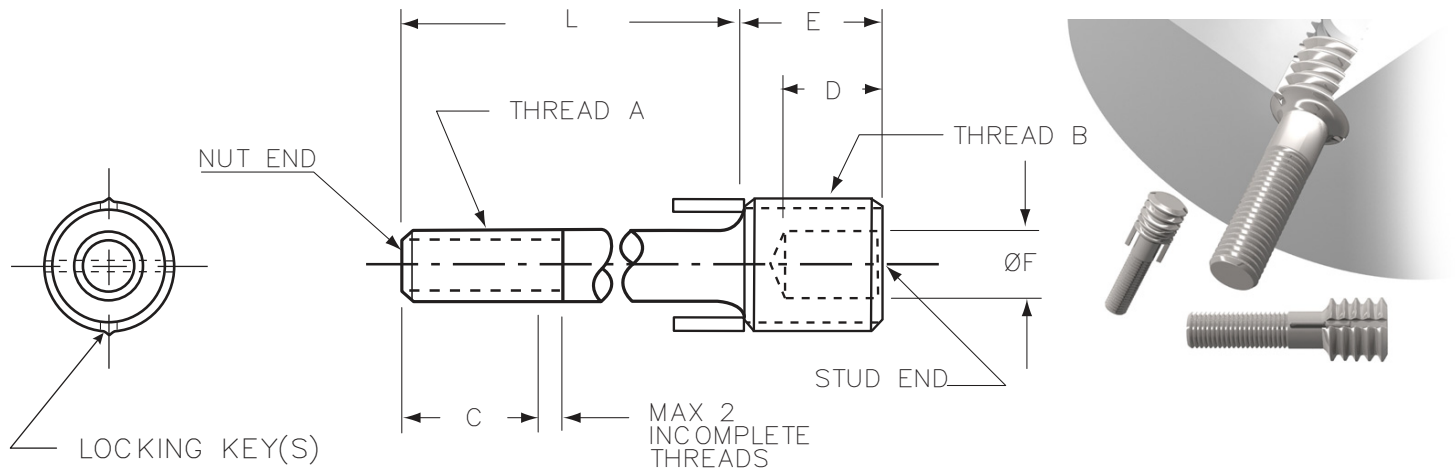
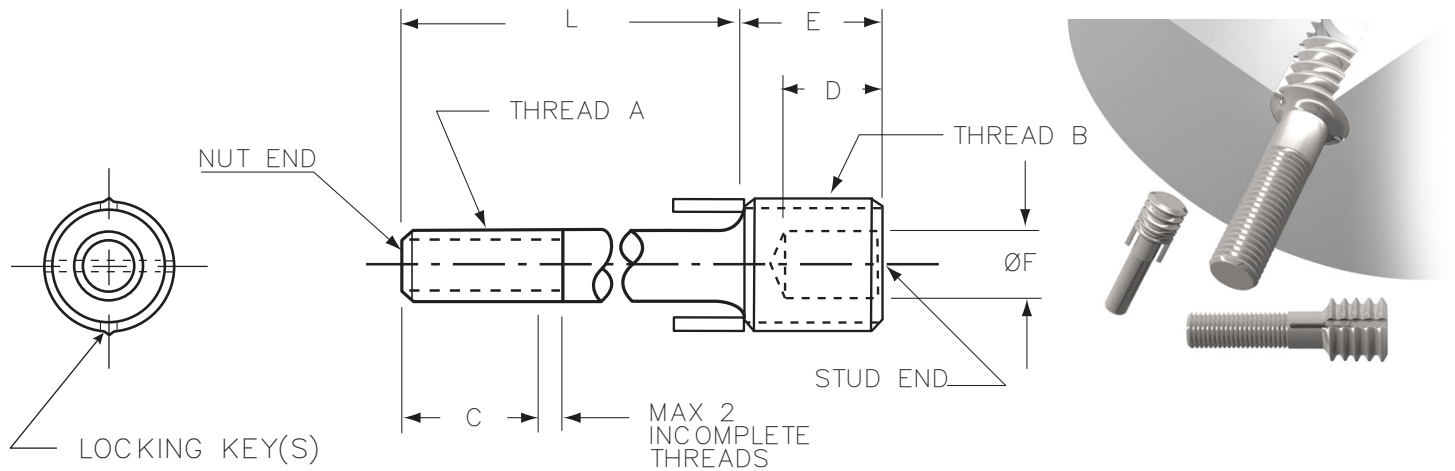




PROCUREMENT NUMBER	A NUT END THREAD UNJF-3A	B STUD END THD MOD MINOR DIA		C MIN	D	E	F ±.010	L ±.030	NO. OF LOCKING KEYS
		THREAD UNC-2A	MINOR DIA						
RA2009-2101	.1900-32	.3125-18	.256 .249	.410	-	.390 .360	-	.600	2
RA2009-2201	.2500-28	.3750-16	.320 .312	.691	.505 .445	.590 .570	.188	.813	2
RA2009-2202	.2500-28	.3750-16	.320 .312	.875	.505 .445	.590 .570	.188	2.050	2
RA2009-2203	.2500-28	.3750-16	.320 .312	.610	-	.360 .380	-	.750	2
RA2009-2301	.3125-24	.4375-14	.383 .375	.679	.585 .525	.650 .670	.250	.813	4
RA2009-2401	.3750-24	.5000-13	.440 .432	.720	-	.710 .690	-	.900	4

6. HEAT TREAT: STUD: HEAT TREAT TO 180 KSI PER AMS5663.
KEYS: 48 HRC MIN.
5. REFERENCE: INSTALLATION OF STUD PER MS51835
4. STUD SHALL BE FREE FROM ALL HANGING BURRS OR SLIVERS.
3. THREADS: NUT END: PER AS8879
STUD END: PER FED-STD-28/2. EXCEPT MINOR DIAMETERS MODIFIED AS SPECIFIED.
2. FINISH: KEY & STUD: PASSIVATE PER AMS-QQ-P-35.
1. MATERIAL: STUD: 718 INCONEL PER AMS5662
KEYS: 718 INCONEL PER AMS5662 (CHEMISTRY ONLY)

CAGE CODE 63EM5	DWG NO. RA2009 REV: NC SHEET 1 of 2	Drawn by:	Date: 12/11/2013
		Approved by:	Date: 12/12/2013



PROCUREMENT NUMBER	A NUT END THREAD UNJF-3A	B STUD END THD MOD MINOR DIA		C MIN	D	E	F ±.010	L ±.030	NO. OF LOCKING KEYS
		THREAD UNC-2A	MINOR DIA						
RA2009-3001	.1900-32	.3750-16	.320 .312	.410	.285 .235	.390 .360	.188	.600	2
RA2009-3002	.2500-28	.4375-14	.383 .375	.691	.505 .445	.590 .570	.250	.813	4
RA2009-3003	.2500-28	.4375-14	.383 .375	.875	.505 .445	.590 .570	.250	2.050	4
RA2009-3004	.2500-28	.4375-14	.383 .375	.610	.285 .235	.380 .360	.250	.750	4
RA2009-3005	.3125-24	.5000-13	.440 .432	.679	.585 .525	.670 .650	.310	.813	4
RA2009-3006	.3750-24	.5625-12	.503 .495	.720	.625 .565	.710 .690	.370	.900	4

6. HEAT TREAT: STUD: HEAT TREAT TO 180 KSI PER AMS5663.
KEYS: 48 HRC MIN.
5. REFERENCE: INSTALLATION OF STUD PER MS51835
4. STUD SHALL BE FREE FROM ALL HANGING BURRS OR SLIVERS.
3. THREADS: NUT END: PER AS8879
STUD END: PER FED-STD-28/2. EXCEPT MINOR DIAMETERS MODIFIED AS SPECIFIED.
2. FINISH: KEY & STUD: PASSIVATE PER AMS-QQ-P-35.
1. MATERIAL: STUD: 718 INCONEL PER AMS5662
KEYS: 718 INCONEL PER AMS5662 (CHEMISTRY ONLY)

CAGE CODE 63EM5	DWG NO. RA2009 REV: NC SHEET 2 of 2	Drawn by:	Date: 12/11/2013
		Approved by:	Date: 12/12/2013