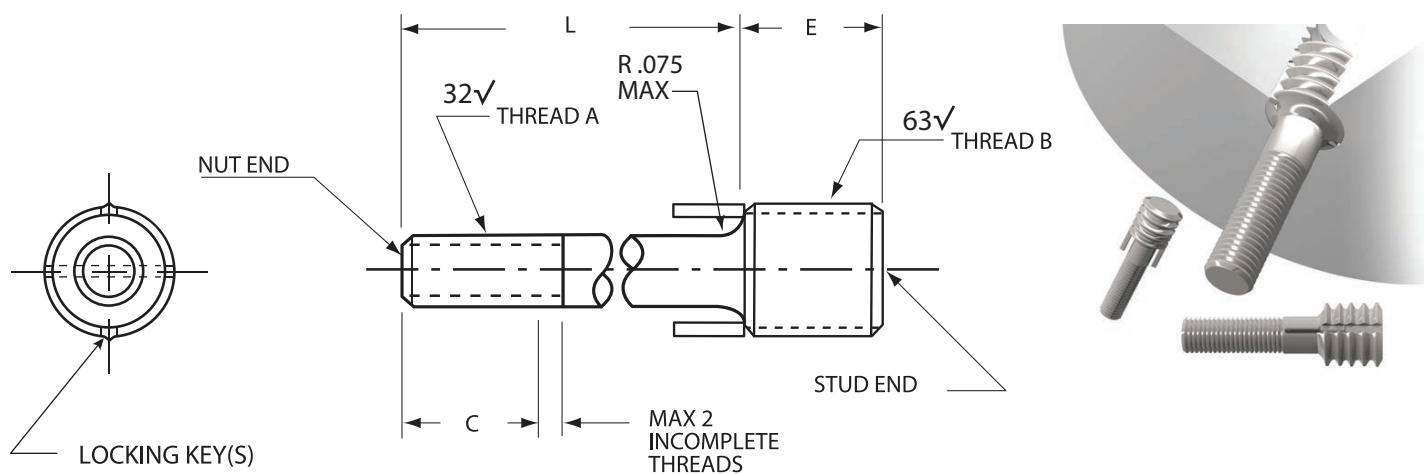




Example of Part Number

RA2010 - 0106

LENGTH NUMBER FROM TABLE III

THREAD CODE NUMBER FROM TABLES I, II

D R A W I N G N U M B E R

1. MATERIAL. STUD: 718 INCONEL PER AMS5662
KEYS: 718 INCONEL PER AMS5662 (CHEMISTRY ONLY)
2. FINISH. KEY & STUD: PASSIVATE PER AMS-QQP-35
3. TWO LOCKING KEYS ON -11,12, -21, AND -22; FOUR LOCKING KEYS ON ALL OTHER SIZES.
4. THREADS: NUT END: PER MIL-S-8879
STUD END: PER FED-STD-H28, EXCEPT MINOR DIAMETERS MODIFIED AS SPECIFIED HEREIN
5. STUD SHALL BE FREE FROM ALL HANGING BURRS OR SLIVERS
6. REFERENCE: INSTALLATION OF STUD PER MS51835
7. HEAT TREAT: STUD: HEAT TREAT TO 180 KSI PER AMS5663.
KEYS: 48 HRC MIN.

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		Approved by:	Date: 1/9/15



TABLE I - COURSE THREAD NUT END

THREAD CODE NUMBER	A NUT END THREAD UNJC - 3A	B STUD END THD MOD MINOR DIA		C * ± .030	E ± .015
		THREAD UNC-2A	MINOR DIA		
11	.190-24	.3125-18	.256 .249	.410	.312
12	.250-20	.375-16	.320 .312	.470	.375
13	.3125-18	.4375-14	.383 .375	.530	.437
14	.375-16	.500-13	.440 .432	.640	.500
15	.4375-14	.5625-12	.503 .495	.660	.562
16	.500-13	.625 -11	.565 .551	.780	.625

TABLE II - FINE THREAD NUT END

THREAD CODE NUMBER	A NUT END THREAD UNJF - 3A	B STUD END THD MOD MINOR DIA		C * ± .030	E ± .015
		THREAD UNC-2A	MINOR DIA		
21	.190-32	.3125-18	.256 .249	.410	.312
22	.250-28	.375-16	.320 .312	.470	.375
23	.3125-24	.4375-14	.383 .375	.530	.437
24	.375-24	.500-13	.440 .432	.640	.500
25	.4375-20	.5625-12	.503 .495	.660	.562
26	.500-20	.625 -11	.565 .551	.780	.625

*THIS DIMENSION DOES NOT APPLY TO DASH NUMBER IN TABLE III ABOVE THE HEAVY LINES

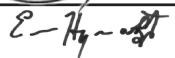
CAGE CODE 63EM5	DWG NO. RA2010 REV: NC SHEET 2 OF 3	Drawn by: 	Date: 1/9/15
		Approved by: 	Date: 1/9/15



TABLE III - LENGTHS

L NUT END ± .030	LENGTH NUMBER					
	NOMINAL DIAMETER					
	.190	.250	.3125	.375	.4375	.500
.375	06	06	N/A	N/A	N/A	N/A
.438	07	07	N/A	N/A	N/A	N/A
.500	08	08	N/A	N/A	N/A	N/A
.562	09	09	09	N/A	N/A	N/A
.625	10	10	10	10	10	N/A
.688	11	11	11	11	11	N/A
.750	12	12	12	12	12	12
.812	13	13	13	13	13	13
.875	14	14	14	14	14	14
.938	15	15	15	15	15	15
1.000	16	16	16	16	16	16
1.062	17	17	17	17	17	17
1.125	18	18	18	18	18	18
1.188	19	19	19	19	19	19
1.250	20	20	20	20	20	20
1.312	21	21	21	21	21	21
1.375	22	22	22	22	22	22
1.438	23	23	23	23	23	23
1.500	24	24	24	24	24	24
1.562	25	25	25	25	25	25
1.625	26	26	26	26	26	26
1.688	27	27	27	27	27	27
1.750	28	28	28	28	28	28
1.812	29	29	29	29	29	29
1.875	30	30	30	30	30	30
1.938	31	31	31	31	31	31
2.000	32	32	32	32	32	32
2.125	34	34	34	34	34	34
2.250	36	36	36	36	36	36
2.375	38	38	38	38	38	38
2.500	40	40	40	40	40	40
2.625	N/A	42	42	42	42	42
2.750	N/A	44	44	44	44	44
2.875	N/A	46	46	46	46	46
3.000	N/A	48	48	48	48	48
3.125	N/A	50	50	50	N/A	50
3.250	N/A	52	52	52	N/A	52
3.375	N/A	54	54	54	N/A	54
3.500	N/A	56	56	56	N/A	56
3.625	N/A	58	58	58	N/A	58
3.750	N/A	60	60	60	N/A	60
3.875	N/A	62	62	62	N/A	62
4.000	N/A	64	64	64	N/A	64

DASH NUMBERED PARTS ABOVE THE HEAVY LINE ARE THREADED TO THE STUD END AS SPECIFIED HEREIN.

THE MAXIMUM DISTANCE FROM THE STUD END TO THE FIRST FULL THREAD SHALL BE EQUAL TO THE SUM OF THE MAXIMUM FILLET RADIUS AND MAXIMUM OF TWO INCOMPLETE THREADS.

INCOMPLETE THREADS SHALL NOT ENTER FILLET AREA

N/A: NOT AVAILABLE

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