



DASH NUMBER	THREADS UNJF-3B	ØA MAX	ØB MIN	C MIN	H MAX	ØP MAX	S MIN	V MIN	W		X	Y	AXIAL STRENGTH LBS. MIN.	WEIGHT MAXIMUM LBS/100
									MAX	MIN				
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	.120	.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	.600	.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

- MATERIAL: TITANIUM ALLOY PER AMS 4928.
- LUBRICANT: DRY FILM LUBRICANT.
- FLUORESCENT PENETRANT INSPECT 100% PER SPS-N-269.
- BEARING SQUARENESS: WHEN CHECKED AT A POINT MIDWAY BETWEEN THE I.D. AND O.D. OF THE BEARING SURFACE.
- BEARING SURFACE: FLAT TO CONCAVE WITHIN " Y" T.I.R. WHEN CHECKED IN ACCORDANCE WITH SPS-G-1013.
- DIMENSIONS ARE TO BE MET PRIOR TO LUBRICATION.
- THREADS ARE BEFORE LUBRICATION PER MIL-S-8879.
- DIMENSIONS ARE IN INCHES.
- BREAK ALL SHARP EDGES.
- PART NUMBER: CONSISTS OF BASIC PART NUMBER PLUS APPLICABLE DASH NUMBER
EXAMPLE: FNT20-428 = .2500-28 UNJF-3B NUT
- PART NUMBERS OTHER THAN LISTED ON THIS DRAWING SHALL NOT BE USED.
- 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.
- 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° SURFACE ROUGHNESS 125 UNLESS OTHERWISE NOTED DRAWN BY: STEVE FOSTER APPROVED: M ZATAVESKI APPROVED: M LAWLER	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M DATE: 11/07/91 DATE: 9/1/98	SPS TECHNOLOGIES	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS SPS-N-269 CLASS II
TITLE NUT, DOUBLE HEXAGON, SELF-LOCKING, FLANGED TITANIUM, 750°F, 200 KSI			PART NUMBER: FNT 20	
			SHEET 1 OF 1	