



DRAWING NUMBER
SPS-B-54526

ISSUE DATE
2/24/59

REVISION

(15)

12/03/90

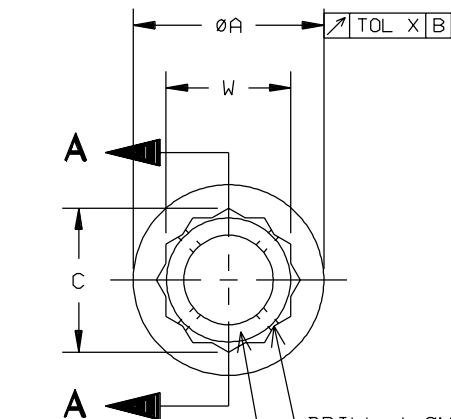
REVISED AND REDRAWN

(16)

8/4/98

(17)

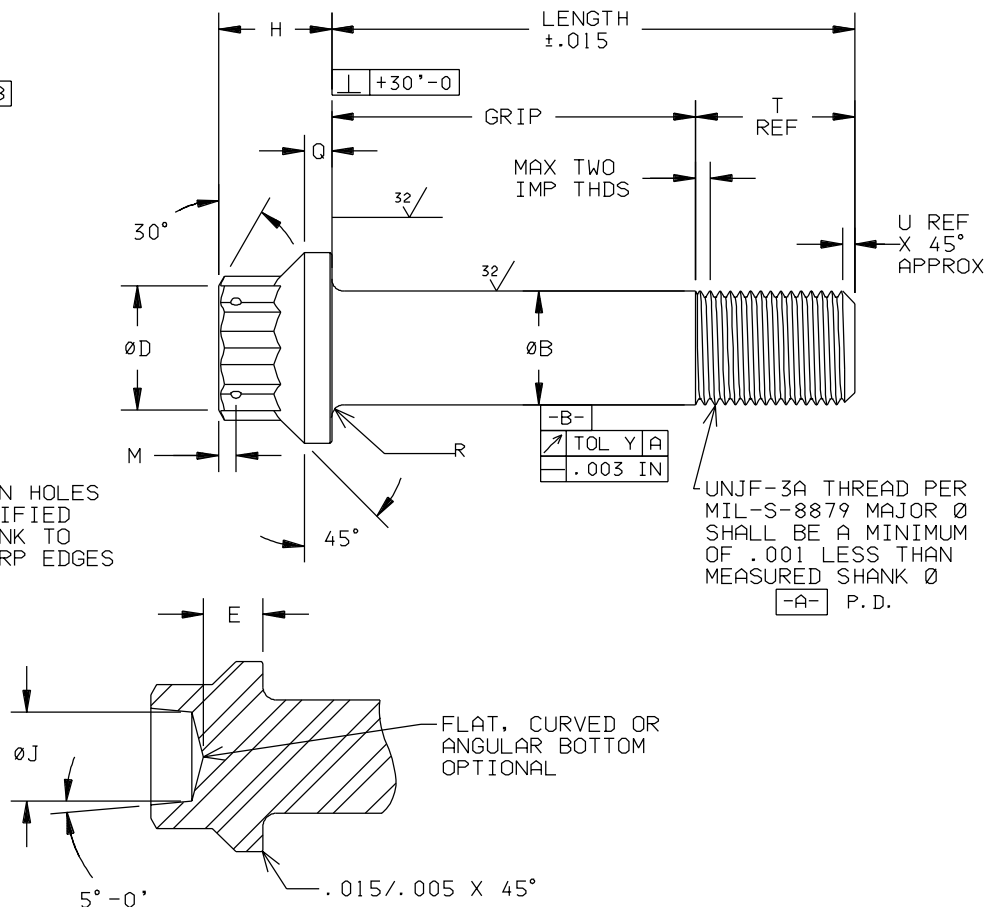
2/5/02



STAMP SPS LWB 922
AND APPLICABLE
FIRST DASH NUMBER
AND LOT NUMBER
.010 MAXIMUM DEEP

DRILL 4 ØN HOLES
WHEN SPECIFIED
COUNTERSINK TO
BREAK SHARP EDGES

SECTION A-A



UNJF-3A THREAD PER
MIL-S-8879 MAJOR Ø
SHALL BE A MINIMUM
OF .001 LESS THAN
MEASURED SHANK Ø
-A- P.D.

FLAT, CURVED OR
ANGULAR BOTTOM
OPTIONAL

SPS PART NUMBER	THREAD UNJF-3A	ØA ±.005	ØB	C MIN	ØD +.000 -.015	E MIN	H ±.010	ØJ +.010 -.030	M ±.010	N ±.005	Q ±.010	R	T REF	U REF	W	X	Y
LWB922-3	.1900-32	.345	.1895 .1885	.277	.250	.092	.275	.125	.062	.037	.064	.041 .031	.344	.04	.251 .243	.005	.0045
LWB922-4	.2500-28	.433	.2495 .2485	.347	.312	.135	.300	.180	.062	.037	.069	.041 .031	.412	.04	.313 .304	.005	.0045
LWB922-5	.3125-24	.526	.3120 .3110	.419	.375	.162	.348	.215	.070	.055	.082	.041 .031	.480	.05	.376 .367	.006	.0045
LWB922-6	.3750-24	.644	.3745 .3735	.491	.437	.197	.388	.260	.070	.055	.091	.057 .047	.560	.05	.439 .430	.008	.0045
LWB922-7	.4375-20	.745	.4370 .4360	.561	.500	.228	.435	.320	.070	.055	.099	.057 .047	.665	.06	.502 .492	.009	.0060
LWB922-8	.5000-20	.823	.4995 .4985	.631	.562	.254	.504	.380	.094	.055	.123	.057 .047	.761	.06	.564 .553	.010	.0060
LWB922-9	.5625-18	.933	.5615 .5605	.703	.625	.287	.557	.440	.094	.055	.133	.057 .047	.828	.07	.627 .616	.011	.0060
LWB922-10	.6250-18	1.045	.6240 .6230	.775	.687	.327	.618	.500	.094	.055	.150	.073 .063	.868	.07	.690 .679	.012	.0060
LWB922-12	.7500-16	1.225	.7490 .7480	.917	.812	.380	.711	.570	.094	.055	.178	.073 .063	1.009	.08	.814 .803	.015	.0060
LWB922-14	.8750-14	1.433	.8740 .8730	1.059	.937	.438	.808	.650	.125	.055	.198	.073 .063	1.175	.09	.940 .928	.018	.0090
LWB922-16	1.0000-12	1.620	.9990 .9980	1.200	1.062	.493	.923	.740	.125	.055	.222	.073 .063	1.345	.10	1.064 1.052	.020	.0090
LWB922-16A	1.0000-14*	1.620	.9990 .9980	1.200	1.062	.493	.923	.740	.125	.055	.222	.073 .063	1.309	.09	1.064 1.052	.020	.0090
LWB922-18	1.1250-12	1.870	1.1240 1.1225	1.414	1.250	.556	1.051	.840	.125	.055	.258	.073 .063	1.515	.10	1.252 1.239	.022	.0090
LWB922-20	1.2500-12	2.120	1.2490 1.2475	1.484	1.312	.636	1.155	.950	.125	.055	.269	.089 .077	1.665	.10	1.314 1.301	.025	.0090
LWB922-22	1.3750-12	2.308	1.3740 1.3725	1.628	1.437	.698	1.266	1.070	.188	.055	.274	.089 .077	1.815	.10	1.440 1.427	.028	.0120
LWB922-24	1.5000-12	2.495	1.4990 1.4975	1.842	1.625	.750	1.434	1.200	.188	.055	.335	.089 .077	2.015	.10	1.627 1.614	.030	.0120

* = UNJS-3A

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TOLERANCES ±.010 AND ±2°
SURFACE ROUGHNESS 125
UNLESS OTHERWISE NOTED
DRAWN BY: STEVE FOSTER
APPROVED: L. KLINE
APPROVED: S. FOSTER

THIS
PRODUCT DRAWING
IS DRAFTED
IN ACCORDANCE
WITH ASME Y14.5M
DATE: 8/4/98
DATE: 2/18/02



FSCM NO. 56878
CUSTODIAN:
JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS
SPS-B-640
APPENDIX 5.2

TITLE
BOLT, 12 POINT, TENSION, LIGHTWEIGHT
220 KSI MINIMUM TENSILE STRENGTH
APPLICATIONS TO 900°F

PART NUMBER: **LWB 922**
SHEET 1 OF 2
ER-020

1. MATERIAL: ALLOY STEEL PER AMS 6487.
2. HEAT TREATMENT: 220 KSI MINIMUM ULTIMATE TENSILE STRENGTH.
46-50 HRC.
3. FINISH: DIFFUSED NICKEL-CADMIUM PLATE PER AMS 2416 WITH CHROMATE TREATMENT.
4. MAGNETIC PARTICLE INSPECT 100% PER ASTM E 1444.
5. REQUIREMENTS: HEAD OF BOLT TO BE FORGED.
LIGHTENING HOLE IN HEAD MAY BE FORGED OR DRILLED.
THREAD SHALL BE ROLLED AFTER HEAT TREAT.
HEAD TO SHANK FILLET TO BE COLD WORKED.
6. PART NUMBER: **LWB 922 - 4 H - 8HDW** = .250-28 BOLT, .912 LONG, .500 GRIP, CROSSDRILLED HEAD, DIFFUSED NICKEL-CADMIUM PLATE PER AMS 2416 WITH CHROMTE TREATMENT.
 - = HEAD DYED WHITE
 - = GRIP LENGTH IN SIXTEENTHS
 - "H" = CROSSDRILLED HEADS
NO LETTER = NO CROSSDRILLED HEADS
 - = NOMINAL DIAMETER IN SIXTEENTHS
 - BASIC PART NUMBER
7. BREAK SHARP EDGES .005-.015 X 45°.
8. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
9. CHAMFER "U" REF X 45° APPROX. PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES.
10. DIMENSIONS ARE IN INCHES.