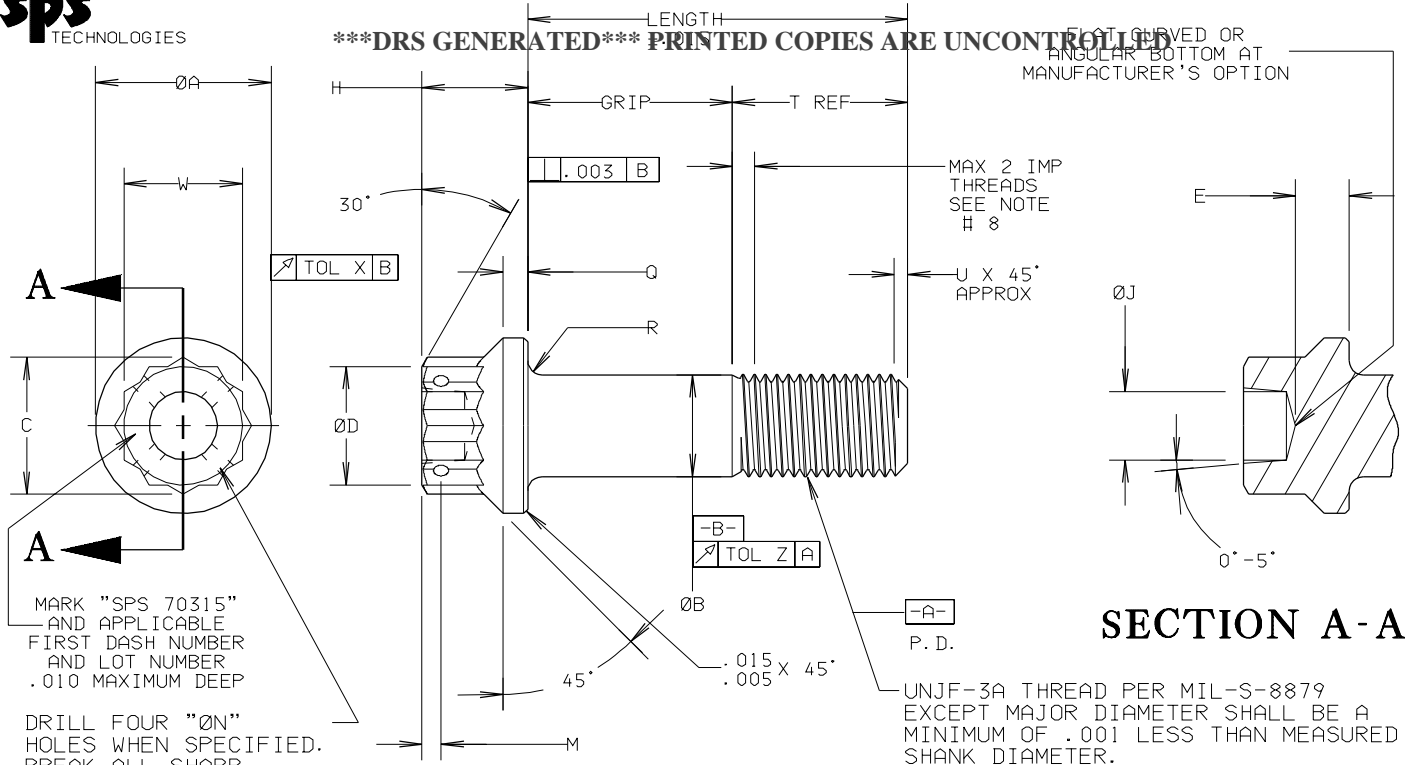


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FLOT CURVED OR ANGULAR BOTTOM AT MANUFACTURER'S OPTION



MARK "SPS 70315" AND APPLICABLE FIRST DASH NUMBER AND LOT NUMBER .010 MAXIMUM DEEP

DRILL FOUR "ØN" HOLES WHEN SPECIFIED. BREAK ALL SHARP OUTSIDE EDGES.

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

BASIC PART NO.	THREADS UNJF-3A	ØA ±.005	ØB			C MIN	ØD	E MIN	H	ØJ +.010 - .030	M ±.005	N ±.005	Q	R	T REF	U REF	W MAX MIN	X TIR	Z TIR
			NOM Ø	.0156 O/S	.03125 O/S														
70315-3	.1900-32	.364	.1895 .1885	.2051 .2041	.2208 .2198	.277	.250 .235	.098	.214	.156	.062	.055	.040	.041 .031	.419	.040	.251 .243	.005	.0045
70315-4	.2500-28	.470	.2495 .2485	.2651 .2641	.2808 .2798	.347	.312 .297	.135	.254	.180	.062	.055	.042	.041 .031	.531	.040	.313 .304	.005	.0045
70315-5	.3125-24	.580	.3120 .3110	.3276 .3266	.3433 .3423	.419	.375 .360	.162	.319	.215	.070	.070	.050	.041 .031	.611	.050	.376 .367	.006	.0045
70315-6	.3750-24	.720	.3745 .3735	.3901 .3891	.4058 .4048	.561	.500 .485	.197	.405	.297	.070	.070	.075	.057 .047	.707	.050	.502 .492	.008	.0045
70315-7	.4375-20	.825	.4370 .4360	.4526 .4516	.4683 .4673	.631	.562 .547	.228	.464	.320	.070	.070	.083	.057 .047	.814	.060	.564 .553	.009	.0045
70315-8	.5000-20	.945	.4995 .4985	.5151 .5141	.5308 .5298	.703	.625 .610	.254	.530	.380	.094	.070	.098	.057 .047	.926	.060	.627 .616	.010	.0060
70315-9	.5625-18	1.050	.5615 .5605	.5771 .5761	.5928 .5918	.846	.750 .735	.287	.600	.440	.094	.070	.118	.073 .063	1.025	.070	.752 .741	.011	.0060
70315-10	.6250-18	1.190	.6240 .6230	.6396 .6386	.6553 .6543	.917	.812 .797	.327	.673	.469	.094	.070	.125	.073 .063	1.152	.070	.814 .803	.012	.0060
70315-12	.7500-16	1.420	.7490 .7480	.7646 .7636	.7803 .7793	1.059	.937 .922	.380	.806	.570	.094	.070	.152	.073 .063	1.314	.080	.940 .928	.015	.0060

FOR PARTS ABOVE Ø.750 REFER TO SPS-B-92432

1. MATERIAL: MP35N ALLOY PER AMS 5844.
2. HEAT TREATMENT: 260,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH. 145,000 PSI MINIMUM SHEAR.
3. FINISH: PLAIN OR CADMIUM PLATED PER AMS 2400(SEE PART NUMBER CODE NOTE 5).
4. FLUORESCENT PENETRANT INSPECT 100% PER ASTM E 1417, ACCEPTANCE CRITERIA PER SPS-I-650.
5. PART NUMBER: 70315 X 6 H - 12 C

"C" = CADMIUM PLATE
NO LETTER = PLAIN

GRIP IN 1/16 INCREMENTS

"H" = CROSS DRILLED HOLES IN HEAD
"- " = NO CROSS HOLES

NOMINAL BOLT DIAMETER IN SIXTEENTHS

"X" = .0156 OVERSIZE BODY DIAMETER
"Y" = .0312 OVERSIZE BODY DIAMETER
"- " = STANDARD BODY DIAMETER

BASIC PART NUMBER
LENGTH = NOMINAL GRIP PLUS "T"

6. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT AN INSPECTION REQUIREMENT.
7. CHAMFER "U" X 45° APPROX. CHAMFER PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES.
8. FOR "X" AND "Y" OVERSIZE PARTS, MAX THREAD RUNOUT TO BE 3 IMP. THREADS.
9. THESE BOLTS ARE DESIGNED TO BE USED WITH COMPANION NUT EWNM 26 PRODUCED TO DRAWING, SPS-N-70538.

MP35N IS A REGISTERED TRADEMARK OF SPS TECHNOLOGIES.

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TOLERANCES ±.010 AND ±2'	SPS TECHNOLOGIES	FSCM NO. 56878	STANDARDS AND SPECIFICATIONS SPS-B-640 APPENDIX 6.5
SURFACE ROUGHNESS 125/ UNLESS OTHERWISE NOTED		CUSTODIAN: JENKINTOWN, PA.	
DRAWN: STEVE FOSTER DATE: 11/30/88	TITLE BOLT, TENSION, EXTERNAL WRENCHING, 260,000 PSI MINIMUM TENSILE STRENGTH, TEMP. TO 450°F (PLATED), 700°F (UNPLATED) MP35N MATERIAL		PART NUMBER: 70315-()-()
APPROVED: L KLINE DATE: 7/8/97			SHEET 1 OF 1 PROJECT 7215
APPROVED: R HUKARI			