



MARK SPS EWSB922 AND APPLICABLE FIRST DASH NUMBER AND LOT NUMBER .010 MAX DEEP

TOL X B SEE NOTE 5

-B- TOL Z A SEE NOTE 6

SPS PART NUMBER	THREAD	ØB	C MIN	ØD ±.016	H	M ±.016	P ±.005	R	T REF	U REF	W	X	Z
EWSB922-3	.1900-32	.1894/.1885	.419	.375	.140	✓	✓	.019	.236	.04	.376/.367	.005	.0045
EWSB922-4	.2500-28	.2492/.2483	.491	.438	.164			.025	.293	.04	.439/.430	.005	.0045
EWSB922-5	.3125-24	.3117/.3108	.561	.500	.187	.232	.076	.031	.351	.05	.502/.492	.006	.0045
EWSB922-6	.3750-24	.3742/.3733	.631	.562	.210	.267	.106	.037	.400	.05	.564/.553	.008	.0045
EWSB922-7	.4375-20	.4367/.4358	.775	.687	.257	.341	.106	.043	.466	.06	.689/.678	.009	.0060
EWSB922-8	.5000-20	.4991/.4982	.846	.750	.281	.376	.106	.050	.516	.06	.752/.741	.010	.0060
EWSB922-9	.5625-18	.5616/.5607	.987	.875	.328	.471	.141	.056	.590	.07	.877/.865	.011	.0060
EWSB922-10	.6250-18	.6240/.6230	1.059	.938	.350	.513	.141	.062	.632	.07	.940/.928	.012	.0060

✓ DUE TO SPACE LIMITATIONS COTTER PIN HOLE IS NOT RECOMMENDED ON .190 AND .250 DIAMETERS

- MATERIAL: ALLOY STEEL PER AMS 6487.
- HEAT TREATMENT: 220 KSI MINIMUM ULTIMATE STRENGTH. 132 KSI MINIMUM SHEAR STRENGTH. HRC 46-50.
- FINISH: DIFFUSED NICKEL CADMIUM PLATING PER AMS 2416 WITH CHROMATE TREATMENT.
- MAGNETIC PARTICLE INSPECTION 100%. ACCEPTANCE STANDARDS OF SPS-B-109.
- WHEN HELD IN A "V" BLOCK EQUAL TO OR LONGER THAN THE GRIP LENGTH.
- WHEN HELD ON P.D. OF FULL THREADS CLOSEST TO THE BODY AND CHECKED AT A POINT ON THE BODY WITHIN ONE DIAMETER DISTANCE FROM THE THREAD END OF THE GRIP.
- PART NUMBER: EWSB922 - 5 - A 24 = .3125-24 X 1.851 BOLT, 1.500 GRIP, WITHOUT COTTER PIN HOLE, WITH DIFFUSED NICKEL CADMIUM PLATE PER AMS 2416 WITH CHROMATE TREATMENT
 = GRIP LENGTH IN SIXTEENTHS
 A = NO COTTER PIN HOLE
 NO LETTER = COTTER PIN HOLE
 = DIAMETER IN SIXTEENTHS
 BASIC PART NUMBER
- REQUIREMENTS: HEAD TO SHANK FILLET MUST BE COLD WORKED. ROLL THREADS AFTER HEAT TREAT.
- REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
- FOR USE WITH SPS EWSN922 SERIES NUTS.
- DIMENSIONS ARE IN INCHES.
- FOR WEIGHTS SEE SPS SD. 301.52968.
- CHAMFER "U" PLUS INCOMPLETE THREADS NOT TO EXCEED 2 PITCHES.
- REQUIREMENTS OF SPEC. SPS-B-640 APPENDIX 5.10.2 - FATIGUE STRENGTH NOT APPLICABLE ON CROSSDRILLED PARTS.

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TOLERANCES ±.010 AND ±2'
 SURFACE ROUGHNESS 125/
 UNLESS OTHERWISE NOTED
 DRAWN: STEVE FOSTER DATE: 8/29/91
 APPROVED: L KLINE DATE: 6/9/94
 APPROVED: R WAELTZ

SPS
TECHNOLOGIES
 TITLE
 BOLT, SHEAR, PROTRUDING TYPE
 132 KSI MINIMUM SHEAR STRENGTH
 ALLOY STEEL PER AMS6487, APPLICATIONS TO 900°F

FSCM NO. 56878
 STANDARDS AND SPECIFICATIONS
 SPS-B-640
 APPENDIX 5.10.2
 PART NUMBER: **EWSB922**
 SHEET 1 OF 1 PROJECT 56A17