



STAMP SPS 71788 AND APPLICABLE FIRST DASH NUMBER AND LOT NUMBER

SPS PART NUMBER	THREAD UNJF-3A	ØA ±.005	ØB	C MIN	ØD +.000 - .015	E MIN	H ±.010	ØJ +.010 - .030	G ±.010	R	T REF	U REF	W	X	Y
71788-3	.1900-32	.345	.1895 .1885	.277	.250	.092	.196	.125	.064	.041 .031	.353	.04	.251 .243	.005	.0045
71788-4	.2500-28	.433	.2495 .2485	.347	.312	.135	.234	.180	.069	.041 .031	.431	.04	.313 .304	.005	.0045
71788-5	.3125-24	.526	.3120 .3110	.419	.375	.162	.276	.215	.082	.041 .031	.500	.05	.376 .367	.006	.0045
71788-6	.3750-24	.644	.3745 .3735	.491	.437	.197	.322	.260	.091	.057 .047	.583	.05	.439 .430	.008	.0045
71788-7	.4375-20	.745	.4370 .4360	.561	.500	.228	.355	.320	.099	.057 .047	.665	.06	.502 .492	.009	.0045
71788-8	.5000-20	.823	.4995 .4985	.631	.562	.254	.401	.380	.123	.057 .047	.789	.06	.564 .553	.010	.0060
71788-9	.5625-18	.933	.5615 .5605	.703	.625	.287	.444	.440	.133	.057 .047	.859	.07	.627 .616	.011	.0060
71788-10	.6250-18	1.045	.6240 .6230	.775	.687	.327	.494	.500	.150	.073 .063	.901	.07	.690 .679	.012	.0060
71788-12	.7500-16	1.225	.7490 .7480	.917	.812	.380	.566	.570	.178	.073 .063	1.050	.08	.814 .803	.015	.0060

- MATERIAL: ALLOY STEEL PER AMS 6487.
- HEAT TREATMENT: 260 KSI MINIMUM ULTIMATE TENSILE STRENGTH. RC 51-54.
- FINISH: DIFFUSED NICKEL-CADMIUM PLATE PER AMS 2416 WITH CHROMATE TREATMENT FOR 900°F APPLICATION. VACUUM CADMIUM PLATE PER MIL-C-8837, TYPE II, CLASS 2 FOR 450°F APPLICATION. ALUMINUM COATING, CERAMIC BONDED PER AMS 2506, WITH CETYL ALCOHOL LUBRICANT.
- MAGNETIC PARTICLE INSPECT PER MIL-STD-1949. ACCEPTANCE CRITERIA PER SPS-I-650.
- REQUIREMENTS: HEAD TO BE FORGED
LIGHTENING HOLE IN HEAD MAY BE FORGED OR DRILLED
THREADS TO BE ROLLED AFTER HEAT TREATMENT
HEAD TO SHANK FILLET TO BE COLD WORKED
- PART NUMBER: 71788 W - 4 - 10 = .2500-28 ASYMMETRIC BOLT, .625 GRIP, 1.056 LONG WITH ALUMINUM COATING
 - "L" = GRIP LENGTH IN SIXTEENTHS
 - "G" = NOMINAL DIAMETER IN SIXTEENTHS
 - "W" = VACUUM CADMIUM PLATING
 - "X" = ALUMINUM COATING
 - BASIC PART NUMBER - USE BASIC PART NUMBER TO DENOTE DIFFUSED NICKEL CADMIUM PLATING
- THESE BOLTS ARE DESIGNED TO BE USED WITH A HARD STEEL WASHER UNDER HEAD AND ALSO UNDER MATING NUT. USE 69678 FOR 450°F APPLICATION.
- FOR WEIGHTS SEE SD. 300.71788.

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TOLERANCES ±.010 AND ±2'	SPS TECHNOLOGIES	FSCM NO. 56878	STANDARDS AND SPECIFICATIONS SPS-B-640 APPENDIX 6.4
SURFACE ROUGHNESS 125/ UNLESS OTHERWISE NOTED		CUSTODIAN: JENKINTOWN, PA.	
DRAWN: STEVE FOSTER DATE: 11/29/90	TITLE	BOLT, 12 POINT, TENSION, LIGHTWEIGHT 260 KSI MINIMUM TENSILE STRENGTH ASYMMETRIC THREADS	
APPROVED: L. KLINKE DATE: 12/18/90		PART NUMBER:	71788 - []
APPROVED: TAR		SHEET 1 OF 1	PROJECT 55A22