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DRAWING NUMBER
SPS-B-94703

ISSUE DATE
 4/12/97

REVISION

① 6/6/97

② 9/16/97

③ 1/22/98

④ 3/23/98

⑤ 11/12/99

⑥ 1/12/2001

⑦ 3/12/2001

⑧ 3/10/03

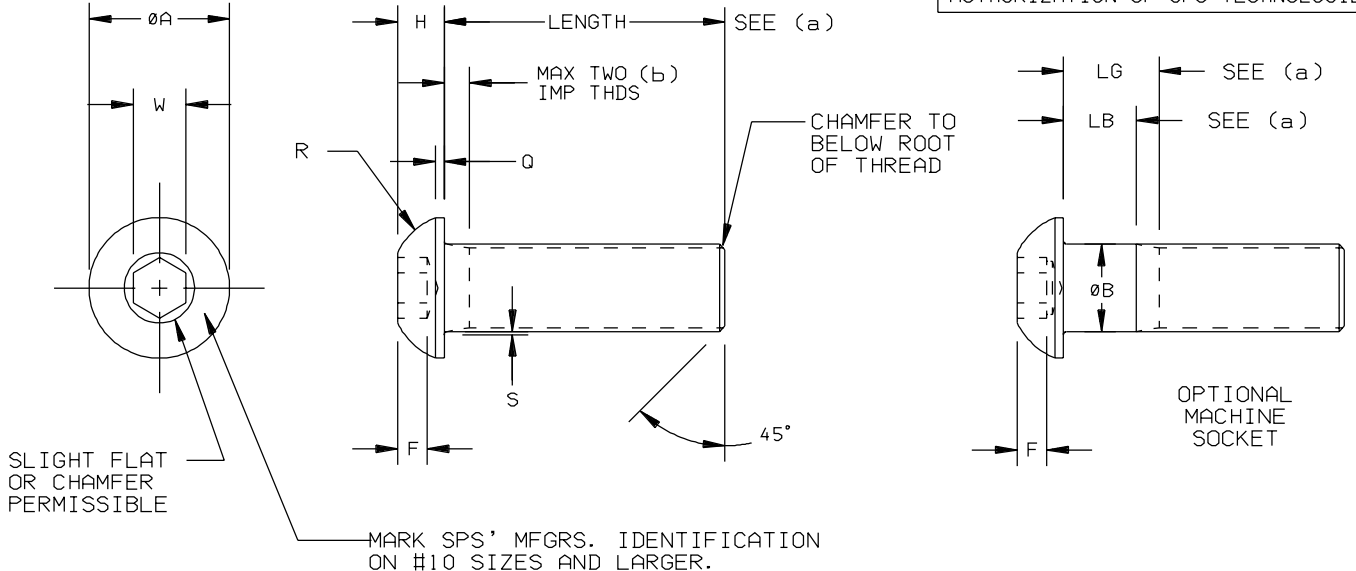


TABLE I

DASH NO	SIZE	THREAD DESIGNATION		ØA		ØB		F	H		L (a)	Q REF	R REF	S			
		UNRF	CLASS	UNRC	CLASS	MAX	MIN		MAX	MIN				MAX	MIN	MAX	MIN
90	H0	.060-80	3A			.114	.104	.060	.0568	.020	.032	.026	.500	.010	.070	.010	.005
91	H1	.073-72	3A	.073-64	3A	.139	.129	.073	.0695	.028	.039	.033	.500	.010	.080	.010	.005
92	H2	.086-64	3A	.086-56	3A	.164	.154	.086	.0822	.028	.046	.038	.500	.010	.099	.010	.005
93	H3	.099-56	3A	.099-48	3A	.188	.176	.099	.0949	.035	.052	.044	.500	.010	.110	.010	.005
94	H4	.112-48	3A	.112-40	3A	.213	.201	.112	.1075	.035	.059	.051	.500	.015	.135	.010	.005
95	H5	.125-44	3A	.125-40	3A	.238	.226	.125	.1202	.044	.066	.058	.500	.015	.141	.010	.005
96	H6	.138-40	3A	.138-32	3A	.262	.250	.138	.1329	.044	.073	.063	.625	.015	.158	.010	.005
98	H8	.164-36	3A	.164-32	3A	.312	.298	.164	.1585	.052	.087	.077	.750	.015	.185	.015	.010
3	#10	.190-32	3A	.190-24	3A	.361	.347	.190	.1840	.070	.101	.091	1.000	.020	.213	.015	.010
4	1/4"	.250-28	3A	.250-20	3A	.437	.419	.250	.2435	.087	.132	.122	1.000	.031	.249	.020	.015
5	5/16"	.312-24	3A	.312-18	3A	.547	.527	.3125	.3053	.105	.166	.152	1.000	.031	.309	.020	.015
6	3/8"	.375-24	3A	.375-16	3A	.656	.636	.375	.3678	.122	.199	.185	1.250	.031	.368	.020	.015
8	1/2"	.500-20	3A	.500-13	3A	.875	.851	.500	.4919	.175	.265	.245	2.000	.046	.481	.030	.020
10	5/8"	.625-18	3A	.625-11	3A	1.000	.970	.625	.6163	.210	.331	.311	2.000	.062	.523	.030	.020

(a) FOR SCREWS OF NOMINAL LENGTHS EQUAL TO OR SHORTER THAN STANDARD MAXIMUM LENGTH "L" LISTED IN TABLE I, THE COMPLETE (FULL-FORM) THREADS, MEASURED WITH A THREAD RING GAGE HAVING THE THREAD CHAMFER AND/OR COUNTERBORE REMOVED, SHALL EXTEND TO WITHIN TWO PITCHES (THREADS) OF THE BEARING SURFACE OF THE HEAD. FOR LONGER SCREWS, THE LENGTH OF THE COMPLETE THREAD SHALL, AT THE OPTION OF THE MANUFACTURER, BE BETWEEN THE MINIMUM LIMIT OF TWICE THE BASIC SCREW DIAMETER PLUS 0.50 INCH AND THE MAXIMUM LIMIT WITHIN TWO PITCHES (THREADS) OF THE HEAD. THE UNTHREADED PORTION OF THE SCREWS SHALL BE AT NOMINAL DIAMETER.

(b) IMPERFECT THREADS NOT TO ENTER INTO FILLET AREA.

TABLE II

LENGTH TOLERANCE TABLE		
UP TO 1" INCL.	OVER 1" TO 2" INCL.	OVER 2"
-.03	-.04	-.06

TABLE III

SIZE	TENSILE STRENGTH IN POUNDS (c)		RECOMMENDED SEATING TORQUE IN INCH POUNDS PLAIN (d)		DOUBLE SHEAR STRENGTH OF BODY LBS. MIN.	W NOM	X (e)
	UNRC	UNRF	UNRC	UNRF			
H0	---	100	---	1.0	260	.035	.005
H1	150	160	1.7	1.8	380	.050	.005
H2	210	220	2.8	3.0	520	.050	.005
H3	270	290	4.3	4.5	700	.0625	.005
H4	340	370	6.0	6.6	880	.0625	.005
H5	450	470	8.9	9.3	1,100	.0781	.005
H6	510	570	11.0	12.0	1,340	.0781	.005
H8	790	830	20.0	21.0	1,900	.0937	.006
H10	980	1,120	30.0	34.0	2,560	.1250	.007
1/4"	1,780	2,040	71.0	81.0	4,400	.1562	.009
5/16"	2,940	3,250	123.0	136.0	6,900	.1875	.011
3/8"	4,340	4,920	218.0	247.0	9,940	.2187	.013
1/2"	7,950	8,950	532.0	600.0	17,680	.3125	.018
5/8"	12,700	14,300	1,060.0	1,200.0	27,600	.3750	.021

THE RECOMMENDED SEATING TORQUES LISTED SERVE AS GUIDELINES ONLY. EVEN WHEN USING THE RECOMMENDED SEATING TORQUES, THE INDUCED LOADS OBTAINED MAY VARY AS MUCH AS ±25% DEPENDING UPON THE UNCONTROLLED VARIABLES SUCH AS MATING MATERIAL, PLATING, LUBRICATION, SURFACE FINISH, HARDNESS, BOLT/Joint COMPLIANCE, METHOD OF TIGHTENING, ETC.

HOWEVER, THE BEST WAY TO DETERMINE THE CORRECT TORQUE IS TO RUN TESTS ON THE PARTICULAR JOINT BY TIGHTENING SAMPLE BOLTS UNTIL THEY JUST BEGIN TO YIELD. THE OPTIMUM TORQUE IS 80% OF THIS VALUE.

(c) THE TENSILE STRENGTH IS BASED ON 56 KSI AND THE TENSILE STRESS AREA PER ASME B1.1.
 (d) TORQUE VALUES LISTED ARE FOR PLAIN SCREWS. FOR CADMIUM PLATED SCREWS, MULTIPLY RECOMMENDED SEATING TORQUE BY .75; FOR ZINC PLATED SCREWS MULTIPLY BY 1.40
 (e) RUNOUT - SOCKET TO BODY WITHIN "X" T.I.R.

TOLERANCES ±.010 AND ±2"	FSCM NO. 56878	TITLE	STANDARDS AND SPECIFICATIONS
SURFACE ROUGHNESS 125	CUSTODIAN: JENKINTOWN, PA.	SCREW, BUTTON HEAD HEXAGON RECESS AUSTENITIC STAINLESS STEEL, 56 KSI U.T.S.	FF-S-86 EXCEPT AS NOTED
UNLESS OTHERWISE NOTED	DRAFTED IN ACCORDANCE WITH ASME Y14.5M		PART NUMBER:
DRAWN BY: STEVE FOSTER	DATE: 4/12/97		94703()-()-()-()
APPROVED: S FOSTER	DATE: 3/12/03		SHEET 1 OF 2
APPROVED: L KLINE			ER-020



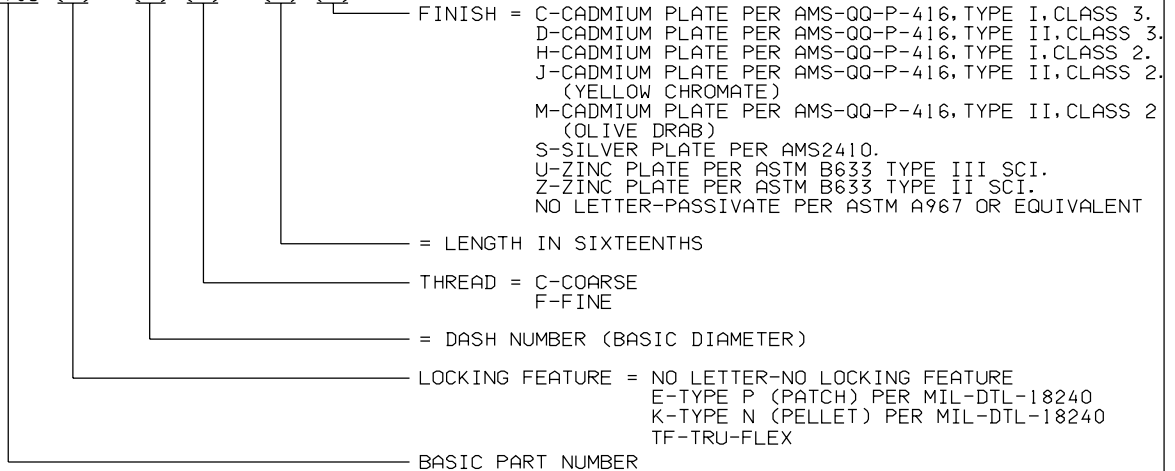
TABLE IV

FOR LENGTHS SHORTER THAN LISTED. (LENGTHS ABOVE HEAVY LINE) SCREWS WILL BE THREADED TO WITHIN 3 THREAD PITCHES OF THE HEAD.

BODY AND GRIP LENGTHS FOR FLAT HEAD SOCKET SCREWS																			
SIZE	#0		#1		#2		#3		#4		#5		#6		#8		#10		
	NOM. LENGTH	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B
3/4	0.250	0.190																	
7/8	0.250	0.190	0.250	0.170	0.250	0.160	0.250	0.150											
1	0.500	0.440	0.250	0.170	0.250	0.160	0.250	0.150											
1-1/4	0.750	0.690	0.620	0.550	0.620	0.540	0.620	0.520	0.500	0.380	0.500	0.380	0.500	0.340	0.380	0.220			
1-1/2			0.880	0.800	0.880	0.790	0.880	0.770	0.500	0.380	0.500	0.380	0.500	0.340	0.380	0.220	0.620	0.420	
1-3/4					1.120	1.040	1.120	1.020	1.000	0.880	1.000	0.880	1.000	0.840	0.880	0.720	0.620	0.420	
2							1.380	1.270	1.000	0.880	1.000	0.880	1.000	0.840	0.880	0.720	0.620	0.420	
2-1/4									1.500	1.380	1.500	1.380							
2-1/2														1.500	1.340	1.380	1.220	1.620	1.420
2-3/4														2.000	1.840	1.880	1.720	1.620	1.420
3																1.880	1.720	2.120	1.920
3-1/4																2.380	2.222	2.120	1.920
3-1/2																		2.620	2.420
3-3/4																		2.620	2.420
4																		3.120	2.920

SIZE	1/4		5/16		3/8		7/16		1/2		5/8		
	NOM. LENGTH	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B	L _G	L _B
1-3/4	0.750	0.500											
2	0.750	0.500	0.880	0.600									
2-1/4	1.250	1.000	0.880	0.600	1.000	0.690							
2-1/2	1.250	1.000	1.380	1.100	1.000	0.690	1.120	0.770	1.000	0.620			
2-3/4	1.750	1.500	1.380	1.100	1.500	1.190	1.120	0.770	1.000	0.620			
3	1.750	1.500	1.880	1.600	1.500	1.190	1.620	1.270	1.000	0.620			
3-1/4	2.250	2.000	1.880	1.600	2.000	1.690	1.620	1.270	1.750	1.360	1.500	1.040	
3-1/2	2.250	2.000	2.380	2.100	2.000	1.690	2.120	1.770	1.750	1.360	1.500	1.040	
3-3/4	2.750	2.500	2.380	2.100	2.500	2.190	2.120	1.770	1.750	1.360	1.500	1.040	
4	2.750	2.500	2.880	2.600	2.500	2.190	2.620	2.270	2.500	2.120	2.250	1.800	
4-1/4	3.250	3.000	2.880	2.600	3.000	2.690	2.620	2.270	2.500	2.120	2.250	1.800	
4-1/2	3.250	3.000	3.380	3.100	3.000	2.690	3.120	2.770	2.500	2.120	2.250	1.800	
4-3/4	3.750	3.500	3.380	3.100	3.500	3.190	3.120	2.770	3.250	2.860	3.000	2.540	
5	3.750	3.500	3.880	3.600	3.500	3.190	3.620	3.270	3.250	2.860	3.000	2.540	
5-1/4	4.250	4.000	3.880	3.600	4.000	3.690	3.620	3.270	3.250	2.860	3.000	2.540	
5-1/2			4.380	4.100	4.000	3.690	4.120	3.770	4.000	3.620	3.750	3.300	
5-3/4			4.380	4.100	4.500	4.190	4.120	3.770	4.000	3.620	3.750	3.300	
6			4.880	4.600	4.500	4.190	4.620	4.270	4.000	3.620	3.750	3.300	
6-1/4			4.880	4.600	5.000	4.690	4.620	4.270	4.750	4.360	4.500	4.040	
6-1/2			5.380	5.100	5.000	4.690	5.120	4.770	4.750	4.360	4.500	4.040	
6-3/4					5.500	5.190	5.120	4.770	4.750	4.360	4.500	4.040	
7					5.500	5.190	5.620	5.270	5.500	5.120	5.250	4.800	
7-1/4					6.000	5.690	5.620	5.270	5.500	5.120	5.250	4.800	
7-1/2					6.000	5.690	6.120	5.770	5.500	5.120	5.250	4.800	
7-3/4					6.500	6.190	6.120	5.770	6.250	5.860	6.000	5.540	
8							6.620	6.270	6.250	5.860	6.000	5.540	
8-1/2							7.120	6.770	7.000	6.620	6.750	6.300	
9							7.620	7.270	7.000	6.620	6.750	6.300	
9-1/2							8.120	7.770	8.000	7.620	7.750	7.300	
10									8.000	7.620	7.750	7.300	
11											9.250	8.800	
12											10.250	9.800	

- MATERIAL: AUSTENITIC STAINLESS STEEL PER CHEMISTRY OF ASTM A493.
- FINISH: SEE NOTE 4.
- DIMENSIONS, GEOMETRIC TOLERANCE PER ASME B18.3 - INCLUDING MANUFACTURING NOTES NOT LISTED ON THIS DRAWING.
- PART NUMBERING: 94703 () - () () - () ()



TOLERANCES ±.010 AND ±2°
 SURFACE ROUGHNESS 125
 UNLESS OTHERWISE NOTED

DRAFTED
 IN ACCORDANCE
 WITH ASME Y14.5M



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 94703 () - () () - () ()

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