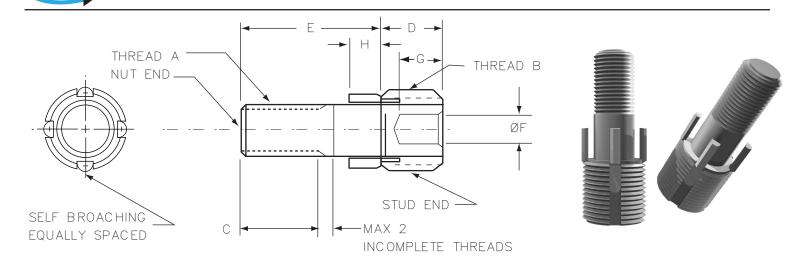


ROLAND AEROSPACE MANUFACTURER OF SPECIALIZED JET ENGINE COMPONENTS 13429 Western Ave. Gardena, California 90249



PART NUMBER	A NUT END THREAD		3 ND THD NOR Ø	C MIN	D	E	F	G	H REF	NO. OF KEYS
THO MID ETC	UNJF-3A REF	THREAD UNC-2A	MINOR Ø REF							IKETS
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	DWG NO. RA2008	Drawn by: Lines / hard	Date: 07/23/2012		
63EM5	REV: NC SHEET 1 OF 1	Approved by:	Date: 07/23/2012		