



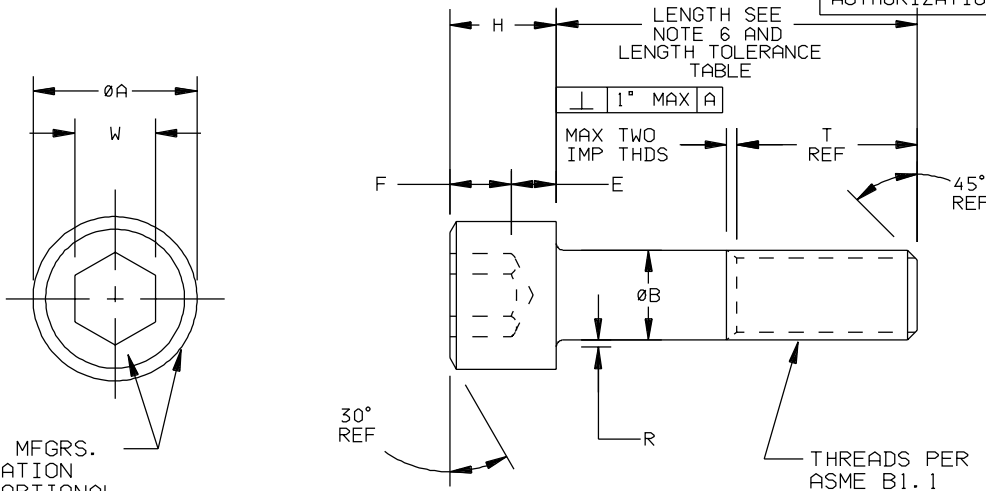
PROPRIETARY INFORMATION
 INFORMATION ON THIS DOCUMENT IS A
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DRAWING NUMBER
SPS-B-73015

ISSUE DATE
 4/28/89

REVISION

⑤ 7/23/98
 ⑥ 3/21/01
 ⑦ 3/10/03



MARK SPS' MFGRS.
 IDENTIFICATION
 LOCATION OPTIONAL

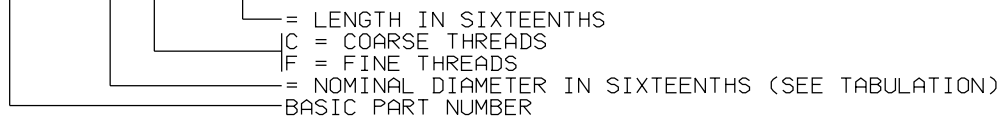
DASH NUMBER	THREADS CLASS 3A	ØA	ØB	E MIN	F MIN	H	R FILLET EXT	T REF	W NOM	ULTIMATE TENSILE STRENGTH LBS. MIN.
3	.190-24 UNRC	.312	.190	.065	.090	.190	.014	.875	.1562	3,200
	.190-32 UNRF	.303	.184			.185	.009			3,600
4	.250-20 UNRC	.375	.250	.095	.120	.250	.014	1.000	.1875	5,700
	.250-28 UNRF	.365	.2435			.244	.009			6,500
5	.312-18 UNRC	.469	.3125	.119	.151	.312	.017	1.125	.2500	9,400
	.312-24 UNRF	.457	.3053			.306	.012			10,400
6	.375-16 UNRC	.562	.375	.143	.182	.375	.020	1.250	.3125	13,900
	.375-24 UNRF	.550	.3678			.368	.015			15,800
7	.437-14 UNRC	.656	.4375	.166	.213	.438	.023	1.375	.3750	19,100
	.437-20 UNRF	.642	.4294			.430	.018			21,400
8	.500-13 UNRC	.750	.500	.190	.245	.500	.026	1.500	.3750	25,500
	.500-20 UNRF	.735	.4919			.492	.020			28,800
10	.625-11 UNRC	.938	.625	.238	.307	.625	.032	1.750	.5000	40,700
	.625-18 UNRF	.921	.6163			.616	.024			46,100
12	.750-10 UNRC	1.125	.750	.285	.370	.750	.039	2.000	.6250	60,100
	.750-16 UNRF	1.107	.7406			.740	.030			67,100
14	.875-9 UNRC	1.312	.875	.333	.432	.875	.044	2.250	.7500	83,200
	.875-14 UNRF	1.293	.8647			.864	.034			91,600
16	1.000-8 UNRC	1.500	1.000	.380	.495	1.000	.050	2.500	.7500	109,000
	1.000-12 UNRF	1.479	.9886			.988	.040			119,000

THE TENSILE STRENGTH IS BASED ON 180 KSI STRESS LEVEL AT ROOM TEMPERATURE AND TENSILE STRESS AREA PER ASME B1.1

LENGTH TOLERANCE

DIAMETER	UP TO 1" INCL.	OVER 1" TO 2-1/2" INCL.	OVER 2-1/2" TO 6" INCL.	OVER 6"
.190 THRU .375	-.030	-.040	-.060	-.120
.437 THRU .750	-.030	-.060	-.080	-.120
OVER .750	-.050	-.100	-.140	-.200

- MATERIAL: ALLOY STEEL PER AMS 6304 OR AMS 6305.
- HEAT TREATMENT: 38-43 HRC.
- FINISH: THERMAL OXIDE (BLACK) PLUS RUST PREVENTITIVE OIL.
- DIMENSIONS AND GEOMETRIC TOLERANCING PER ASME B18.3 - INCLUDING MANUFACTURING NOTES NOT LISTED IN THIS DRAWING.
- MANUFACTURING REQUIREMENTS: HEAD TO BE FORGED.
 THREADS TO BE ROLLED.
 SOCKET MAY BE FORGED OR MACHINED.
- PART NUMBER: 73015 - () () - ()



TOLERANCES ±.010 AND ±2°	FSCM NO. 56878
SURFACE ROUGHNESS 125/√	CUSTODIAN: JENKINTOWN, PA.
UNLESS OTHERWISE NOTED	
DRAFTED IN ACCORDANCE WITH ASME Y14.5M	
DRAWN BY: STEVE FOSTER	DATE: 7/23/98
APPROVED: S FOSTER	
APPROVED: L KLINE	DATE: 3/12/03

TITLE
 BOLT, SHCS, HEX RECESS
 ALLOY STEEL
 APPLICATIONS TO 1,000°F.

STANDARDS AND SPECIFICATIONS FF-S-86 EXCEPT AS NOTED
PART NUMBER: 73015-() () - ()
SHEET 1 OF 1