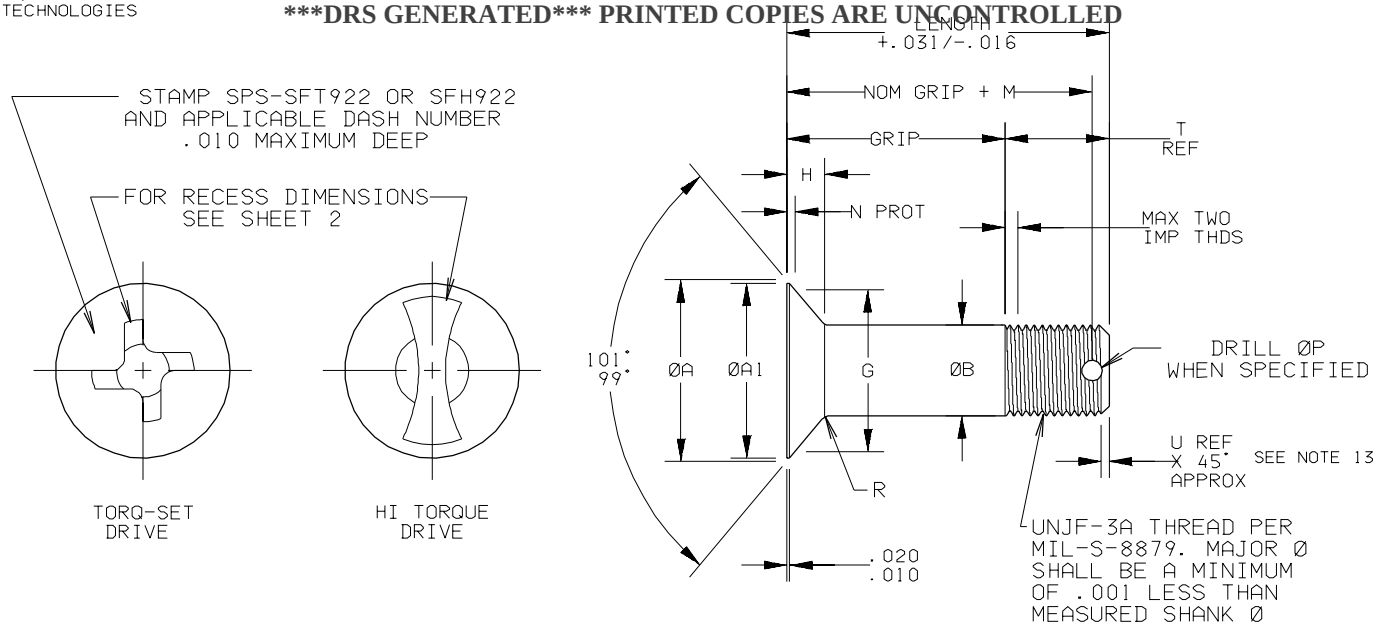


SPS BASIC PART NUMBER		THREAD UNJF-3A	ØA MAX 1/	ØA1 MIN 2/	ØB		H REF	G +.0002 −.0000	N		M ±.016	P ±.005	R	T REF	U REF
TORQ SET	HI TORQUE				MAX	MIN			MAX	MIN					
SFT922-3	SFH922-3	.1900-32	.385	.325	.1894	.1885	.080	.2830	.0420	.0380	3/	3/	.019	.236	.04
SFT922-4	SFH922-4	.2500-28	.507	.447	.2492	.2483	.106	.4318	.0310	.0264			.025	.293	.04
SFT922-5	SFH922-5	.3125-24	.635	.573	.3117	.3108	.133	.5449	.0371	.0321	.232	.076	.031	.351	.05
SFT922-6	SFH922-6	.3750-24	.762	.698	.3742	.3733	.160	.6580	.0429	.0373	.267	.106	.037	.400	.05
SFT922-7	SFH922-7	.4375-20	.890	.825	.4367	.4358	.188	.7782	.0461	.0401	.341	.106	.043	.466	.06
SFT922-8	SFH922-8	.5000-20	1.017	.950	.4991	.4982	.215	.8900	.0523	.0457	.376	.106	.050	.516	.06
SFT922-9	SFH922-9	.5625-18	1.145	1.076	.5616	.5607	.242	1.0026	.0587	.0517	.471	.141	.056	.590	.07
SFT922-10	SFH922-10	.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. HARDNESS RC 46-50.
3. FINISH: DIFFUSED NICKEL CADMIUM PLATE PER AMS 2416 WITH CHROMATE TREATMENT.
4. MAGNETIC PARTICLE INSPECT 100%. ACCEPTANCE STANDARDS OF SPS-B-109.
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: SFT922 - 6 - A 8 = .375-24 BOLT, DIFFUSED NICKEL CADMIUM PLATE PER AMS 2416 WITH CHROMATE TREATMENT, .500 GRIP WITHOUT COTTER PIN HOLE
   - 8 = GRIP LENGTH IN SIXTEENTHS
   - A = WITHOUT COTTER PIN HOLE
   - 6 = DIAMETER IN SIXTEENTHS
   - SFT922 = 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.300.52967 OR SD.301.52967.
15. REQUIREMENTS OF SPEC. SPS-B-640 APPENDIX 5.10.1 - FATIGUE STRENGTH NOT APPLICABLE ON CROSSDRILLED PARTS.

TOLERANCES ±.010 AND ±2°
SURFACE ROUGHNESS 125√
UNLESS OTHERWISE NOTED
DRAWN: STEVE FOSTER DATE: 9/03/91
APPROVED: L.KLINE DATE: 6/9/94
APPROVED: R.WAELTZ

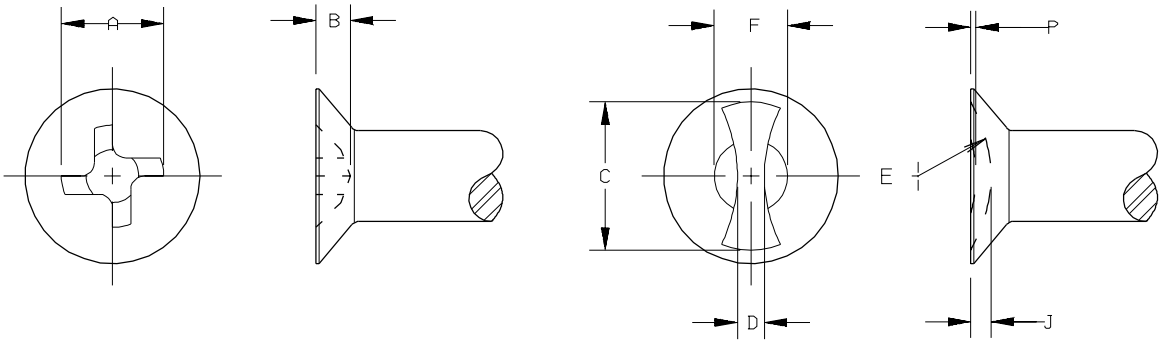
SPS TECHNOLOGIES

FSCM NO. 56878
CUSTODIAN: JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS
SPS-B-640
APPENDIX 5.10.1

TITLE
BOLT, SHEAR, FLUSH TYPE
132 KSI MINIMUM SHEAR STRENGTH
ALLOY STEEL PER AMS 6487, APPLICATIONS TO 900°F

PART NUMBER: SFT922 / SFH922



TORQ-SET DRIVE

HI TORQUE DRIVE

PART NUMBER		A		B		C	D		E	F		J		P	MINIMUM TORQUE IN. LBS.
		MAX	MIN	MAX	MIN	REF	MAX	MIN	±.005	MAX	MIN	MAX	MIN		
SFT922-3	SFH922-3	.248	.238	.090	.080	.305	.064	.060	.281	.156	.146	.045	.042	.014	70
SFT922-4	SFH922-4	.325	.315	.118	.108	.422	.078	.074	.437	.206	.196	.054	.051	.015	175
SFT922-5	SFH922-5	.357	.347	.122	.112	.490	.084	.080	.500	.256	.246	.064	.061	.020	280
SFT922-6	SFH922-6	.427	.417	.145	.135	.639	.100	.096	.625	.306	.294	.088	.084	.022	530
SFT922-7	SFH922-7	.498	.488	.169	.159	.715	.118	.113	.687	.356	.344	.100	.097	.027	910
SFT922-8	SFH922-8	.568	.558	.193	.183	.766	.147	.143	.750	.406	.394	.105	.101	.031	1,400
SFT922-9	SFH922-9	.638	.628	.217	.207	.877	.168	.163	.875	.456	.444	.118	.114	.033	1,950
SFT922-10	SFH922-10	.708	.698	.241	.231	1.020	.188	.183	1.000	.511	.499	.141	.137	.036	2,700

DASH NUMBER	GRIP ±.010	LENGTH +.031 -.016 SFT922 AND SFH922 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