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**SPS-B-95845**

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 8/01/01

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9/11/01

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10/13/04

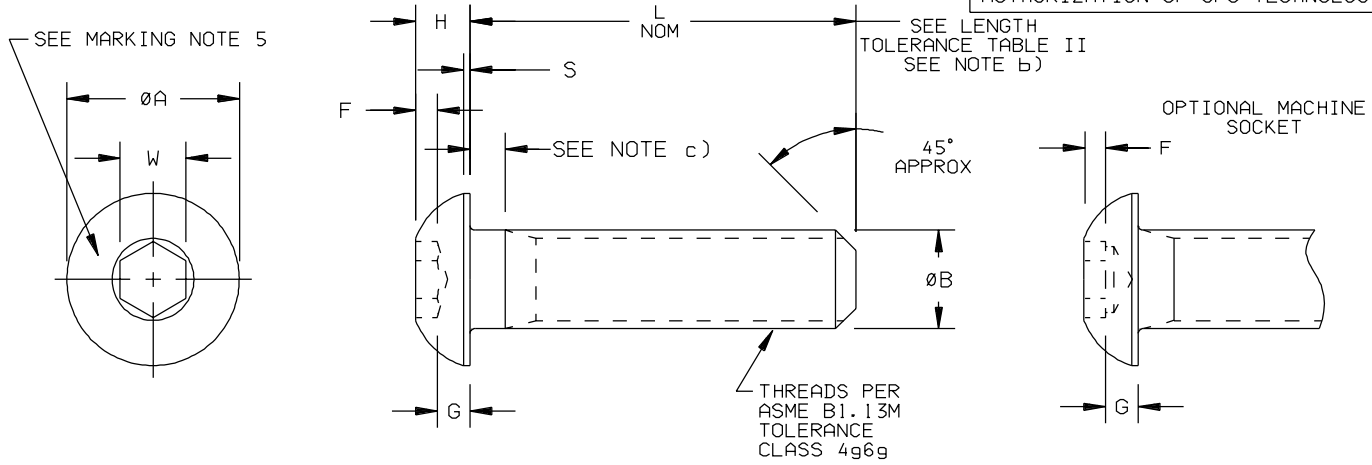


TABLE I

NOM. DIA.	THREADS	ØA		ØB NOM	F MIN	G MIN	H		L NOM MAX STND LENGTH	S REF	W NOM	TENSILE STRENGTH kN MIN (a)
		MAX	MIN				MAX	MIN				
M3	MJ3X0.5	5.70	5.40	3.0	1.04	0.20	1.65	1.43	12	0.38	2.0	5.5
M4	MJ4X0.7	7.60	7.24	4.0	1.30	0.30	2.20	1.95	20	0.38	2.5	9.7
M5	MJ5X0.8	9.50	9.14	5.0	1.56	0.38	2.75	2.50	30	0.50	3.0	15.6
M6	MJ6X1	10.50	10.07	6.0	2.08	0.74	3.30	3.00	30	0.80	4.0	22.1
M8	MJ8X1.25	14.00	13.57	8.0	2.60	1.05	4.40	4.05	40	0.80	5.0	40.3
M10	MJ10X1.5	17.50	17.07	10.0	3.12	1.45	5.50	5.20	40	0.80	6.0	63.8
M12	MJ12X1.75	21.00	20.48	12.0	4.16	1.63	6.60	6.24	60	0.80	8.0	92.7
M16	MJ16X2	28.00	27.48	16.0	5.20	2.25	8.80	8.44	60	1.50	10.0	172.3

a). ULTIMATE TENSILE STRENGTH IS CALCULATED USING TENSILE STRESS AREA PER APPENDIX B OF ASME B1.13M AND 1100MPa MINIMUM STRESS LEVEL

b). THE STANDARD LENGTHS SHALL BE AS FOLLOWS: 3, 4, 5, 6, 8, 10, 12, 16, 20, 25, 30, 35, 40, 45, 50, 55, AND 60. THE LONGEST STANDARD NOMINAL LENGTHS FOR THE RESPECTIVE SCREW SIZES ARE LISTED IN TABLE I.

c). SCREWS OF NOMINAL LENGTHS EQUAL TO OR SHORTER THAN THE LONGEST STANDARD LENGTHS LISTED UNDER COLUMN L IN TABLE I SHALL BE THREADED FULL LENGTH. THE DISTANCE MEASURED, PARALLEL TO THE AXIS OF THE SCREW, FROM THE UNDERSIDE OF THE HEAD TO THE FACE OF A NONCOUNTERBORED OR NONCOUNTERSUNK STANDARD GO THREAD RING GAGE ASSEMBLED BY HAND AS FAR AS THE THREAD WILL PERMIT, SHALL NOT EXCEED TWO PITCHES (THREADS). FOR LONGER SCREWS, THE LENGTH OF COMPLETE (FULL FORM) THREAD SHALL, AT THE OPTION OF THE MANUFACTURER, BE BETWEEN A MINIMUM LIMIT EQUAL TO TWICE THE BASIC SCREW DIAMETER PLUS 12.0 MM AND A MAXIMUM LIMIT OF TO WITHIN TWO PITCHES (THREADS) OF THE HEAD.

TABLE II

LENGTH TOLERANCE, mm	
NOMINAL SCREW LENGTH	TOLERANCE
UP TO 16, INCL	±0.3
OVER 16 TO 60, INCL	±0.5

1. MATERIAL: ALLOY STEEL PER CHEMISTRY OF ASTM F835M.
2. HEAT TREATMENT: PER THE REQUIREMENTS OF ASTM F835M.
3. FINISH: SEE NOTE 6.
4. DIMENSIONS AND GEOMETRIC TOLERANCING PER ASME B18.3.4M - INCLUDING MANUFACTURING NOTES NOT LISTED IN THIS DRAWING.
5. MARK "S" OR "SPS" AS APPLICABLE.
6. PART NUMBER: 95845( )-( )-( ) ( )

FINISH: B = CHEMICAL BLACK OXIDE PER MIL-DTL-13924.  
 C = CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.  
 D = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3.  
 H = CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2.  
 J = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.  
 (YELLOW CHROMATE)  
 M = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. (OLIVE DRAB)  
 S = SILVER PLATE PER AMS 2410.  
 U = ZINC PLATE PER ASTM B633 TYPE III SCI.  
 Z = ZINC PLATE PER ASTM B633 TYPE II SCI.  
 NO LETTER = THERMAL OXIDE (BLACK) PLUS RUST PREVENTATIVE OIL.

LENGTH IN MILLIMETERS  
 DIAMETER PER TABULATION  
 LOCKING FEATURE - NO LETTER = NO LOCKING FEATURE  
 E = TYPE P (PATCH) PER MIL-DTL-18240  
 K = TYPE N (PELLET) PER MIL-DTL-18240.

BASIC PART NUMBER

7. DIMENSIONS ARE IN MILLIMETERS.

TOLERANCES ±0.25 AND ±2°	FSCM NO. 56878	TITLE	STANDARDS AND SPECIFICATIONS
SURFACE ROUGHNESS 3.2	CUSTODIAN: JENKINTOWN, PA.	SCREW, BUTTON HEAD CAP, HEXAGON RECESS, ALLOY STEEL 1100MPa UTS	ASTM F835M EXCEPT AS NOTED
UNLESS OTHERWISE NOTED	DRAFTED IN ACCORDANCE WITH ANSI Y14.5M-1982		PART NUMBER:
DRAWN BY: STEVE FOSTER	DATE: 8/01/01		95845( )-( )-( ) ( )
APPROVED: S FOSTER	DATE: 10/26/04		
APPROVED: F CICCARONE			