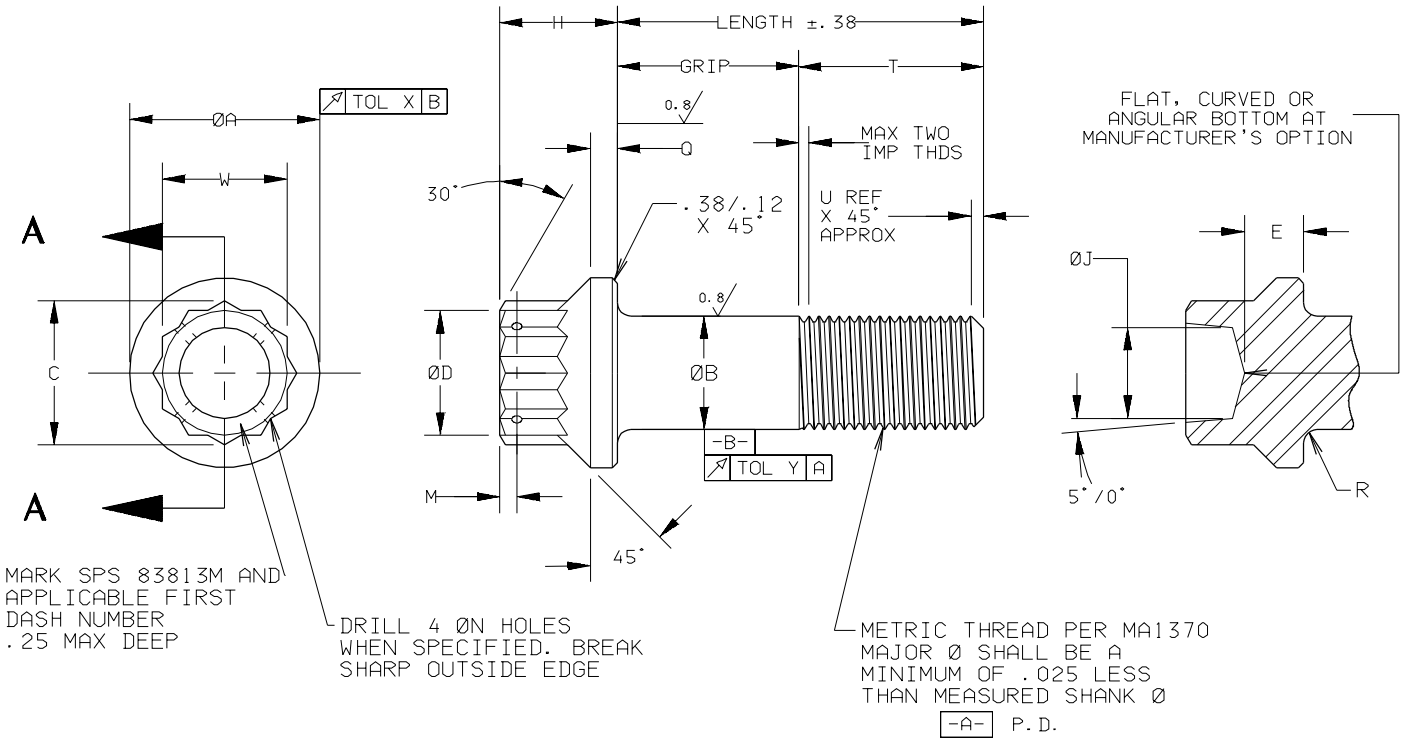

FIRST DASH NUMBER	THREAD PER MA1370	ØA ±.25	ØB MAX	ØB MIN	C MIN	ØD +.000 -.400	E MIN	H ±.250	ØJ ±.500	M	ØN ±.120	Q ±.250	R MAX	R MIN
M5	MJ5 X 0.8	9.06	4.987	4.962	7.74	7.0	2.7	6.64	3.0	1.60	1.00	1.58	1.1	.8
M6	MJ6 X 1.0	10.50	5.987	5.962	8.87	8.0	3.1	7.39	4.0	1.60	1.00	1.76	1.1	.8
M8	MJ8 X 1.0	13.60	7.987	7.962	11.05	10.0	4.1	8.82	5.0	1.80	1.00	2.17	1.1	.8
M10	MJ10 X 1.25	17.00	9.987	9.962	13.25	12.0	5.5	11.04	6.0	1.80	1.50	2.63	1.5	1.2
M12	MJ12 X 1.25	21.00	11.987	11.962	15.51	14.0	6.4	12.77	8.0	1.80	1.50	3.04	1.5	1.2
M14	MJ14 X 1.50	24.00	13.987	13.962	18.90	17.0	7.3	14.41	11.0	2.40	1.50	3.43	1.5	1.2
M16	MJ16 X 1.50	27.00	15.987	15.962	21.10	19.0	8.6	16.42	12.0	2.40	1.50	3.91	1.9	1.6
M18	MJ18 X 1.50	30.00	17.975	17.950	24.49	22.0	9.4	18.14	15.0	2.40	1.50	4.32	1.9	1.6
M20	MJ20 X 1.50	33.50	19.975	19.950	26.75	24.0	10.5	19.87	17.0	2.40	1.50	4.73	1.9	1.6
M22	MJ22 X 1.50	36.50	21.975	21.950	29.01	26.0	11.6	21.58	18.0	3.20	1.50	5.14	1.9	1.6
M24	MJ24 X 2.00	39.50	23.975	23.950	31.19	28.0	12.5	23.15	19.0	3.20	1.50	5.51	1.9	1.6
M27	MJ27 X 2.00	44.00	26.975	26.935	35.65	32.0	14.9	25.73	21.0	3.20	1.50	6.13	1.9	1.6
M33	MJ33 X 2.00	54.00	32.975	32.935	42.33	38.0	18.2	31.19	25.0	3.20	1.50	7.43	2.3	2.0
M36	MJ36 X 2.00	59.00	35.975	35.935	45.63	41.0	20.3	33.77	28.0	4.80	1.50	8.04	2.3	2.0

FIRST DASH NUMBER	T REF	U REF	W MAX	W MIN	X	Y
M5	10.5	1.6	7.0	6.85	.10	.12
M6	13.0	2.0	8.0	7.85	.12	.12
M8	15.0	2.0	10.0	9.75	.16	.12
M10	18.0	2.5	12.0	11.73	.20	.12
M12	20.0	2.5	14.0	13.73	.24	.12
M14	23.0	3.0	17.0	16.73	.28	.12
M16	25.0	3.0	19.0	18.67	.32	.13
M18	27.0	3.0	22.0	21.67	.36	.14
M20	30.0	3.0	24.0	23.67	.40	.16
M22	32.0	3.0	26.0	25.67	.44	.18
M24	36.5	4.0	28.0	27.67	.48	.19
M27	40.0	4.0	32.0	31.38	.54	.22
M33	46.0	4.0	38.0	37.38	.66	.26
M36	50.0	4.0	41.0	40.38	.72	.29

TOLERANCES ±0.25 AND ±2°
SURFACE ROUGHNESS 3.2/
UNLESS OTHERWISE NOTED
DRAWN: R.L. SANDY DATE: 7/24/86
APPROVED: R WAELTZ DATE: 11/11/91
APPROVED: TAR

SPS TECHNOLOGIES

FSCM NO. 56878
CUSTODIAN: JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS
SPS-B-640
APPENDIX 3.1

TITLE BOLT, TENSION, DOUBLE HEXAGON, FLANGED, METRIC ALLOY STEEL, 1250 MPa MINIMUM TENSILE STRENGTH APPLICATIONS TO 235°C

PART NUMBER: 83813M[ ]-[ ]

SHEET 1 OF 2 PROJECT 29A98

1. MATERIAL: ALLOY STEEL PER AMS 6322, MIL-S-5626 OR MIL-S-5000.
2. HEAT TREATMENT: 1250 MPa MINIMUM ULTIMATE TENSILE STRENGTH. HRC 39-43.
3. FINISH: CADMIUM PLATE PER QQ-P-416 TYPE II, CLASS 2.
4. MAGNETIC PARTICLE INSPECT 100 PERCENT PER MIL-STD-6868.
5. REQUIREMENTS: HEAD TO BE FORGED.
   THREADS TO BE ROLLED AFTER HEAT TREATMENT.
   HEAD TO SHANK FILLET TO BE COLD WORKED.
   LIGHTENING HOLE IN HEAD MAY BE DRILLED OR FORGED
6. PART NUMBER: 83813 M 8 H - 24

   - 24 = NOMINAL GRIP LENGTH IN MILLIMETERS
   - H = CROSSDRILLED HEADS
   - 8 = DIAMETER IN MILLIMETERS
   - M = METRIC
   - 83813 = BASIC PART NUMBER

   NOMINAL LENGTH = NOMINAL GRIP LENGTH PLUS "T"

7. FOR COMPANION NUT SEE SPS-N-83811
8. DIMENSIONS ARE IN MILLIMETERS (mm)