



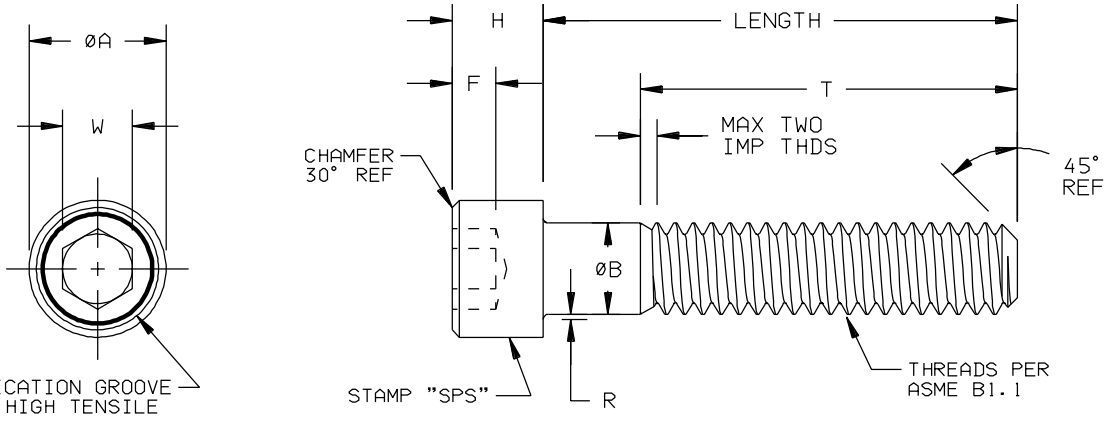
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DRAWING NUMBER
SPS-B-56350

ISSUE DATE
 11/23/60

REVISION
 (1)

(1) 12/23/99 REVISED AND REDRAWN
 (2) 5/4/2000
 (3) 3/12/2001
 (4) 10/13/04



BASIC PART NUMBER AND DASH NUMBER	THREAD SIZE	ØA MAX MIN	ØB MAX MIN	F MIN	H MAX MIN	R MAX MIN	T MIN	W MAX MIN	MAXIMUM LENGTH
KS812-836	.1640-36 UNRF-3A	.270	.1640	.077	.164	.012	.875	.1426	1.500
KS812-832	.1640-32 UNRC-3A	.262	.1585		.159	.007		.1406	
KS812-1032	.1900-32 UNRF-3A	.312	.1900	.090	.190	.014	.875	.1587	2.000
KS812-1024	.1900-24 UNRC-3A	.303	.1840		.185	.009		.1562	
KS812-428	.2500-28 UNRF-3A	.375	.2500	.120	.250	.014	1.000	.1900	2.500
KS812-420	.2500-20 UNRC-3A	.365	.2435		.244	.009		.1875	
KS812-524	.3125-24 UNRF-3A	.468	.3125	.151	.312	.017	1.125	.2530	3.000
KS812-518	.3125-18 UNRC-3A	.457	.3053		.306	.012		.2500	
KS812-624	.3750-24 UNRC-3A	.562	.3750	.182	.375	.020	1.250	.3160	3.250
KS812-618	.3750-18 UNRC-3A	.550	.3678		.368	.015		.3125	

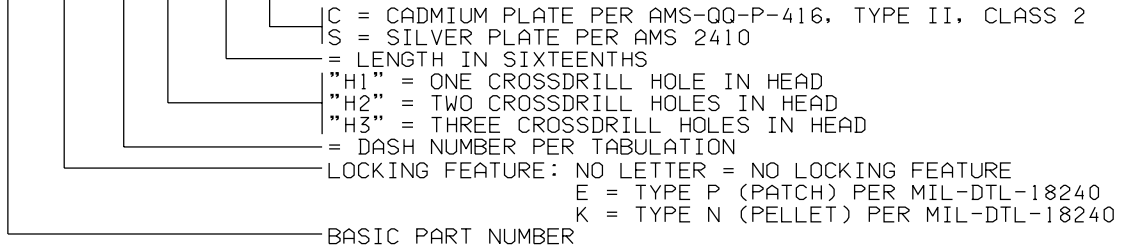
BASIC PART NUMBER AND DASH NUMBER	TENSILE STRENGTH LBS. MIN.		DOUBLE SHEAR STRENGTH LBS. (REF ONLY)	RECOMMENDED SEATING TORQUES INCH LBS.	
	UNRC	UNRF		UNRC	UNRF
KS812-836 KS812-832	1,750	1,840	3,160	31	33
KS812-1032 KS812-1024	2,190	2,500	4,260	45	51
KS812-428 KS812-420	3,980	4,550	7,360	107	123
KS812-524 KS812-518	6,550	7,250	11,500	221	245
KS812-624 KS812-618	9,690	10,980	16,560	392	445

THE TENSILE STRENGTH IS BASED ON 125 KSI STRESS LEVEL AND THE AREA PER ASME B1.1.

LENGTH TOLERANCE

UP TO 1" INCL.	OVER 1" TO 2-1/2" INCL.	OVER 2-1/2" TO 6" INCL.
-.030/+0	-.040/+0	-.060/+0

1. MATERIAL: AUSTENITIC STAINLESS STEEL.
2. HEAT TREATMENT: 125 KSI MINIMUM ULTIMATE TENSILE STRENGTH. 80 KSI MINIMUM YIELD STRENGTH.
3. FLUORESCENT PENETRANT INSPECT PER ASTM E1417.
4. DIMENSIONS AND GEOMETRIC TOLERANCING PER ASME B18.3.
5. PART NUMBER: KS812()-()-()-()-()



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: 12/23/99
APPROVED: S FOSTER	DATE: 10/26/04
APPROVED: F CICCARONE	

TITLE
 SHCS, HEXAGON RECESS
 AUSTENITIC STAINLESS STEEL
 125 KSI UTS

STANDARDS AND SPECIFICATIONS FF-S-86 EXCEPT AS NOTED
PART NUMBER: KS812()-()-()-()-()
SHEET 1 OF 1