## \*\*\*DRS GENERATED\*\*\* PRINTED COPIES ARE UNCONTROLLED

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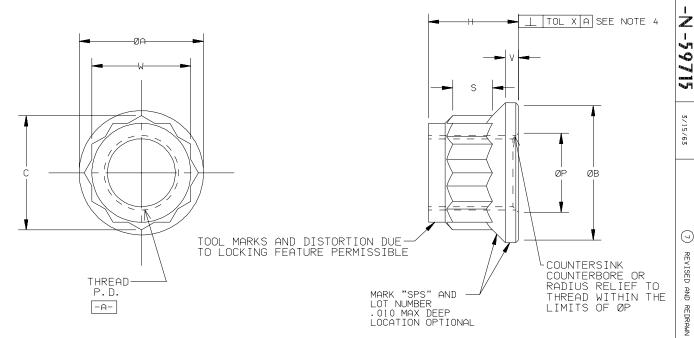
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DASH NUMBER	THREADS UNJF-3B	ØA MAX	ØB MIN	C MIN	H MAX	ØP MAX	S MIN	V MIN	MAX	MIN	X	Y	AXIAL STRENGTH LBS. MIN.	WEIGHT MAXIMUM LBS/100
1032	.1900-32	. 350	. 320	. 277	. 230	. 220	.080	.020	. 251	. 243	. 003	. 002	4,000	. 15
428	. 2500-28	. 438	. 408	. 347	. 300	. 280	. 100	. 027	. 313	. 305	. 003	.002	7,270	. 27
524	. 3125-24	. 531	. 501	. 419	. 385	. 343		.042	. 376	. 367	. 004	.002	11,600	. 50
624	. 3750-24	. 649	- 619	. 491	. 455	. 405	. 152	.067	. 439	. 430	. 005	. 002	17,600	. 85
720	. 4375-20	. 750	. 720	. 631	. 520	. 473	. 168	. 078	. 564	. 553	. 005	.003	23,700	1.45
820	. 5000-20	. 828	. 798	. 703		. 535	. 190	. 092	. 627	. 616	. 006	.003	32,500	2.08
918	.5625-18	. 938	. 908	. 775	. 680	. 597	. 230	. 100	. 690	. 679	. 008	.003	40,600	2. 76
1018	.6250-18	1.050	1.020	. 846	. 740	. 660	. 250	.110	. 752	. 741	. 008	.003	51,200	3.56

- 1. MATERIAL: TITANIUM ALLOY PER AMS 4928.
- 2. LUBRICANT: DRY FILM LUBRICANT.
- 3. FLUORESCENT PENETRANT INSPECT 100% PER SPS-N-269.
- 4. BEARING SQUARENESS: WHEN CHECKED AT A POINT MIDWAY BETWEEN THE I.D. AND O.D. OF THE BEARING SURFACE.
- 5. BEARING SURFACE: FLAT TO CONCAVE WITHIN "Y" T.I.R. WHEN CHECKED IN ACCORDANCE WITH SPS-G-1013.
- 6. DIMENSIONS ARE TO BE MET PRIOR TO LUBRICATION.
- 7. THREADS ARE BEFORE LUBRICATION PER MIL-S-8879.
- 8. DIMENSIONS ARE IN INCHES.
- 9. BREAK ALL SHARP EDGES.
- 10. PART NUMBER: CONSISTS OF BASIC PART NUMBER PLUS APPLICABLE DASH NUMBER EXAMPLE: FNT20-428 = .2500-28 UNJF-3B NUT
- 11. PART NUMBERS OTHER THAN LISTED ON THIS DRAWING SHALL NOT BE USED.
- 12. DESIGN AND USAGE LIMITATIONS: THE ULTIMATE TENSILE STRENGTH IS BASED ON 200 KSI AND THE TENSILE STRESS AREA. THESE NUTS ARE DESIGNED TO BE USED ON CLASS 3A EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
- 13. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

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.										
TOLERANCES ±.010 AND ±2°	THIS PRODUCT DRAWING		<b>Ent</b>	FSCM NO. 56878		DS AND SPECIFICATIONS				
SURFACE ROUGHNESS 125	IS DRAFTED IN ACCORDANCE		TECHNOLOGIES	CUSTODIAN: JENKINTOWN, PA.	- SPS-N-269 . CLASS II					
UNLESS OTHERWISE NOTED	WITH ASME Y14.5M	TITLE				E117 A A				
DRAWN BY:STEVE FOSTER	DATE:11/07/91	ITILE	NUT, DOUBLE HEXAGON, SELF-LOCKING,	EL ANGED	PART NUMBER:	FNT 20				
APPROVED: M ZATAVESKI DATE: 9/1/98			TITANIUM, 750°F, 200 KSI	. L , OLD		111120				
APPROVED: M   AWLER	DHIE - 9/1/98		111HN10H, 730 H, 200 N31		SHEET LOF 1					