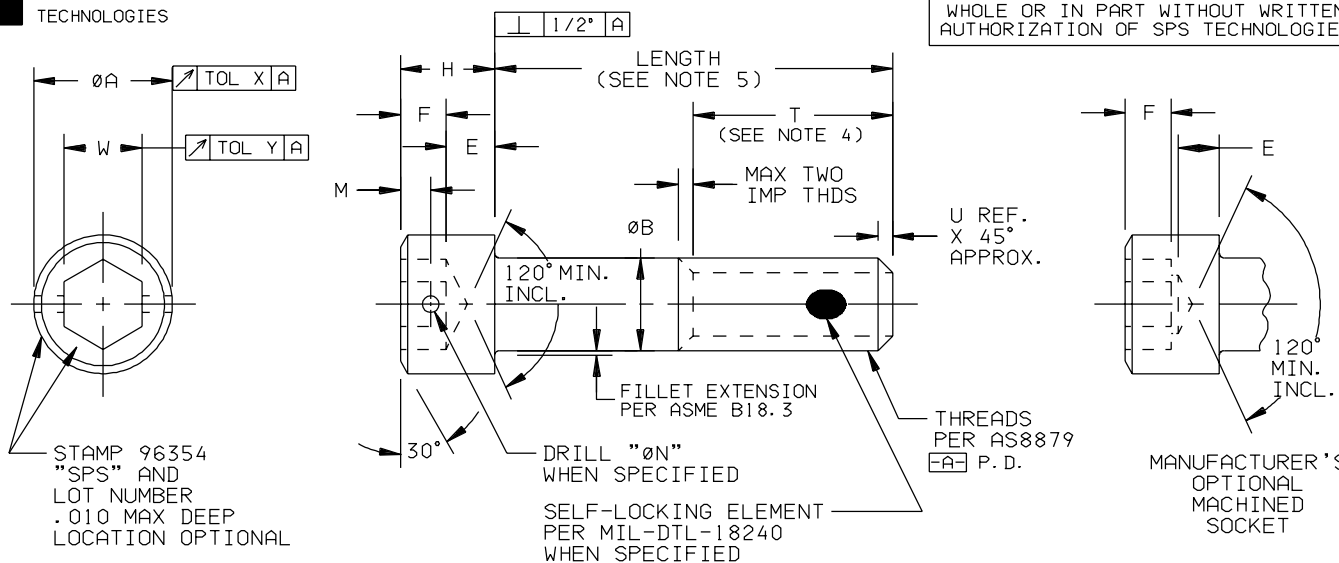


DRAWING NUMBER
SPS-B-96354

ISSUE DATE
4/16/03

REVISION	
1	11/18/04



BASIC PART NUMBER	THREADS	ØA	ØB	E MIN.	F MIN.	H	M	ØN	T MIN.	U REF.	W	X	Y	LENGTH MIN.		ULTIMATE TENSILE LBS. MIN.
														UNC	UNF	
96354-420	.2500-20 UNJC-3A	.375	.2500	.095	.126	.258	.085	.068	1.000	.06	.1900	.006	.011	.281	.156	6,360 7,280
96354-428	.2500-28 UNJF-3A	.367	.2464													
96354-518	.3125-18 UNJC-3A	.469	.3125	.119	.163	.320	.104	.068	1.125	.07	.2530	.006	.013	.250	.187	10,480 11,600
96354-524	.3125-24 UNJF-3A	.457	.3084													
96354-616	.3750-16 UNJC-3A	.563	.3750	.143	.186	.382	.123	.068	1.250	.08	.3160	.008	.013	.250	.187	15,500 17,560
96354-624	.3750-24 UNJF-3A	.552	.3705													
96354-714	.4375-14 UNJC-3A	.656	.4375	.166	.213	.444	.141	.068	1.375	.09	.3790	.009	.018	.312	.218	21,260 23,740
96354-720	.4375-20 UNJF-3A	.642	.4326													
96354-813	.5000-13 UNJC-3A	.750	.5000	.190	.245	.506	.160	.068	1.500	.10	.3790	.010	.020	.500	.500	28,380 31,980
96354-820	.5000-20 UNJF-3A	.739	.4948													
96354-1011	.6250-11 UNJC-3A	.938	.6250	.238	.307	.630	.198	.068	1.750	.110	.5050	.012	.024	.625	.625	45,200 51,200
96354-1018	.6250-18 UNJF-3A	.921	.6193													
96354-1210	.7500-10 UNJC-3A	1.125	.7500	.285	.370	.754	.235	.098	2.000	.120	.6310	.012	.024	.750	.750	66,800 74,600
96354-1216	.7500-16 UNJF-3A	1.107	.7436													
96354-1409	.8750-9 UNJC-3A	1.312	.8750	.333	.432	.878	.273	.098	2.250	.140	.7570	.014	.024	.875	.875	92,400 101,800
96354-1414	.8750-14 UNJF-3A	1.293	.8677													
96354-1608	1.0000-8 UNJC-3A	1.500	1.0000	.380	.495	1.002	.310	.098	2.500	.160	.7570	.014	.024	1.000	1.000	121,200 132,600
96354-1612	1.0000-12 UNJF-3A	1.479	.9916													

1. MATERIAL: SPS TITAN™ ALLOY PER CHEMISTRY OF AMS 4958.
2. HEAT TREATMENT: 180 KSI MINIMUM ULTIMATE TENSILE STRENGTH. 108 KSI MINIMUM SHEAR STRENGTH.
3. MANUFACTURING REQUIREMENTS: HEAD TO BE FORGED. HEXAGON RECESS MAY BE FORGED OR MACHINED.
HEAD TO SHANK FILLET RADIUS TRANSITION SHALL BE SMOOTH AND CONTINUOUS AND COLD WORKING IS NOT REQUIRED.
THREADS TO BE ROLLED AFTER HEAT TREATMENT.
4. MECHANICAL REQUIREMENTS: TENSILE TEST SHALL BE PERFORMED WITH A MINIMUM OF 6 EXPOSED THREADS FROM THE
BEARING SURFACE OF THE NUT OR THREADED TEST BUSHING. SHEAR TESTING IS NOT REQUIRED.
FATIGUE TESTING IS NOT REQUIRED.
5. THREAD LENGTH: THE MINIMUM FULL THREAD LENGTH SHALL BE TWICE THE THREAD DIAMETER, PLUS 1/2 INCH OR 1/2 THE
LENGTH WHICH EVER IS THE THE GREATER. SCREWS TOO SHORT FOR THE FORMULA SHALL BE THREADED AS
CLOSE TO THE HEAD AS PRACTICAL. MAXIMUM THREAD LENGTH NEED NOT EXCEED 1.50 INCH FOR PARTS
UNDER .500 DIAMETER.
6. LENGTH TOLERANCE: THROUGH ONE INCH $\pm .015$; OVER ONE INCH THROUGH TWO INCHES $\pm .031$ $-.015$; OVER TWO INCHES $\pm .031$.
7. PARTS SHALL BE FREE FROM BURRS AND SHARP EDGES.
8. CHAMFER "U" PLUS INCOMPLETE THREADS SHALL NOT EXCEED TWO PITCHES.
9. PART NUMBER: 96354() () () () () ()

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E = NYLON (PATCH) PER MIL-DTL-18240
K = NYLON (PELLET) PER MIL-DTL-18240
M = NYTEMP PATCH
- = LENGTH IN SIXTEENTHS
H = CROSSDRILLED HEAD
NO LETTER = NO CROSSDRILLED HEAD
- = DIAMETER AND PITCH PER TABULATION
M = DRY FILM LUBRICANT PER AS5272 TYPE I
A = ANODIZE PER AMS2487
BASIC PART NUMBER

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10. PERFORMANCE REQUIREMENTS OF MIL-DTL-18240 APPLY TO SCREWS WITH NON-METALLIC LOCKING FEATURES, INCLUDING NYTEMP.®

(R)NYTEMP IS A REGISTERED TRADEMARK OF NYLOK FASTENER CORPORATION.

TM - SPS TITAN IS A TRADEMARK OF SPS TECHNOLOGIES, INC.

TOLERANCES $\pm .010$ AND $\pm 2^\circ$		TITLE SCREW, SOCKET HEAD CAP SPS TITAN ALLOY, 200 KSI F_{tu} APPLICATIONS TO 500°F	STANDARDS AND SPECIFICATIONS	
SURFACE ROUGHNESS 125			SPS-B-640	
UNLESS OTHERWISE NOTED			EXCEPT AS NOTED	
DRAFTED IN ACCORDANCE WITH ASME Y14.5M			PART NUMBER:	
DRAWN BY: STEVE FOSTER			96354()()()()()	
APPROVED: S FOSTER	DATE: 4/16/03			
APPROVED: S BUZOLITS	DATE: 11/22/04	SHEET 1 OF 1		