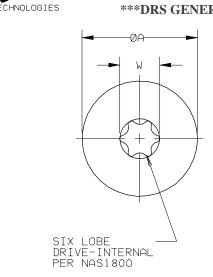
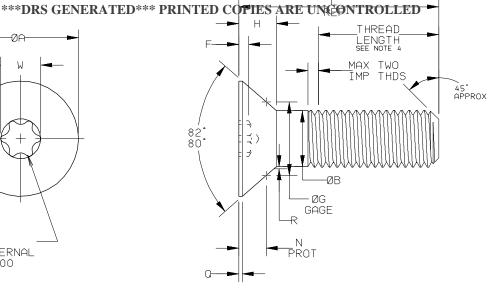
SP S W -9423 4

> 3/02/95 DATE

Θ 6/22/95



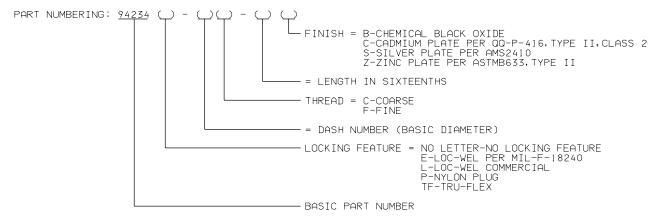


DASH NUMBER	BASIC DIAMETER	PER	ADS INCH	ØA MAX/MIN	ØB MAX/MIN	F MAX/MIN	ØG GAGE	H REF	DRIVE SIZE	L REF	N MAX/MIN	Q MAX	R MAX	W REF	X
		UNRC	UNRF												
-98	#8	32	36	. 359/. 311	.1640/.1585	.040/.034			T20	1.000	.067/.055	. 026		. 155	. 006
-3	#10	24	32	. 411/. 359	.1900/.1840	.055/.044	. 2440	.127	T20	1.250	.095/.081	. 029	.015	. 155	. 007
- 4	1/4	20	28	.531/.480	. 2500/. 2435	.065/.054	. 3314	. 162	T30	1.250	. 113/. 099	.028	.015	. 221	. 009
-5	5/16	18	24	.656/.600	.3125/.3053	.075/.064	. 4047	. 198	T30	1.500	.143/.128	.031	.015	. 221	.011
-6	3/8	16	24	. 781/. 720	.3750/.3678	.080/.069				1.750	.168/.152	.033	. 015	. 226	.013
-8	1/2	13	20	.937/.872	.5000/.4919	.117/.103	6500	. 251	T55	2,250	. 162/. 147	. 034	.015	. 446	.018

LENGTH TOLERANCE					
DIAMETER	TO 1"	OVER 1" TO 2-1/2"	OVER 2-1/2"		
ALL	03	04	06		

DASH	BASIC	TENSILE S		DOUBLE SHEAR STRENGTH OF BODY	
NUMBER	DIAMETER	UNRC	UNRF	LBS. MIN.	
-98	#8	2, 220	2,240	4,060	
-3	#10	2,780	3,180	5,440	
- 4	1/4	5,070	5,790	9,420	
-5	5/16	8,350	9,250	14,720	
-6	3/8	12,400	14,000	21,200	
-8	1/2	22,800	25,600	37,700	

- 1. MATERIAL: HEAT TREATED ALLOY STEEL.
- 2. HEAT TREATMENT: 160,000 PSI TENSILE STRENGTH. HRC 36-43.
- 3. THREAD CLASS: 3A
- 4. THREAD LENGTH: BOLT LENGTHS EQUAL TO OR SHORTER THAN LISTED IN COLUMN L WILL BE THREADED TO HEAD. FOR BOLTS LONGER THAN LISTED, MINIMUM USABLE THREAD LENGTH SHALL BE 2D+1/2", WITH MAXIMUM AT MANUFACTURER'S OPTION.
- 5. CONCENTRICITY: INTERNAL DRIVE TO BODY DIAMETER WITHIN "X" T.I.R. THREAD TO BODY WITHIN .005 INCH PER INCH OF BODY LENGTH (UNTHREADED PORTION) TOTAL INDICATOR READING TAKEN DIRECTLY UNDER THE HEAD WHEN BOLT IS HELD BY THE FULL THREADS CLOSEST TO THE HEAD AND SHALL NOT EXCEED A MAXIMUM OF .025.



REFERENCE: UNBRAKO 16990 EXCEPT SIX LOBE RECESS

INFORMATION ON THIS DOCUMENT IS A TRADE SECRET, PROPRIETARY, AND SHALL NOT BE USED OR REPRODUCED IN WHOLE OR IN PART WITHOUT WRITTEN AUTHORIZATION OF SPS TECHNOLOGIES.

SURFACE ROUGHNESS 125/	<b>&gt;V&gt;</b>	SCM NO. 56878 SIANDARDS AND SPECIFICATIONS CUSTODIAN: CIENKINTOWN PA.
UNLESS OTHERWISE NOTED  DRAWN:STEVE FOSTER DATE:3/02/95  APPROVED: L. KLINE DATE:6/22/95	TITLE BOLT, 82 FLAT HEAD SIX LOBE DRIVE-INTERNAL	PART NUMBER: 94234( )-( )( ) - ( )( )
APPROVED: R. WAELTZ	160 KSI TENSILE STRENGTH	SHEET 1 OF 1 PROJECT 60A61