



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
TWO PENNSYLVANIA PLAZA, NEW YORK, N. Y. 10001

AMS 7253A
Superseding AMS 7253

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NUTS, SELF-LOCKING, ALLOY, CORROSION AND HEAT RESISTANT
High Strength, Prevailing Torque, All Metal
1400° F (760° C) Use, Unified "J" (MIL-S-8879) Thread Form

1. SCOPE:

- 1.1 Type: This specification covers all-metal, self-locking, prevailing-torque nuts, plate nuts, and gang channel nuts made of a corrosion and heat resistant nickel-base alloy.
- 1.2 Application: For use up to 1400° F (760° C) where high strength nuts with Unified "J" (MIL-S-8879) Thread form are required.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) and Aerospace Standards (AS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., Two Pennsylvania Plaza, New York, New York 10001.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods
AMS 2371 - Quality Assurance Sampling of Corrosion and Heat Resistant Alloys, Wrought Products Except Forgings
AMS 2410 - Silver Plating, Nickel Strike, High Bake
AMS 2411 - Silver Plating, High Temperature Application
AMS 5709 - Alloy Bars and Forgings, Corrosion and Heat Resistant, Nickel Base, 19.5Cr - 13.5Co - 4.3Mo - 3.0Ti - 1.4Al, Consumable Electrode or Vacuum Induction Melted, 1975 F (1079.4 C) Solution, Stabilization, and Precipitation Heat Treated
AMS 7471 - Bolts and Screws, Nickel Alloy, Corrosion and Heat Resistant, Upset Headed, Heat Treated, Roll Threaded, 1950 F (1065.6 C) Solution Heat Treatment

2.1.2 Aerospace Standards:

AS 954 - Design Data and Standardization of Thin Wall 12-Point Sockets and Box Wrenches for Aerospace Engine Use

- 2.2 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, Pennsylvania 19120.

2.2.1 Federal Specifications:

GGG-W-636 - Wrenches (Box, Open End, and Combination)

2.2.2 Military Specifications:

MIL-S-7742 - Screw Threads, Standard, Optimum Selected Series; General Specification for
MIL-L-7808 - Lubricating Oil, Aircraft Turbine Engine, Synthetic Base
MIL-S-8879 - Screw Threads, Controlled Radius Root with Increased Minor Diameter, General Specification for

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2.2.3 Bureau of Standards Handbook:

H28 - Screw-Thread Standards for Federal Services

2.3 ANSI Publications: Available from American National Standards Institute, Inc., 1430 Broadway, New York, New York 10018.

ANSI B46.1 - Surface Texture

3. TECHNICAL REQUIREMENTS:

3.1 Material: Shall be a corrosion and heat resistant nickel-base alloy, such as AMS 5709, as specified.

3.2 Construction: Each nut shall be a self-contained unit including the self-locking device. The locking device shall not operate by separate movement from the installation and shall not depend on pressure on the bearing surface for the locking action. The locking device shall be set to meet the locking torque requirements of 3.6.3 when used with MIL-S-8879 external threads.

3.3 Threads: Threads shall conform to MIL-S-8879 except that the finished product may have an anti-seizure allowance that provides a clearance fit as specified on the drawing.

3.3.1 Thread Squareness: The bearing surface shall be square with the thread pitch diameter axis within the limits specified on the drawing. Squareness shall be determined by a method agreed upon by purchaser and vendor. The squareness requirement shall apply to the complete bearing surface of the nut except that, for non-floating plate nuts having a bearing surface exceeding 1.5 times the thread major diameter, the squareness requirement shall, unless otherwise specified, apply only to the portion of the bearing surface of the nut contained within a diameter equal to 1.5 times the thread major diameter. The nuts to be inspected shall permit at least 3 complete turns of engagement on the thread arbor of the gage; plating or other coating may be stripped if necessary to meet this requirement. Multipiece floating plate nuts shall have the nut element removed from the retainer for checking thread squareness.

3.3.2 Plating or Coating Allowance: Unless otherwise specified, internal thread plating or coating allowance shall be as specified in MIL-S-7742.

3.4 Finish: Unless otherwise specified, nuts shall be silver plated in accordance with AMS 2411. On nuts with thread sizes 0.250 in. (6.35 mm) and larger, the plating thickness shall be not less than 0.0002 in. (0.005 mm) when measured on the thread pitch diameter. Microscopic measurement on a sectioned nut shall be used as a referee method. Nuts with thread sizes 0.190 in. (4.83 mm) and smaller shall show complete plate coverage on the threads. Plating on other surfaces shall be 0.0003 - 0.0006 in. (0.008 - 0.015 mm) thick.

3.5 Lubrication: The nuts may be provided with a wax-type coating which will prevent nut-bolt seizure provided such treatment is applicable to all production nuts of the same part number.

3.6 Performance: Nuts shall conform to the following requirements. Unless otherwise specified, all tests shall be conducted on representative nuts assembled on bolts of any convenient length and on which the nuts will assemble freely, with the fingers, up to the self-locking device.

3.6.1 Axial Strength: Not less than 4 nuts in the as-received condition and 4 nuts which have been heated to $1400^{\circ}\text{F} \pm 15$ ($760^{\circ}\text{C} \pm 8.3$), held at heat for 6 hr \pm 15 min., and cooled to room temperature shall be assembled on alloy steel bolts hardened and tempered to not lower than 40 HRC or equivalent and having threads in accordance with 3.7. Each nut-bolt assembly shall be pulled, at room temperature, in tension, axially, using a bearing plate to grip the nut. The diameter of the hole in the bearing plate shall be 0.030 - 0.034 in. (0.76 - 0.86 mm) greater than the basic major diameter of the bolt thread and the bearing plate thickness shall be not less than the major diameter of the bolt thread. Edges of the hole in the bearing plate shall be broken 0.010 - 0.015 in. (0.25 - 0.38 mm). Axial strength of the nut shall be not lower than the values specified in Table I and the nuts shall not crack during test; tests need not be run to destruction.

TABLE I

Nominal Thread Size	Axial Strength	
	lb	(N)
0.112 -40	893	(3,972)
0.112 -48	1,017	(4,524)
0.138 -32	1,340	(5,960)
0.138 -40	1,570	(6,983)
0.164 -32	2,153	(9,576)
0.164 -36	2,313	(10,288)
0.190 -32	3,150	(14,011)
0.250 -28	5,868	(26,101)
0.3125-24	9,432	(41,954)
0.375 -24	14,562	(64,772)
0.4375-20	19,620	(87,270)
0.500 -20	26,748	(118,975)
0.5625-18	33,984	(151,161)
0.625 -18	43,200	(192,154)

3.6.1.1 The axial strength requirement for thread sizes not shown may be calculated from the following formula:

3.6.1.1.1 In U. S. Conventional Units:

$$S = 0.7854 (D - 2h_b)^2 \times 180,000$$

where, S = Axial strength requirement in lb
 D = Max major diameter of external thread in in.
 h_b = Twice the external thread addendum in in.

3.6.1.1.2 In SI Units:

$$S = 0.7854 (D - 2h_b)^2 \times 1241$$

where, S = Axial strength requirement in N
 D = Max major diameter of external thread in mm
 h_b = Twice the external thread addendum in mm

3.6.1.2 Clinch Nuts: Nuts with shanks designed to be flared at assembly (See Fig. 1) shall be tested as in 3.6.1 except that the hole in the bearing plate shall be 0.004 - 0.008 in. (0.10 - 0.20 mm) greater than the maximum allowable shank diameter. It is not necessary to flare the shank for this test. The bearing plate hole shall be chamfered sufficiently to clear the clinch nut bearing surface-to-shank maximum fillet.

3.6.2 Wrench Torque: At least 3 nuts shall be tested at room temperature for wrench torque by assembling a nut on a bolt having sufficient strength. The nut shall be tightened against a bushing with a hole diameter as in 3.6.1 and having hardness not lower than 40 HRC or equivalent and surface texture on the bearing surface of 63 microinches (1.6 μm) or smoother. Nuts shall withstand 12 successive applications of the torque specified in Table II without destroying the wrenchability of the nut. Wrenches used for this test shall be open end type conforming to Federal Specification GGG-W-636, Type IV for hexagon nuts and socket type conforming to AS 954 for double hexagon nuts. This test shall be applicable only to nuts which have provisions for use of a wrench. For this test only, all nuts shall be cleaned to remove all trace of any lubricant, wax, or anti-seize coating.

TABLE II

Nominal Thread Diameter		Wrench Torque	
Inch	(Millimeters)	lb-in.	(N·m)
0.112	(2.84)	14	(1.58)
0.138	(3.51)	30	(3.39)
0.164	(4.17)	40	(4.52)
0.190	(4.83)	82	(9.27)
0.250	(6.35)	205	(23.16)
0.3125	(7.94)	450	(50.75)
0.375	(9.52)	730	(82.49)
0.4375	(11.11)	1130	(127.69)
0.500	(12.70)	1650	(186.45)
0.5625	(14.29)	2000	(226.00)
0.625	(15.88)	2750	(310.75)

3.6.3 Self-Locking Torque: The self-locking torque shall be measured for not less than 10 nuts as received and 10 nuts after conditioning as in 3.6.3.1. Test bolts conforming to 3.7 shall be used. Test shall be conducted at room temperature with no axial stress and with nuts assembled on bolts so that the bolts project through the nuts not less than 3 turns at start of test. Test shall be run in such a manner that a dependable measure of torque will be obtained. The increase in temperature of the nuts during test shall not exceed 75 F (42 C) degrees. The maximum locking torque reading and the minimum breakaway torque shall not exceed the values specified in Table III. The maximum locking torque is the highest self-locking torque encountered in any installation or removal cycle with the nut in motion and with no load on the base of the nut. The breakaway torque is that torque required to start nut or bolt rotation from a fixed position during a removal cycle with no load on the base of the nut.

TABLE III

Nominal Thread Size	Minimum Breakaway Torque	Maximum Locking Torque	
		(1)	(2)
0.112 -40	8 oz-in.	4 lb-in.	8 lb-in.
0.112 -48	8 oz-in.	4 lb-in.	8 lb-in.
0.138 -32	16 oz-in.	7 lb-in.	14 lb-in.
0.138 -40	16 oz-in.	7 lb-in.	14 lb-in.
0.164 -32	24 oz-in.	11 lb-in.	22 lb-in.
0.164 -36	24 oz-in.	11 lb-in.	22 lb-in.
0.190 -32	32 oz-in.	15 lb-in.	30 lb-in.
0.250 -28	3.5 lb-in.	30 lb-in.	60 lb-in.
0.3125-24	6.5 lb-in.	60 lb-in.	120 lb-in.
0.375 -24	9.5 lb-in.	80 lb-in.	160 lb-in.
0.4375-20	14.0 lb-in.	100 lb-in.	200 lb-in.
0.500 -20	18.0 lb-in.	150 lb-in.	300 lb-in.
0.5625-18	24.0 lb-in.	200 lb-in.	400 lb-in.
0.625 -18	32.0 lb-in.	300 lb-in.	600 lb-in.

TABLE III (SI)

Nominal Thread Size	Minimum Breakaway Torque	Maximum Locking Torque	
		(1)	(2)
0.112 -40	0.06 N·m	0.45 N·m	0.90 N·m
0.112 -48	0.06 N·m	0.45 N·m	0.90 N·m
0.138 -32	0.11 N·m	0.79 N·m	1.58 N·m
0.138 -40	0.11 N·m	0.79 N·m	1.58 N·m
0.164 -32	0.17 N·m	1.24 N·m	2.49 N·m
0.164 -36	0.17 N·m	1.24 N·m	2.49 N·m
0.190 -32	0.23 N·m	1.70 N·m	3.39 N·m
0.250 -28	0.40 N·m	3.39 N·m	6.78 N·m
0.3125-24	0.73 N·m	6.78 N·m	13.56 N·m
0.375 -24	1.07 N·m	9.04 N·m	18.08 N·m
0.4375-20	1.58 N·m	11.30 N·m	22.60 N·m
0.500 -20	2.03 N·m	16.95 N·m	33.90 N·m
0.5625-18	2.71 N·m	22.60 N·m	45.20 N·m
0.625 -18	3.62 N·m	33.90 N·m	67.80 N·m

(1) At initial installation, values may be exceeded for 20% of the parts tested when bolt first enters locking feature provided all parts are within the specified limits after a minimum length of two pitches, including chamfer, protrudes through the nut.

(2) Maximum for removal after conditioning only.

3.6.3.1 **Conditioning:** Nut-bolt assemblies shall be axially loaded initially to 85,000 psi (586 MPa) at room temperature in a spacer-type fixture in accordance with 3.6.3.1.2. Loading shall be determined by elongation measurement of the bolt at room temperature. Bolt and fixture lengths conforming to 3.7 shall be used. Allow assembly to remain stressed at room temperature for at least 1 hr., re-measure, and adjust loading to agree with the required stress. The assemblies shall then be heated in a furnace to 1400° F ± 15 (760° C ± 8.3), held at heat for 6 hr ± 15 min., removed, cooled to room temperature, and unloaded by backing off nut 1/2 turn. Breakaway torque shall be measured at this point. In the case of wrenchable nuts, the nut shall be turned relative to the fixture; in the case of anchor or channel nuts, the bolt head shall be turned. The wrenchability of the tested nuts shall not be destroyed by the test.

3.6.3.1.1 **Loading:** The correct elongation for bolts to load the nuts to 85,000 psi (586 MPa) shall be determined by using a modulus of elasticity of 31,000,000 psi (213.7 GPa). Stress area of the bolt shall be based on the basic (maximum) minor diameter of the thread. The elongation of bolts for nut sizes not listed herein shall be 0.002742L, where L = bushing length as in Figure 2.

3.6.3.1.2 **Fixture:** The spacer-type fixture shall be made of AMS 5709 nickel alloy. The diameter of the bolt hole in the fixture shall be 0.030 - 0.034 in. (0.76 - 0.86 mm) greater than the basic major diameter of the bolt thread (See Fig. 2). Fixture may be counter-bored 0.006 in. ± 0.002 (0.015 mm ± 0.05) greater than the maximum allowable shank diameter of clinch nuts to permit the spacer to seat onto the bearing surface of the nut.

3.6.4 **Permanent Set:** At least three nuts shall be assembled on a maximum mandrel (See Fig. 3) so that the mandrel projects through the nut not less than three turns. Nuts shall then be removed from the maximum mandrel and assembled on a minimum mandrel (See Fig. 4) in the same manner. Tests shall be conducted at room temperature with no axial stress. The nuts shall not exceed the maximum locking torque of Table III during the installation or removal cycle on the maximum mandrel and shall not show less than the minimum breakaway torque of Table III at the start of the removal cycle on the minimum mandrel.

- 3.6.5 **Reusability:** Nuts shall be assembled on test bolts conforming to 3.7 and tested in accordance with 3.6.3 as modified below. After testing, nut threads shall show no distortion, galling, or scratches of such depth as to prevent reassembly of nut freely, with the fingers, up to the self-locking device. Bolt threads shall remain servicable and permit assembly of a new nut freely, with the fingers, up to the self-locking device.
- 3.6.5.1 **As Received:** Nuts shall be installed and completely removed from the bolt 12 consecutive times. Except for the first installation, the nuts shall not exceed the maximum locking torque of Table III during the installation or removal cycle on the maximum mandrel and shall not show less than the minimum breakaway torque of Table III at the start of the removal cycle on the minimum mandrel.
- 3.6.5.2 **Conditioned:** Conditioning cycles shall be performed in accordance with 3.6.3.1. The nuts shall be completely removed from the bolt after each cycle of conditioning. The conditioning test shall be run for 5 consecutive cycles, using the same nut, bolt, and spacer. The maximum locking torque and the minimum breakaway torque for each cycle shall not exceed the limits specified in Table III.
- 3.6.6 **Vibration:** Ten nuts of the type to be tested for the sizes listed below shall be installed on a test bolt conforming to 3.7 on a test fixture as in 3.6.3.1.2. The assembly torque values shall be as specified in Table IV. For sizes not shown, the torque shall be as agreed upon by purchaser and vendor. Testing of nuts other than hexagon or double hexagon wrenching types shall be as agreed upon by purchaser and vendor.

TABLE IV

Nominal Thread Size	Assembly Torque	
	lb-in.	(N·m)
0.164 -32	22	(2.49)
0.164 -36	22	(2.49)
0.190 -32	30	(3.39)
0.250 -28	60	(6.78)
0.3125-24	120	(13.56)
0.375 -24	160	(18.08)
0.4375-20	200	(22.60)
0.500 -20	300	(33.90)
0.5625-18	400	(45.20)
0.625 -18	600	(67.80)

Five nuts shall be removed from the test bolts and reinstalled four additional times to the torque values specified for the thread size. The other five assembled nuts shall be baked at $1400^{\circ}\text{F} + 15$ ($760^{\circ}\text{C} + 8.3$) for $6\text{ hr} + 15\text{ min.}$ and air cooled; these nuts shall then be removed and reinstalled four additional times to the torque values specified for the thread size. The five baked nuts and the five unbaked nuts shall be assembled on the vibration test fixture (See Fig. 5) on test bolts and vibration tested at room temperature. Assemblies of nuts having Class 3B threads shall be vibrated 30,000 cycles and assemblies of nuts having Class 3BG threads shall be vibrated 15,000 cycles at a frequency of 1750 - 1800 cpm (29.2 - 30.0 Hz) and an amplitude of 0.435 - 0.465 in. (11.05 - 11.81 mm). The assembly shall traverse the entire length of the slots in the test fixture. Reference lines shall be scribed, or other suitable markings made, to determine the amount the nut turns on the test bolt during vibration test. The relative rotation between any nut and bolt shall be not greater than 360 deg (6.28 rad). The nuts shall not have developed any cracks or broken segments, as shown by examination at 10X magnification.

- 3.6.7 **Flarability:** Unless otherwise specified, the shank of clinch nuts shall be capable of being flared without cracking when flared with a 60-deg (1.05-rad) included angle conical tool to a diameter equal to 115% of the maximum allowable shank diameter.

3.6.8 **Push Out:** This requirement is applicable only to gang channel nuts, floating plate nuts, and non-floating plate nuts. At least five nuts shall be screwed or clamped to a steel plate or plates of a thickness equal to or greater than the basic major diameter of the nut thread. The bolt hole in the plate shall be located within 0.010 in. (0.25 mm) radius of true position in relation to the nut minor diameter when the nut is at basic position. The screw or clamping head diameter shall not exceed 1.5 times the rivet hole diameter and shall employ the rivet holes or be centered over same. The rivet hole size and its location from the thread axis of the nut in gang channel nut assemblies shall be as shown in Table V, unless otherwise specified. With the push out stud or device hemispherical end inserted against the base of the nut thread, the push out load specified in Table V shall be applied evenly to the nut on a line perpendicular to the mounting plane of the nut. When subjected to the push out load, the nut shall not be pushed out of the retainer of any type of plate nut or gang channel nut or effect a permanent deformation axial with the threaded element of more than 0.030 in. (0.76 mm) when measured at the thread centerline between the steel plate and the base of the nut retainer. Any deformation that will prevent a bolt from being assembled freely with the fingers is not permitted.

TABLE V

Nominal Thread Diameter Inch	Rivet Hole Diameter Inch	Hole Location (Distance From Nut Thread Axis) Inch	Push Out Load lb, min
0.112	0.093 - 0.103	0.334 - 0.354	40
0.138	0.093 - 0.103	0.334 - 0.354	60
0.164	0.093 - 0.103	0.334 - 0.354	80
0.190	0.093 - 0.103	0.334 - 0.354	100
0.250	0.093 - 0.013	0.490 - 0.510	125
0.3125	0.125 - 0.135	0.490 - 0.510	125
0.375	0.125 - 0.135	0.490 - 0.510	125
0.4375	0.125 - 0.135	0.552 - 0.572	125
0.500	0.125 - 0.135	0.615 - 0.635	125
0.5625	0.125 - 0.135	0.678 - 0.698	125
0.625	0.125 - 0.135	0.740 - 0.760	125

TABLE V (SI)

Nominal Thread Diameter Millimeters	Rivet Hole Diameter Millimeters	Hole Location (Distance From Nut Thread Axis) Millimeters	Push Out Load N, min
2.84	2.36 - 2.62	8.48 - 8.99	177.9
3.51	2.36 - 2.62	8.48 - 8.99	266.9
4.17	2.36 - 2.62	8.48 - 8.99	355.8
4.83	2.36 - 2.62	8.48 - 8.99	444.8
6.35	2.36 - 2.62	12.45 - 12.95	556.0
7.94	3.18 - 3.43	12.45 - 12.95	556.0
9.52	3.18 - 3.43	12.45 - 12.95	556.0
11.11	3.18 - 3.43	14.02 - 14.53	556.0
12.70	3.18 - 3.43	15.62 - 16.13	556.0
14.29	3.18 - 3.43	17.22 - 17.73	556.0
15.88	3.18 - 3.43	18.80 - 19.30	556.0

3.6.9 **Torque Out:** This requirement is applicable only to gang channel nut assemblies, floating plate nuts, and non-floating plate nuts. At least 5 nuts shall be prepared as in 3.6.8 and subjected to the torque out values in Table VI, first in the clockwise direction and then in the counterclockwise direction. The diameter of the torque stud shall have a maximum diametral clearance of 0.010 in. (0.25 mm) in the test plate. The torque stud shall be provided with a shoulder to seat against the base of the nut element and may incorporate a suitable bushing. Reverse loading may be accomplished by use of a check nut assembled onto the stud threads that protrude through the top of the nut. This test shall be performed with no axial load on the bearing surface of the nut. The nut assembly shall withstand the applied torque without cracking, rupture, or being deformed sufficiently to prevent normal use of the nut. Nuts used in push out test shall be used for this test.

TABLE VI

Nominal Thread Diameter		Torque Out Load, min	
Inch	(Millimeters)	lb-in.	(N·m)
0.112	(2.84)	20	(2.26)
0.138	(3.51)	30	(3.39)
0.164	(4.17)	45	(5.08)
0.190	(4.83)	60	(6.78)
0.250	(6.35)	100	(11.30)
0.3125	(7.94)	160	(18.08)
0.375	(9.52)	240	(27.12)
0.4375	(11.11)	350	(39.55)
0.500	(12.70)	450	(50.85)
0.5625	(14.29)	600	(67.80)
0.625	(15.88)	900	(101.70)

3.7 **Test Bolts:** Except as specified in 3.6.1, test bolts shall conform to AMS 7471 and shall have threads conforming to the requirements of MIL-S-8879. All test bolts, including those specified in 3.6.1, shall have lengths as shown in Table VII:

TABLE VII

Nominal Thread Diameter Inch	Nominal Bolt Length Inches	Fixture Length Inches	Required Bolt Elongation Inch	Reference Part No. (1)
0.112	1.000	0.735 - 0.765	0.0021	---
0.138	1.500	1.109 - 1.139	0.0031	MS9694-22
0.164	2.000	1.569 - 1.599	0.0043	MS9695-29
0.190	2.500	2.010 - 2.040	0.0056	MS9696-33
0.250	2.500	1.941 - 1.971	0.0054	MS9697-33
0.3125	2.500	1.845 - 1.875	0.0051	MS9698-31
0.375	2.500	1.823 - 1.853	0.0050	MS9699-29
0.4375	2.500	1.718 - 1.748	0.0048	MS9700-28
0.500	2.500	1.621 - 1.651	0.0045	MS9701-26
0.5625	2.500	1.518 - 1.548	0.0042	MS9702-25
0.625	2.500	1.433 - 1.463	0.0040	---

TABLE VII (SI)

Nominal Thread Diameter Millimeters	Nominal Bolt Diameter Millimeters	Fixture Length Millimeters	Required Bolt Elongation Millimeters	Reference Part No. (1)
2.84	25.40	18.67 - 19.43	0.053	---
3.51	38.10	28.17 - 28.93	0.079	MS9694-22
4.17	50.80	39.85 - 40.61	0.109	MS9695-29
4.83	63.50	51.05 - 41.82	0.142	MS9696-33
6.35	63.50	49.30 - 50.06	0.137	MS9697-33
7.94	63.50	46.86 - 47.62	0.130	MS9698-31
9.52	63.50	46.30 - 47.07	0.127	MS9699-29
11.11	63.50	43.64 - 44.40	0.122	MS9700-28
12.70	63.50	41.17 - 41.94	0.114	MS9701-26
14.29	63.50	38.56 - 39.32	0.107	MS9702-25
15.88	63.50	36.40 - 37.16	0.102	---

(1) Reference part numbers are for bolts having UNJF threads.

- 3.8 **Uncoated Nuts:** Uncoated nuts that have threads overcut for coating at assembly shall be plated for test purposes as in 3.4. Uncoated nuts permanently attached to brackets or other similar parts shall be checked with bolts plated in accordance with AMS 2410 or AMS 2411 and having plate thickness of 0.0003 - 0.0006 in. (0.008 - 0.015 mm). Plated bolts shall meet the requirements of 3.7 before plating.
- 3.9 **Test Lubrication:** Bolts threads shall be lubricated with MIL-L-7808 oil before each installation of the nut.
- 3.10 **Quality:** Nuts shall be uniform in quality and condition, clean, sound, and free from fins, burrs, cracks, tool marks, and other imperfections detrimental to their performance.
4. **QUALITY ASSURANCE PROVISIONS:**
- 4.1 **Responsibility for Inspection:** The vendor of parts shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to assure that the parts conform to the requirements of this specification.
- 4.2 **Classification of Tests:**
- 4.2.1 **Acceptance Tests:** Tests to determine conformance to material (3.1), locking torque as-received (3.6.3), reusability as-received (3.6.5), and flarability (3.6.7) requirements are classified as acceptance or routine control tests.
- 4.2.2 **Qualification Tests:** Tests to determine conformance to all other technical requirements of this specification are classified as qualification or periodic control tests.
- 4.3 **Sampling:** Shall be as follows:
- 4.3.1 **Acceptance Tests:**
- 4.3.1.1 **Material:** In accordance with AMS 2371.
- 4.3.1.2 **Performance:** As specified herein.
- 4.3.2 **Qualification Tests:** As specified herein or as agreed upon by purchaser and vendor.

4.4 Reports:

- 4.4.1 The vendor shall furnish with, or prior to, the first shipment of parts of each type and material three copies of a report of test data showing that the parts conform to all technical requirements of this specification.
- 4.4.2 The vendor of parts shall furnish with each shipment three copies of a report stating that the composition of the parts conforms to the requirements of the applicable material specification and showing the results of tests to determine conformance to the locking torque and reusability as-received and the flarability requirements of this specification. This report shall include the purchase order number, material specification number and its revision letter if any, this specification number and its revision letter, contractor or other direct supplier of material, part number, and quantity.
- 4.5 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the parts may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the parts represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

- 5.1 Identification: Nuts of each different part number shall be packed in separate containers. Each container shall be marked to show the following information:

NUTS, SELF-LOCKING, ALLOY, CORROSION AND HEAT RESISTANT
AMS 7253A
PART NUMBER _____
PURCHASE ORDER NUMBER _____
QUANTITY _____
MANUFACTURER'S IDENTIFICATION _____

- 5.2 Packaging: Containers of parts shall be prepared for shipment in accordance with commercial practice to assure carrier acceptance and safe transportation to the point of delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.
6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
7. REJECTIONS: Parts not conforming to this specification or to authorized modifications will be subject to rejection.
8. NOTES:
- 8.1 Marginal Indicia: No phi (\emptyset) symbol is used to indicate where technical changes have been made in this specification because of the extensive nature of all changes.
- 8.2 Definition of "Capability": The words "shall be capable of" are used to indicate characteristics or properties required in the product but for which testing of each lot is not required. However, if such testing is performed, material not conforming to the requirements may be rejected.

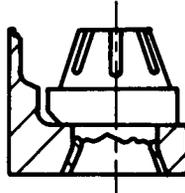
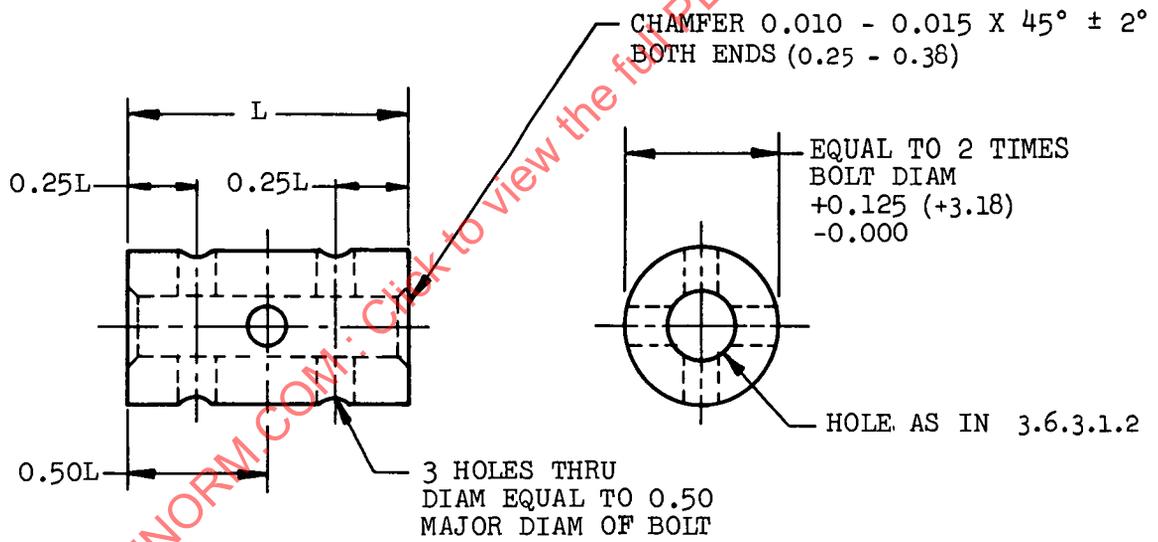
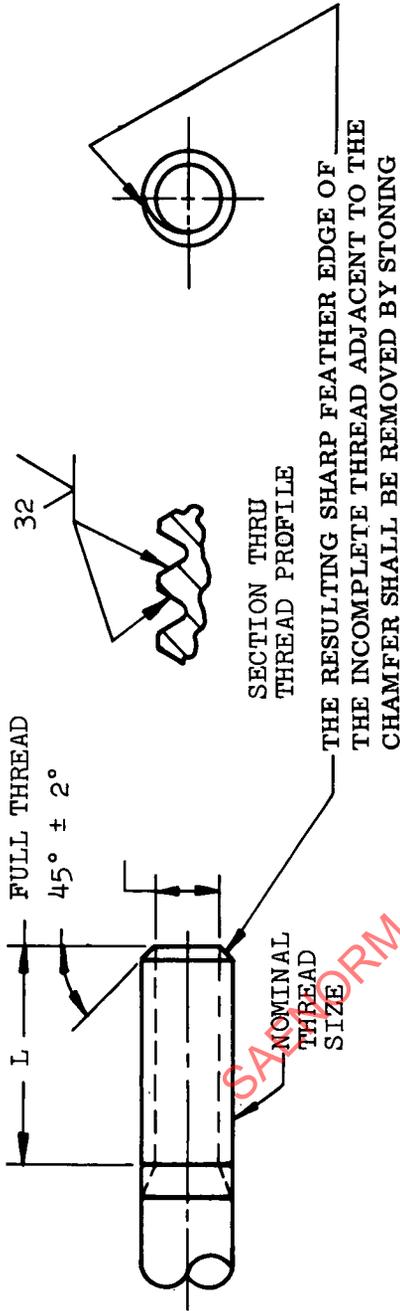


Figure 1



DIMENSIONS ARE IN INCHES (MILLIMETERS)

Figure 2

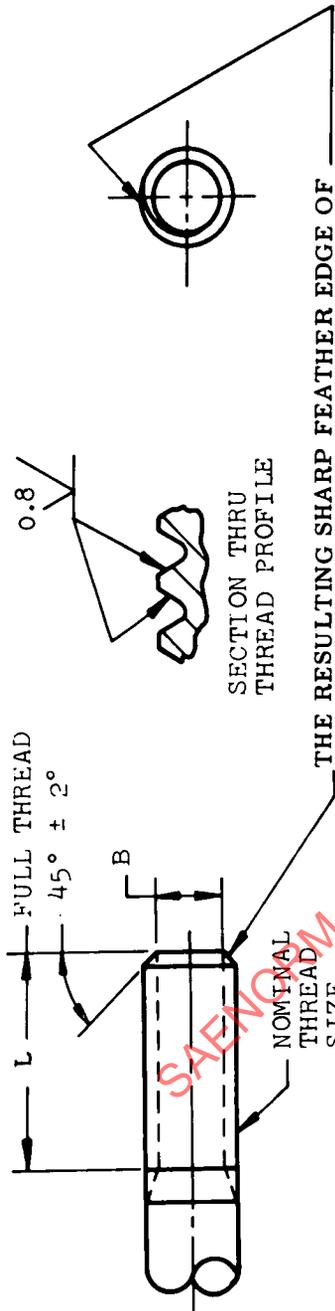


Nominal Thread Size	Major Diameter Inch	Pitch Diameter Inch	Minor Diameter Inch, max	Lead Error Tolerance Inch	Half Angle Tolerance plus and minus	"B" Inch	Length "L" in., min
0.112 -40	0.1069-0.1094	0.0949-0.0953	0.0832	0.0002	0°20'	0.063-0.083	0.224
0.112 -48	0.1075-0.1098	0.0977-0.0981	0.0880	0.0002	0°30'	0.068-0.088	0.224
0.138 -32	0.1320-0.1350	0.1167-0.1171	0.1019	0.0003	0°15'	0.082-0.102	0.276
0.138 -40	0.1329-0.1354	0.1209-0.1213	0.1092	0.0002	0°15'	0.089-0.109	0.276
0.164 -32	0.1580-0.1610	0.1427-0.1431	0.1279	0.0003	0°15'	0.108-0.128	0.328
0.164 -36	0.1585-0.1612	0.1451-0.1455	0.1320	0.0002	0°15'	0.112-0.132	0.328
0.190 -32	0.1840-0.1870	0.1687-0.1691	0.1539	0.0003	0°15'	0.134-0.154	0.380
0.250 -28	0.2435-0.2468	0.2257-0.2261	0.2088	0.0003	0°15'	0.199-0.209	0.500
0.3125 -24	0.3053-0.3089	0.2843-0.2847	0.2644	0.0003	0°15'	0.244-0.264	0.625
0.375 -24	0.3678-0.3714	0.3467-0.3471	0.3268	0.0003	0°15'	0.307-0.327	0.750
0.4375 -20	0.4294-0.4334	0.4038-0.4042	0.3797	0.0003	0°15'	0.360-0.380	0.875
0.500 -20	0.4919-0.4960	0.4663-0.4667	0.4422	0.0003	0°15'	0.422-0.442	1.000
0.5625 -18	0.5538-0.5582	0.5251-0.5255	0.4983	0.0003	0°10'	0.478-0.498	1.125
0.625 -18	0.6163-0.6206	0.5876-0.5880	0.5608	0.0003	0°10'	0.541-0.561	1.250

Surface texture is in microinches, per ANSI B46.1.
 Material of mandrel to be steel having hardness not lower than 50 HRC.
 Use of bolt or stud meeting requirements of this figure is optional.
 Screw threads per MIL-S-7742 except as otherwise specified in table.
 Tolerance on lead error is the allowable variation between any two threads (See Handbook H28).

MAXIMUM MANDREL TEST FIXTURE

Figure 3



THE RESULTING SHARP FEATHER EDGE OF THE INCOMPLETE THREAD ADJACENT TO THE CHAMFER SHALL BE REMOVED BY STONING

Nominal Thread Size	Major Diameter Millimeters	Pitch Diameter Millimeters	Minor Diameter mm, max	Lead Error Tolerance Millimeter	Half Angle Tolerance plus and minus	"B" Millimeters	Length "L" mm, min
0.112 -40	2.716 - 2.778	2.411 - 2.420	2.113	0.0051	0° 20'	1.61 - 2.10	5.69
0.112 -48	2.731 - 2.788	2.482 - 2.491	2.235	0.0051	0° 30'	1.73 - 2.23	5.69
0.138 -32	3.353 - 3.429	2.965 - 2.974	2.588	0.0076	0° 15'	2.09 - 2.59	7.02
0.138 -40	3.376 - 3.439	3.071 - 3.081	2.773	0.0051	0° 15'	2.27 - 2.76	7.02
0.164 -32	4.104 - 4.089	3.625 - 3.634	3.248	0.0076	0° 15'	2.75 - 3.25	8.34
0.164 -36	4.026 - 4.094	3.686 - 3.695	3.352	0.0051	0° 15'	2.85 - 3.35	8.34
0.190 -32	4.674 - 4.749	4.285 - 4.295	3.909	0.0076	0° 15'	3.41 - 3.91	9.66
0.250 -28	6.190 - 6.268	5.733 - 5.742	5.303	0.0076	0° 15'	4.81 - 5.30	12.70
0.3125-24	7.755 - 7.846	7.222 - 7.231	6.715	0.0076	0° 15'	6.20 - 6.70	15.88
0.375 -24	9.343 - 9.433	8.807 - 8.816	8.300	0.0076	0° 15'	7.80 - 8.30	19.05
0.4375-20	10.907 - 11.008	10.257 - 10.266	9.644	0.0076	0° 15'	9.15 - 9.65	22.23
0.500 -20	12.495 - 12.598	11.845 - 11.854	11.231	0.0076	0° 15'	10.72 - 11.22	25.40
0.5625-18	14.067 - 14.178	13.338 - 13.347	12.656	0.0076	0° 10'	12.15 - 12.64	28.58
0.625 -18	15.655 - 15.763	14.926 - 14.935	14.244	0.0076	0° 10'	13.75 - 14.24	31.75

Surface texture is in μm , per ANSI B46.1.

Material of mandrel to be steel having hardness not lower than 50 HRC.

Use of bolt or stud meeting requirements of this figure is optional.

Screw threads per MIL-S-8879 except as otherwise specified in table.

Tolerance on lead error is the allowable variation between any two threads (See Handbook H28).

MAXIMUM MANDREL TEST FIXTURE

Figure 3 (SI)