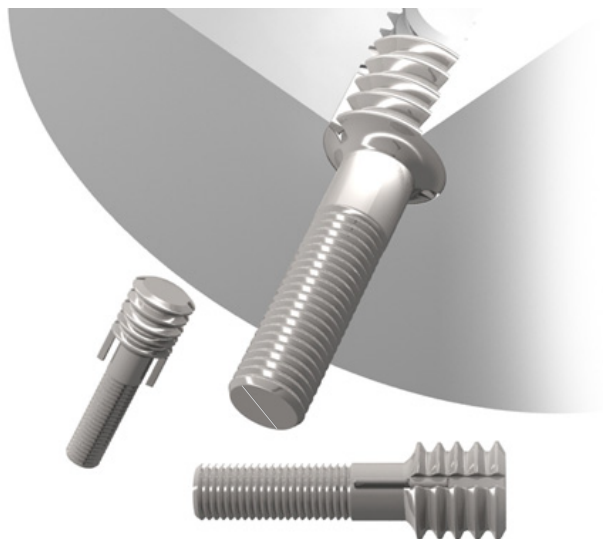


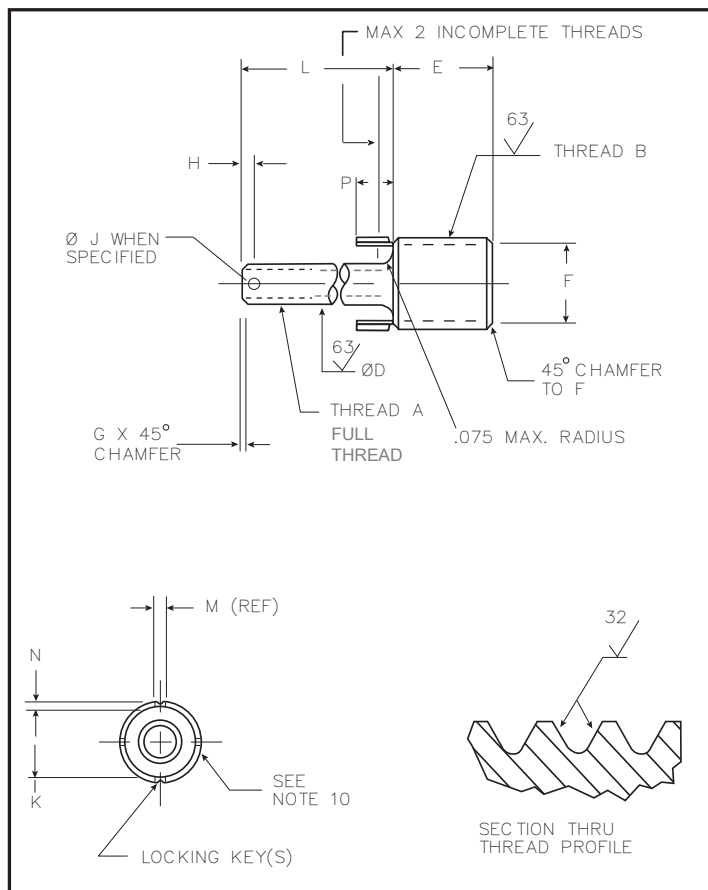


NOTES

- 1) MATERIAL: STUD: AMS5731, AMS5734 or AMS5737 A-286 CRES.
LOCKING KEYS: QQ-S-763 420 CRES.
- 2) HEAT TREAT: STUD: 140K.S.I. MINIMUM TENSILE STRENGTH.
LOCKING KEYS: 48HRC MINIMUM.
- 3) SURFACE TREATMENT : PASSIVATE PER QQ-P-35C OR
AMS-QQ-P-35.
- 4) SURFACE ROUGHNESS: IN ACCORDANCE WITH ANSI B46.1.
- 5) THREADS: NUT END PER MIL-S-8879.
STUD END PER H-28 EXCEPT MINOR DIAMETERS
MODIFIED AS SPECIFIED HEREIN.
- 6) NO HANGING BURRS OR SLIVERS ALLOWED WHICH MIGHT
BECOME DISLODGED DURING USE.
- 7) INSTALL IN ACCORDANCE WITH MS51835.
- 8) PERFORMANCE PER MIL-I-45915.
- 9) NUT END THREAD PITCH DIAMETER CONCENTRIC WITH
STUD END THREAD PITCH DIAMETER WITHIN .006 T. I.
- 10) SUPPLIED WITH 2 OR 4 LOCKING KEYS AS NECESSARY
TO FRACTURE NUT END APPROXIMATELY AT MINOR THREAD
DIAMETER DURING ROTATIONAL RESISTANCE TEST.
- 11) DASH MARK ON NUT END IDENTIFIES MATERIAL: A-286.
- 12) DIMENSIONS ARE REFERENCE FOR INSTALLATION
PURPOSE ONLY.
- 13) PART NUMBER EXAMPLE:

RA2013-01 06

LENGTH NUMBER FROM TABLE III.
THREAD CODE NUMBER FROM TABLE I OR II.
DRAWING NUMBER.



TITLE

**STUD, KEYLOCKED LIGHT WEIGHT, FULL THREAD
A286 CRES, PASSIVATED, 420 CRES KEYS**

CAGE CODE	DWG NO. RA2013	Drawn by:	Date: 02-17-16
		Approved by:	Date: 02-17-16
63EM5	REV: NC SHEET 1 of 3		

TABLE I – COARSE THREAD NUT END

THREAD CODE NUMBER		A NUT END FULL THD	B STUD END THD MOD MINOR DIA		D DIA	E $\pm .015$	F DIA $\pm .010$	G	H $\pm .020$	J $\pm .010$	K $\pm .004$	KEY DIMENSIONS		
		THREAD	THREAD	MINOR DIA								M REF	N $\pm .004$	P $\pm .015$
PLAIN	DRILL	UNJC – 3A	UNC – 2A											
01	11	.190–24	.3125–18	.256 .249	.189 .185	.312	.250	.060 .030	.141	.070	.220	.068	.040	.160
02	12	.250–20	.375–16	.320 .312	.249 .245	.375	.310	.060 .030	.156	.076	.284	.068	.040	.190
03	13	.3125–18	.4375–14	.383 .375	.312 .308	.437	.375	.060 .030	.172	.076	.345	.068	.040	.190
04	14	.375–16	.500–13	.440 .432	.374 .370	.500	.430	.060 .030	.172	.106	.407	.068	.040	.190
05	15	.4375–14	.5625–12	.503 .495	.437 .433	.562	.495	.060 .030	.172	.106	.469	.068	.040	.190
06	16	.500–13	.625–11	.565 .551	.499 .495	.625	.550	.060 .030	.172	.106	.532	.068	.040	.190

TABLE II – FINE THREAD NUT END

THREAD CODE NUMBER		A FULL NUT END	B STUD END THD MOD MINOR DIA		D DIA	E $\pm .015$	F DIA $\pm .010$	G	H $\pm .020$	J DIA $\pm .010$	K $\pm .004$	KEY DIMENSIONS		
		THREAD	THREAD	MINOR DIA								M REF	N $\pm .004$	P $\pm .015$
PLAIN	DRILL	UNJF – 3A	UNC – 2A											
21	31	.190–32	.3125–18	.256 .249	.189 .185	.312	.250	.060 .030	.141	.070	.220	.068	.040	.160
22	32	.250–28	.375–16	.320 .312	.249 .245	.375	.310	.060 .030	.156	.076	.284	.068	.040	.190
23	33	.3125–24	.4375–14	.383 .375	.312 .308	.437	.375	.060 .030	.172	.076	.345	.068	.040	.190
24	34	.375–24	.500–13	.440 .432	.374 .370	.500	.430	.060 .030	.172	.106	.407	.068	.040	.190
25	35	.4375–20	.5625–12	.503 .495	.437 .433	.562	.495	.060 .030	.172	.106	.469	.068	.040	.190
26	36	.500–20	.625–11	.565 .551	.499 .495	.625	.550	.060 .030	.172	.106	.532	.068	.040	.190

TITLE

**STUD, KEYLOCKED LIGHT WEIGHT, FULL THREAD
A286 CRES, PASSIVATED, 420 CRES KEYS**

CAGE CODE 63EM5	DWG NO. RA2013	Drawn by:	Date: 02-17-16
		Approved by:	Date: 02-17-16

TABLE III – LENGTHS						
L NUT END +-.030	LENGTH NUMBER					
	NOMINAL DIAMETER					
	.190	.250	.3125	.375	.4375	.500
.375	06	06	06	06	06	06
.438	07	07	07	07	07	07
.500	08	08	08	08	08	08
.562	09	09	09	09	09	09
.625	10	10	10	10	10	10
.688	11	11	11	11	11	11
.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
1.00	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
1.313	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	42	42	42	42	42	42
2.750	44	44	44	44	44	44
2.875	46	46	46	46	46	46
3.000	48	48	48	48	48	48
3.125	50	50	50	50	50	50
3.250	52	52	52	52	52	52
3.375	54	54	54	54	54	54
3.500	56	56	56	56	56	56
3.625	58	58	58	58	58	58
3.750	60	60	60	60	60	60
3.875	62	62	62	62	62	62
4.000	64	64	64	64	64	64

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

INCOMPLETE THREADS SHALL NOT ENTER FILLET AREA

		TITLE	
		STUD, KEYLOCKED LIGHT WEIGHT, FULL THREAD A286 CRES, PASSIVATED, 420 CRES KEYS	
CAGE CODE	DWG NO. RA2013	Drawn by:	Date: 02-17-16
63EM5	REV: NC SHEET 3 of 3	Approved by:	Date: 02-17-16