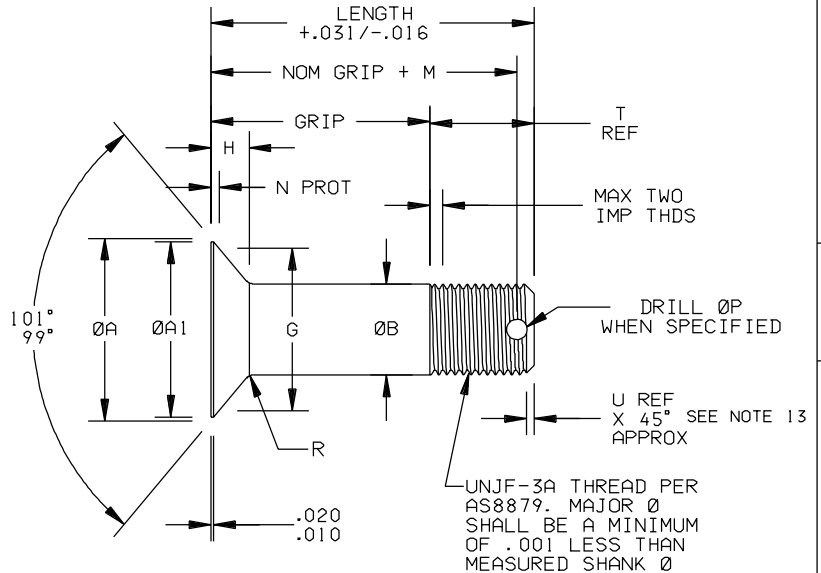
FOR RECESS DIMENSIONS
SEE SHEET 2



TORQ-SET
DRIVE



HI TORQUE
DRIVE



SPS BASIC PART NUMBER		THREAD UNJF-3A	ØA MAX 1/ 2/	ØA1 MIN 2/	ØB		H REF	G +.0002 -.0000	N		M ±.016	P ±.005	R	T REF	U REF
TORQ SET	HI TORQUE				MAX	MIN			MAX	MIN					
SFT22-3	SFH22-3	.1900-32	.385	.325	.1894	.1885	.080	.2830	.0420	.0380	3/	3/	.019	.236	.04
SFT22-4	SFH22-4	.2500-28	.507	.447	.2492	.2483	.106	.4318	.0310	.0264	3/	3/	.025	.293	.04
SFT22-5	SFH22-5	.3125-24	.635	.573	.3117	.3108	.133	.5449	.0371	.0321	.232	.076	.031	.351	.05
SFT22-6	SFH22-6	.3750-24	.762	.698	.3742	.3733	.160	.6580	.0429	.0373	.267	.106	.037	.400	.05
SFT22-7	SFH22-7	.4375-20	.890	.825	.4367	.4358	.188	.7782	.0461	.0401	.341	.106	.043	.466	.06
SFT22-8	SFH22-8	.5000-20	1.017	.950	.4991	.4982	.215	.8900	.0523	.0457	.376	.106	.050	.516	.06
SFT22-9	SFH22-9	.5625-18	1.145	1.076	.5616	.5607	.242	1.0026	.0587	.0517	.471	.141	.056	.590	.07
SFT22-10	SFH22-10	.6250-18	1.272	1.202	.6240	.6230	.270	1.1122	.0659	.0583	.513	.141	.062	.632	.07

1/ TO THEORETICAL SHARP CORNER

2/ ABSOLUTE MINIMUM WITH FLAT

3/ DUE TO SPACE LIMITATIONS COTTER PIN HOLE IS NOT RECOMMENDED ON .190 AND .250 DIAMETER

1. MATERIAL: ALLOY STEEL PER AMS 6487.
2. HEAT TREATMENT: 220 KSI ULTIMATE TENSILE STRENGTH. 132 KSI MINIMUM SHEAR. 46-50 HRC.
3. FINISH: CADMIUM FLUOBORATE PLATE PER NAS 672. CADMIUM FLUOBORATE PLATE PER NAS 672 EXCEPT THICKNESS TO BE .0002 - .0004.
4. MAGNETIC PARTICLE INSPECT 100% PER ASTM E 1444.
5. CONCENTRICITY: CONICAL SURFACE OF HEAD TO BODY WITHIN .003 T.I.R.; BODY TO PITCH DIAMETER WITHIN .0045 FOR .190 THRU AND INCLUDING .375; .006 FOR .437 THRU .625. WHEN HELD ON THE PITCH DIAMETER OF FULL THREADS CLOSEST TO BODY AND CHECKED AT A POINT ON THE BODY WITHIN ONE DIAMETER DISTANCE FROM THE THREAD END OF THE GRIP.
6. HEADS TO BE FORGED.
7. THREADS TO BE ROLLED AFTER HEAT TREATMENT.
8. HEAD TO SHANK FILLET MUST BE COLD WORKED.

9. PART NUMBER: SFT22 D - 6 - A 8 = .375-24 BOLT, PLATING PER NAS 672. .500 GRIP WITHOUT COTTER PIN HOLE

_____ = GRIP LENGTH IN SIXTEENTHS
 _____ A = WITHOUT COTTER PIN HOLE
 _____ NO LETTER = PART WITH COTTER PIN HOLE
 _____ = DIAMETER IN SIXTEENTHS
 _____ D = PLATING PER NAS 672 (.0003-.0005) THICK
 _____ NO LETTER = PLATING PER NAS 672 EXCEPT (.0002 - .0004) THICK
 _____ BASIC PART NUMBER

LONGER LENGTHS THAN SHOWN IN THE TABLE MAY BE SPECIFIED BY THE USE OF WHOLE DASH NUMBERS ONLY.

10. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
11. DIMENSIONS ARE IN INCHES.
12. BREAK ALL SHARP EDGES.
13. CHAMFER "U" PLUS INCOMPLETE THREADS NOT TO EXCEED 2 PITCHES.
14. FOR WEIGHTS SEE SD. 300.52943 OR SD. 301.52943.

TOLERANCES ±.010 AND ±2°	FSCM NO. 56878
SURFACE ROUGHNESS 125	CUSTODIAN: JENKINTOWN, PA.
UNLESS OTHERWISE NOTED	
DRAFTED IN ACCORDANCE WITH ANSI Y14.5M-1982	
DRAWN BY: STEVE FOSTER	DATE: 8/27/91
APPROVED: L KLINE	
APPROVED: F CICCARONE	DATE: 12/6/06

TITLE

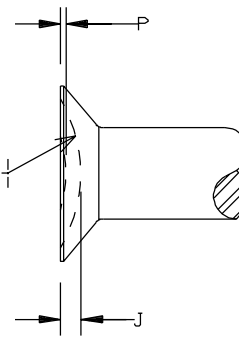
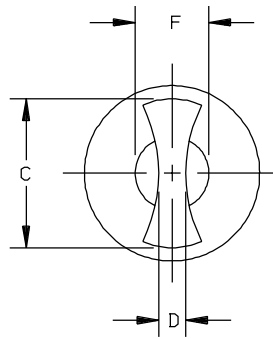
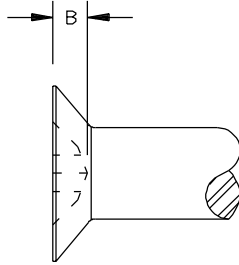
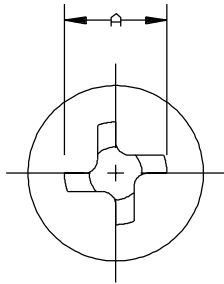
BOLT, SHEAR, FLUSH TYPE
132 KSI MINIMUM SHEAR STRENGTH
ALLOY STEEL PER AMS 6487, APPLICATIONS TO 450°F

STANDARDS AND SPECIFICATIONS
SPS-B-640
APPENDIX 5.9.1

PART NUMBER:

SFT22 / SFH22

SHEET 1 OF 2



TORQ-SET DRIVE

HI TORQUE DRIVE

PART NUMBER		A		B		C REF	D		E ±.005	F		J		P	MINIMUM TORQUE IN. LBS.
		MAX	MIN	MAX	MIN		MAX	MIN		MAX	MIN	MAX	MIN		
SFT22-3	SFH22-3	.248	.238	.090	.080	.305	.064	.060	.281	.156	.146	.045	.042	.014	70
SFT22-4	SFH22-4	.325	.315	.118	.108	.422	.078	.074	.437	.206	.196	.054	.051	.015	175
SFT22-5	SFH22-5	.357	.347	.122	.112	.490	.084	.080	.500	.256	.246	.064	.061	.020	280
SFT22-6	SFH22-6	.427	.417	.145	.135	.639	.100	.096	.625	.306	.294	.088	.084	.022	530
SFT22-7	SFH22-7	.498	.488	.169	.159	.715	.118	.113	.687	.356	.344	.100	.097	.027	910
SFT22-8	SFH22-8	.568	.558	.193	.183	.766	.147	.143	.750	.406	.394	.105	.101	.031	1,400
SFT22-9	SFH22-9	.638	.628	.217	.207	.877	.168	.163	.875	.456	.444	.118	.114	.033	1,950
SFT22-10	SFH22-10	.708	.698	.241	.231	1.020	.188	.183	1.000	.511	.499	.141	.137	.036	2,700

DASH NUMBER	GRIP ±.010	LENGTH +.031 -.016 SFT22 AND SFH22 WITH APPLICABLE DASH NUMBER								
		-3 .190	-4 .250	-5 .312	-6 .375	-7 .437	-8 .500	-9 .562	-10 .625	
3	.1875	.424	.480	.538	.588	.654	.704	.778	.820	
4	.2500	.486	.543	.601	.650	.716	.766	.840	.882	
5	.3125	.548	.606	.664	.712	.778	.828	.902	.945	
6	.3750	.611	.668	.726	.775	.841	.891	.965	1.007	
7	.4375	.674	.730	.788	.838	.904	.954	1.028	1.070	
8	.5000	.736	.793	.851	.900	.966	1.016	1.090	1.132	
9	.5625	.798	.856	.914	.962	1.028	1.078	1.152	1.194	
10	.6250	.861	.918	.976	1.025	1.091	1.141	1.215	1.257	
11	.6875	.924	.980	1.038	1.088	1.154	1.204	1.278	1.320	
12	.7500	.986	1.043	1.101	1.150	1.216	1.266	1.340	1.382	
13	.8125	1.048	1.106	1.164	1.212	1.278	1.328	1.402	1.444	
14	.8750	1.111	1.168	1.226	1.275	1.341	1.391	1.465	1.507	
15	.9375	1.174	1.230	1.288	1.338	1.404	1.454	1.528	1.569	
16	1.0000	1.236	1.293	1.351	1.400	1.466	1.516	1.590	1.632	
17	1.0620	1.298	1.356	1.414	1.462	1.528	1.578	1.652	1.694	
18	1.1250	1.361	1.418	1.476	1.525	1.591	1.641	1.715	1.757	
19	1.1880	1.424	1.480	1.538	1.588	1.654	1.704	1.778	1.820	
20	1.2500	1.486	1.543	1.601	1.650	1.716	1.766	1.840	1.882	
21	1.3120	1.548	1.606	1.664	1.712	1.778	1.828	1.902	1.945	
22	1.3750	1.611	1.668	1.726	1.775	1.841	1.891	1.965	2.007	
23	1.4380	1.674	1.730	1.788	1.838	1.904	1.954	2.028	2.070	
24	1.5000	1.736	1.793	1.851	1.900	1.966	2.016	2.090	2.132	
25	1.5620	1.798	1.856	1.914	1.962	2.028	2.078	2.152	2.194	
26	1.6250	1.861	1.918	1.976	2.025	2.091	2.141	2.215	2.257	
27	1.6880	1.924	1.980	2.038	2.088	2.154	2.204	2.278	2.320	
28	1.7500	1.986	2.043	2.101	2.150	2.216	2.266	2.340	2.382	
29	1.8120	2.048	2.106	2.164	2.212	2.278	2.328	2.402	2.444	
30	1.8750	2.111	2.168	2.226	2.275	2.341	2.391	2.465	2.507	
31	1.9380	2.174	2.230	2.288	2.338	2.404	2.454	2.528	2.569	
32	2.0000	2.236	2.293	2.351	2.400	2.466	2.516	2.590	2.632	
33	2.0620	2.298	2.356	2.414	2.462	2.528	2.578	2.652	2.694	
34	2.1250	2.361	2.418	2.476	2.525	2.591	2.641	2.715	2.757	
35	2.1880	2.424	2.480	2.538	2.588	2.654	2.704	2.778	2.820	
36	2.2500	2.486	2.543	2.601	2.650	2.716	2.766	2.840	2.882	
37	2.3120	2.548	2.606	2.664	2.714	2.778	2.828	2.902	2.945	
38	2.3750	2.611	2.668	2.726	2.775	2.841	2.891	2.965	3.007	
39	2.4380	2.674	2.730	2.788	2.838	2.904	2.954	3.028	3.070	
40	2.5000	2.736	2.793	2.851	2.900	2.966	3.016	3.090	3.132	
41	2.5620	2.798	2.856	2.914	2.962	3.028	3.078	3.152	3.194	
42	2.6250	2.861	2.918	2.976	3.025	3.091	3.141	3.215	3.257	
43	2.6880	2.924	2.980	3.038	3.088	3.154	3.204	3.278	3.320	
44	2.7500	2.986	3.043	3.101	3.150	3.216	3.266	3.340	3.382	
45	2.8120	3.048	3.106	3.164	3.212	3.278	3.328	3.402	3.444	
46	2.8750	3.111	3.168	3.226	3.275	3.341	3.391	3.465	3.507	
47	2.9380	3.174	3.230	3.288	3.338	3.404	3.454	3.528	3.569	
48	3.0000	3.236	3.293	3.351	3.400	3.466	3.516	3.590	3.632	
49	3.0620	3.298	3.356	3.414	3.462	3.528	3.578	3.652	3.694	
50	3.1250	3.361	3.418	3.476	3.525	3.591	3.641	3.715	3.757	
51	3.1880	3.424	3.480	3.538	3.588	3.654	3.704	3.778	3.820	