



PART NUMBER	A NUT END THREAD UNJF-3A REF	B STUD END THD MOD MINOR Ø		C MIN	D	E	F	G	H REF	NO. OF KEYS
		THREAD UNC-2A	MINOR Ø REF							
RA2008-1	.250-28	.375-16	.320 .312	.503	.385 .365	.655 .595	.198 .178	.300 .240	.190	2
RA2008-2	.250-28	.375-16	.320 .312	.628	.385 .365	.780 .720	.198 .178	.300 .240	.190	2
RA2008-3	.250-28	.375-16	.320 .312	.750	.385 .365	.905 .845	.198 .178	.300 .240	.190	2
RA2008-4	.250-28	.375-16	.320 .312	1.000	.385 .365	1.330 1.270	.198 .178	.300 .240	.190	2
RA2008-5	.375-24	.500-13	.440 .432	.640	.510 .490	.842 .782	.322 .302	.430 .370	.190	4
RA2008-6	.375-24	.500-13	.440 .432	.640	.510 .490	.905 .845	.322 .302	.430 .370	.190	4

1. MATERIAL: STUDS - TITANIUM 6AL-4V PER AMS4967 OR AMS4928
KEYS - 718 INCONEL PER AMS5662 (CHEMISTRY ONLY)
2. HEAT TREAT: STUDS - ANNEALED
KEYS - 48 HRC MINIMUM.
3. FINISH: STUDS - NONE
KEYS - PASSIVATE PER AMS-QQ-P-35
4. THREADS: NUT END - PER AS8879.
STUD END - PER FED-STD-28/2. EXCEPT MINOR DIA. MODIFIED AS SPECIFIED ABOVE.
5. STUD SHALL BE FREE FROM HANGING BURRS OR SLIVERS
6. REF. INSTALLATION OF STUDS SHALL BE IN ACCORDANCE WITH MS51835
7. THREADS, METALLURGICAL, GRINDING BURNS/DAMAGE, MICROSTRUCTURE, HYDROGEN, OXYGEN, GRAIN FLOW-THREADS PER TABLE 1 OF NAS4004

CAGE CODE 63EM5	DWG NO. RA2008 REV: NC SHEET 1 OF 1	Drawn by: <i>[Signature]</i>	Date: 07/23/2012
		Approved by: <i>[Signature]</i>	Date: 07/23/2012