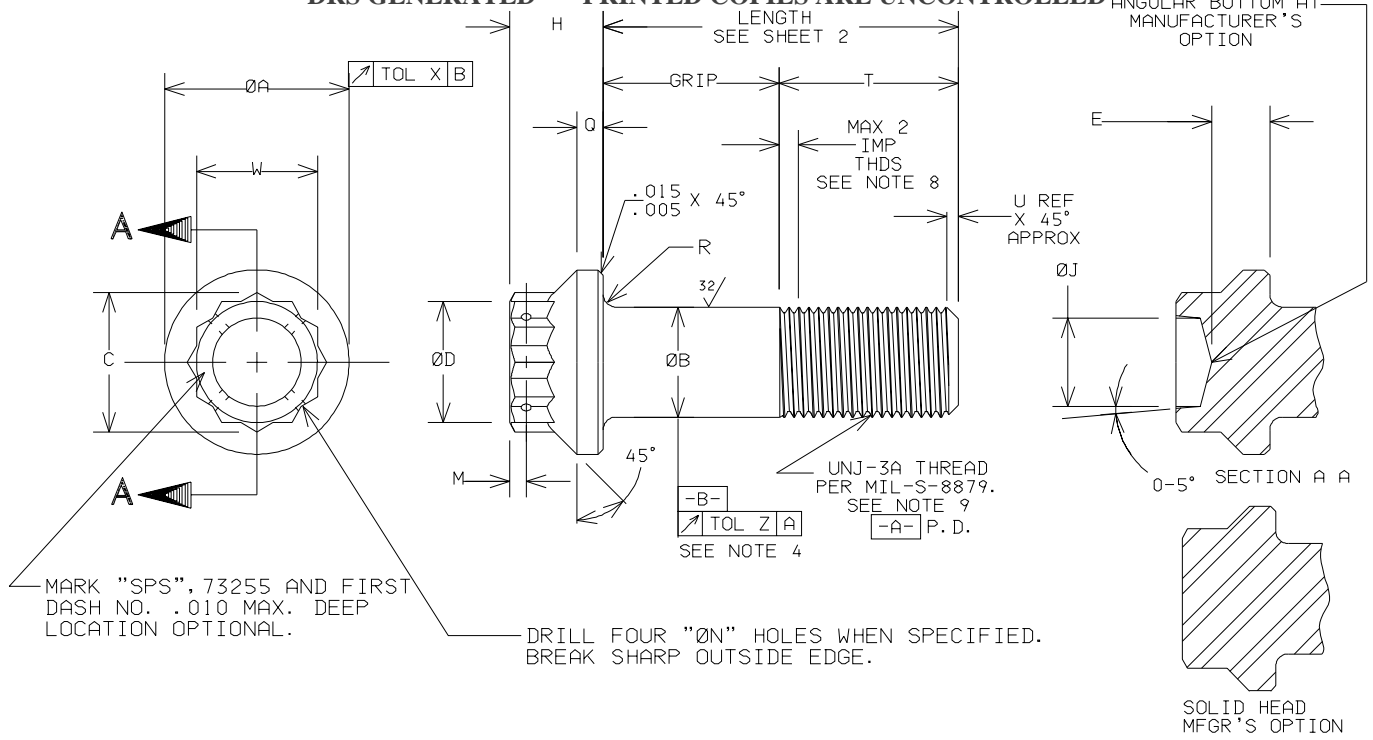


FLAT, CURVED OR
ANGULAR BOTTOM AT
MANUFACTURER'S
OPTION



MARK "SPS", 73255 AND FIRST DASH NO. .010 MAX. DEEP LOCATION OPTIONAL.

DRILL FOUR "ØN" HOLES WHEN SPECIFIED. BREAK SHARP OUTSIDE EDGE.

BASIC PART NUMBER	THREAD	A	B	C MIN	D	E MIN	H	J	M	N	O	R	T REF	W	X	Z
73255-428	.250-28	.438	.2500	.347	.312	.135	.310	.190	.072	.042	.079	.041	.492	.313	.005	.0045
73255-420	.250-20	.428	.2435		.297		.290	.150	.052	.032	.059	.031		.304		
73255-524	.3125-24	.532	.3125	.419	.375	.162	.358	.225	.080	.060	.092	.041	.579	.376	.006	.0045
73255-518	.3125-18	.520	.3053		.360		.338	.185	.060	.050	.072	.031		.367		
73255-624	.3750-24	.650	.3750	.491	.437	.197	.396	.270	.080	.060	.101	.057	.625	.439	.008	.0045
73255-616	.3750-16	.638	.3678		.422		.378	.230	.060	.050	.081	.047		.430		
73255-720	.4375-20	.752	.4375	.561	.500	.228	.445	.330	.080	.060	.109	.057	.721	.502	.009	.006
73255-714	.4375-14	.738	.4294		.485		.425	.290	.060	.050	.089	.047		.492		
73255-820	.5000-20	.830	.5000	.631	.562	.254	.514	.390	.104	.060	.133	.057	.768	.564	.010	.006
73255-813	.5000-13	.816	.4919		.547		.494	.350	.084	.050	.113	.047		.553		
73255-918	.5625-18	.941	.5625	.703	.625	.287	.567	.450	.104	.060	.143	.057	.852	.627	.011	.006
73255-912	.5625-12	.925	.5538		.610		.547	.410	.084	.050	.123	.047		.616		
73255-1018	.6250-18	1.053	.6250	.775	.687	.327	.628	.510	.104	.060	.160	.073	.899	.690	.012	.006
73255-1011	.6250-11	1.037	.6163		.672		.608	.470	.084	.050	.140	.063		.679		
73255-1216	.7500-16	1.234	.7500	.917	.812	.380	.721	.580	.104	.060	.188	.073	1.036	.814	.015	.006
73255-1210	.7500-10	1.216	.7406		.797		.701	.540	.084	.050	.168	.063		.803		
73255-1414	.8750-14	1.442	.8750	1.059	.937	.438	.818	.660	.135	.060	.208	.073	1.244	.940	.018	.009
73255-1409	.8750-9	1.424	.8647		.922		.798	.620	.115	.050	.188	.063		.928		
73255-1614	1.0000-14	1.630	1.0000	1.200	1.062	.493	.933	.750	.135	.060	.232	.073	1.479	1.064	.020	
73255-1612	1.0000-12	1.610	.9886		1.047		.913	.710	.115	.050	.213	.063		1.052	.020	.009
73255-1608	1.0000-8															
73255-1812	1.1250-12	1.881	1.1250	1.414	1.250	.556	1.061	.850	.135	.060	.268	.073	1.650	1.252	.022	
73255-1807	1.1250-7	1.859	1.1086		1.235		1.041	.810	.115	.050	.248	.063		1.239		
73255-2012	1.2500-12	2.131	1.250	1.484	1.312	.636	1.165	.960	.135	.060	.279	.089	1.760	1.314	.025	
73255-2007	1.2500-7	2.109	1.2336		1.297		1.155	.920	.115	.050	.259	.077		1.360		
73255-2212	1.3750-12	2.320	1.3750	1.628	1.437	.698	1.276	1.080	.198	.060	.284	.089	1.885	1.440	.028	
73255-2206	1.3750-6	2.296	1.3568		1.421		1.258	1.040	.178	.050	.264	.077		1.427		
73255-2412	1.5000-12	2.508	1.5000	1.842	1.625	.750	1.444	1.210	.198	.060	.345	.089	2.010	1.627	.030	
73255-2406	1.5000-6	2.482	1.4880		1.609		1.424	1.170	.178	.050	.325	.077		1.614		
73255-2812	1.750-12	2.824	1.750	2.484	1.938	.848	1.660	1.302	.188	.060	.350	.073	2.278	1.940	.030	
73255-285	1.750-5	2.796	1.7295						.050		.058	.058		1.926		
73255-3212	2.000-12	3.170	2.000	2.839	2.188	.993	1.997	1.500	.188	.060	.419	.111	2.573	2.190	.030	
73255-324.5	2.000-4.5	3.140	1.9780						.050		.091	.091		2.176		
73255-3612	2.250-12	3.706	2.250	2.769	2.437	1.111	2.114	1.688	.188	.060	.486	.114	23778	23440	.030	
73255-364.5	2.250-4.5	3.676	2.2280						.050		.099	.099		2.426		
73255-4012	2.500-12	4.071	2.500	3.124	2.750	1.227	2.341	1.875	.188	.060	.583	.122	3.034	2.752	.030	
73255-404	2.500-4	4.039	2.4762						.050		.107	.107		2.737		
73255-4412	2.750-12	4.441	2.750	3.409	3.000	1.343	2.567	2.062	.188	.060	.637	.131	3.290	3.002	.030	
73255-444	2.750-4	4.407	2.7262						.050		.116	.116		2.987		
73255-4812	3.000-12	4.806	3.000	3.695	3.250	1.457	2.794	2.250	.188	.060	.689	.139	3.546	3.252	.030	
73255-484	3.000-4	4.770	2.9762						.050		.124	.124		3.237		

SEE NOTE 4

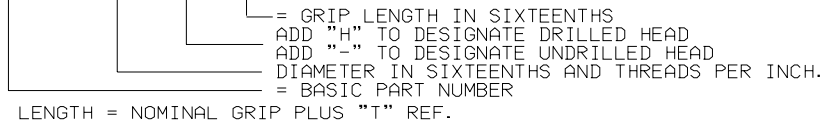
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TOLERANCES ±.010 AND ±2° SURFACE ROUGHNESS 125/ UNLESS OTHERWISE NOTED DRAWN: KATHY SCHWARTZ DATE: 05/20/97 APPROVED: L. KLINE DATE: 2/26/98 APPROVED: S. HUTCHINSON	SPS TECHNOLOGIES	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS SPS-B-645 PART NUMBER: 73255-() () () SHEET 1 OF 2 PROJECT 64A69
TITLE BOLT, TENSION, EXTERNAL WRENCHING DOUBLE HEXAGON ALLOY STEEL, 180 KSI, 450° F., COMMERCIAL APPLICATIONS			

GRIP TOLERANCES	LENGTH TOLERANCES			
	BOLT LENGTH	NOMINAL BOLT DIAMETERS		
		THRU .375 DIA.	.4375 THRU .7500 DIA.	.8750 THRU 1.500 DIA.
±.010 THRU 1.000 DIA	UP TO 1.000	-.030	-.030	-.050
±.031 OVER 1.000 DIA	1.000 THRU 2.500	-.040	-.060	-.100
THRU 6.000 GRIP	OVER 2.500 THRU 6.000	-.060	-.080	-.140
±.062 GRIP 6.000	OVER 6.000 BOLT LENGTH	-.120	-.120	-.200
THRU 16.000				
±.125 OVER 16.000 GRIP				

GRIP TOLERANCES FOR DIAMETERS OVER 1.500	LENGTH TOLERANCES FOR DIAMETERS OVER 1.500
±.031 THRU 6.000 OF GRIP LENGTH	+ .000 FOR LENGTHS UP TO 6.000 INCLUSIVE
±.062 - 6.000 THRU 16.000 GRIP LENGTH	- .200
±.125 OVER 16.000 GRIP LENGTH	+ .000 FOR LENGTHS OVER 6.000
	- .240

1. MATERIAL: ALLOY STEEL.
2. HEAT TREATMENT: 180,000 PSI MINIMUM.
3. FINISH: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 3.
4. THE RUNOUT OF BODY AND PITCH DIAMETER OF BOLTS OVER 1.000 SHALL BE WITHIN .005 PER INCH OF BODY LENGTH, .060 MAX.
5. PART NUMBER: 73255 - () () ()



LENGTH = NOMINAL GRIP PLUS "T" REF.

EXAMPLE: 73255-524H20 = .3125-24 BOLT, DRILLED HEAD, 1.250 GRIP LENGTH, CADMIUM PLATED.

6. BREAK ALL SHARP EDGES .003-.006.
7. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENTS.
8. MAX. OF THREE INCOMPLETE THREADS FOR 1.000 AND OVER DIAMETER BOLTS.
9. BOLTS OVER 1.000 DIAMETER SHALL HAVE UNJ-2A THREADS PRIOR TO PLATE.
10. CHAMFER "U" X 45° PLUS INCOMPLETE THREADS ARE NOT TO EXCEED TWO PITCHES.
11. DIMENSIONS ARE IN INCHES.