



AEROSPACE MATERIAL SPECIFICATION

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AMS 7473C
Superseding AMS 7473B

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BOLTS AND SCREWS Roll Threaded

1. **ACKNOWLEDGMENT:** A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. **APPLICATION:** High quality bolts and screws of steel or corrosion and heat resistant alloys for special purposes. Parts of corrosion and heat resistant steels and alloys are generally for use at temperatures over 700 F (371 C) where stresses are low. Parts of AMS 5061 are generally for use at temperatures up to 800 F (472 C) where stresses are low. Parts of AMS 5624 or AMS 5625 are generally for use at lower temperatures when high expansion is required.
3. **MATERIAL:** Shall be as specified on the drawing.
4. **FABRICATION:**
 - ∅ 4.1 **Blanks:** Heads shall be formed by hot forging, cold forging, or machining.
 - 4.2 **Oxide and Decarburization Removal:** The blanks, before cold working the fillet radius when specified and rolling the threads, shall have all surfaces free from surface oxide, oxide penetration, and decarburization except as permitted in 5.2.2. The removal process shall produce no intergranular attack or corrosion of the blanks. The metal removed from the bearing surface of the head and the full body diameter of the shank shall be as little as practicable to obtain a clean, smooth surface and in no case shall be so great as to produce more cutting of flow lines in the head-to-shank junction of upset headed parts than shown in Fig. 1B.
 - ∅ attack or corrosion of the blanks. The metal removed from the bearing surface of the head and the full body diameter of the shank shall be as little as practicable to obtain a clean, smooth surface and in no case shall be so great as to produce more cutting of flow lines in the head-to-shank junction of upset headed parts than shown in Fig. 1B.
 - 4.3 **Cold Working of Fillet Radius:** After removal of oxide and decarburization as in 4.2, the head-to-shank fillet radius of parts having the radius complete throughout the circumference of the part shall, when specified, be cold worked sufficiently to remove all visual evidence of grinding or tool marks. Distortion due to cold working shall not raise metal more than 0.002 in. above the contour at "A" or depress metal more than 0.002 in. below the contour at "B" as shown in Fig. 2; distorted areas shall not extend beyond "C" as shown in Fig. 2. In configurations having an undercut associated with the fillet radius, the cold working will be required only for 90 deg of fillet arc, starting at the point of tangency of the fillet radius and the bearing surface of the head.
 - ∅ distortion due to cold working shall not raise metal more than 0.002 in. above the contour at "A" or depress metal more than 0.002 in. below the contour at "B" as shown in Fig. 2; distorted areas shall not extend beyond "C" as shown in Fig. 2. In configurations having an undercut associated with the fillet radius, the cold working will be required only for 90 deg of fillet arc, starting at the point of tangency of the fillet radius and the bearing surface of the head.
 - 4.4 **Thread Rolling:** Threads shall be formed on the finished blanks by a single rolling process after removal of oxide as in 4.2.
 - ∅ removal of oxide as in 4.2.
 - 4.5 **Cleaning:** Parts made of corrosion and heat resistant steels and alloys, after finishing, shall be degreased and then immersed in one of the following solutions for the time and at the temperature shown:
 - (a) One volume of nitric acid (sp gr 1.42) and 9 volumes of water for not less than 20 min. at room temperature.
 - ∅ (b) One volume of nitric acid (sp gr 1.42) and 4 volumes of water for 30 - 40 min. at room temperature.
 - (c) One volume of nitric acid (sp gr 1.42) and 4 volumes of water for 10 - 15 min. at 140 - 160 F (60 - 71.1 C).

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5. **TECHNICAL REQUIREMENTS:** Parts shall conform to the metallurgical and mechanical requirements specified below. Parts shall also conform to the latest issue of the following:

- ∅ AS 1177 - Nondestructive Inspection Standards for Bolts and Screws
- AS 3062 - Bolts, Screws, and Studs, Screw Thread Requirements
- AS 3063 - Bolts, Screws, and Studs, Straightness, Concentricity, and Squareness Requirements

5.1 **Macroscopic Examination:** Parts or sections of parts, as applicable, shall be etched in a solution of approximately 50% hydrochloric acid (sp gr 1.19) and 50% water for sufficient time to reveal flow lines but not longer than 15 min. and shall then be examined at approximately 20X magnification to determine conformance to the following requirements, except that examination for the thread imperfections of 5.1.3 may be made by microscopic examination of specimens polished and etched as in 5.2.

5.1.1 **Flow Lines:**

5.1.1.1 If parts have upset heads, examination of a longitudinal section through the part shall show flow lines in the shank, head-to-shank fillet, and bearing surface which follow the contour of the part as shown in Fig. 1A, except that slight cutting of flow lines by the oxide and decarburization removal process of 4.3 is permissible, as shown in Fig. 1B; excessive cutting of flow lines in the shank, head-to-shank fillet, and bearing surface, as shown in Fig. 1C, is not permissible except when an undercut is associated with the fillet radius. The head style shown in Figs. 1A through 1C is for illustrative purposes only but other symmetrical head styles shall conform to the above requirements. Flow lines in upset heads on parts having special heads, such as Dee- or Tee-shaped heads or thinner-than-standard heads, shall be as agreed upon by purchaser and vendor.

5.1.1.2 Flow lines in threads shall be continuous, shall follow the general thread contour, and shall be of maximum density at root of thread (See Fig. 3).

5.1.2 **Internal Defects:** Examination of longitudinal sections of the head and shank and of the threads shall reveal no cracks, laps, or porosity. The head and shank section shall extend not less than D/2 in. from the bearing surface of the head and the threaded section shall extend not less than D/2 in. beyond the thread runout where "D" is the nominal diameter of the shank after heading. If the two sections would overlap, the entire length of the part shall be sectioned and examined as a whole.

5.1.3 **Threads:**

5.1.3.1 Root defects such as notches, slivers, folds, roughness, and oxide scale are not permissible (See Fig. 4).

5.1.3.2 Multiple laps on the flanks of threads are not permissible regardless of location. Single laps on the flanks of threads that extend toward the root are not permissible (See Figs. 5 and 6).

5.1.3.3 There shall be no laps along the flank of the thread below the pitch diameter (See Fig. 7). A single lap is permissible along the flank of the thread above the pitch diameter on either the pressure or non-pressure flank (one lap at any cross section through the thread) provided it extends toward the crest and generally parallel to the flank (See Fig. 7).

5.1.3.4 Crest craters, crest laps, or a crest lap in combination with a crest crater are permissible, provided the imperfections do not extend deeper than 20% of the basic thread height (See Table I) as measured from the thread crest when the thread major diameter is at minimum size (See Fig. 8). The major diameter of the thread shall be measured prior to sectioning. As the major diameter of the thread approaches maximum size, values for depth of crest crater and crest lap imperfections listed in Table I may be increased by 1/2 of the difference between the minimum major diameter and the actual major diameter as measured on the part.

5.2 Microscopic Examination: Specimens cut from parts shall be polished, etched, and then examined at not lower than 100X magnification to determine conformance to the following requirements; the etchant shall be 2% Nital for parts made of carbon or low alloy steels and Kalling's reagent (100 ml of absolute ethyl alcohol, 100 ml of hydrochloric acid (sp gr 1.19), and 5 g of cupric chloride), Marble's reagent (20 ml of hydrochloric acid (sp gr 1.19), 20 ml of water, and 4 g of cupric sulfate pentahydrate), or other suitable etchant for parts made of corrosion and heat resistant steels and alloys.

5.2.1 Surface Hardening: Except for parts whose strength is obtained only by cold working, parts shall have no surface hardening except as produced during cold working of the head-to-shank fillet radius when specified and during rolling of threads. Evidence of carburization or nitriding will not be permitted. In case of dispute over results of the microscopic examination, microhardness testing shall be used as a referee method; a Vickers hardness reading within 0.003 in. of the surface more than 30 points higher than the reading in the core will be evidence of nonconformance to this requirement.

5.2.2 Decarburization: Parts made of carbon or low alloy steels shall not be decarburized more than the following:

5.2.2.1 The bearing surface of the head, the head-to-shank fillet radius, the shank, and the threads shall be free from decarburization.

5.2.2.2 Depth of decarburization on those surfaces of the head which are the original surfaces of the bar shall be not greater than that permitted by the applicable material specification.

5.2.2.3 Depth of decarburization on the OD of the head of cylindrical head parts made by upsetting is not restricted.

5.2.2.4 Depth of decarburization at any point on any surface not covered by 5.2.2.1, 5.2.2.2, or 5.2.2.3 shall not exceed 0.002 inch.

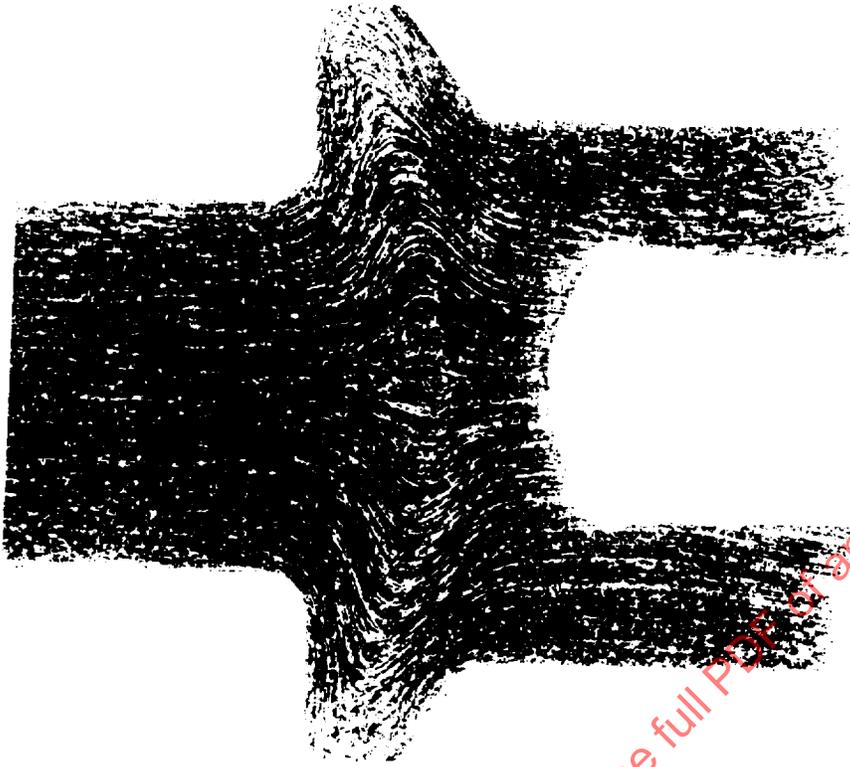
5.3 Resampling and Retesting: If any part or specimen used in the above tests fails to meet the specified requirements, acceptance of the parts may be based on the testing of three additional parts or specimens for each original nonconforming part or specimen, all of which additional parts or specimens shall conform to specified requirements. Failure of any retest part or 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.

6. QUALITY: Parts shall be uniform in quality and condition, clean, sound, smooth, and free from burrs and foreign materials and from internal and external imperfections detrimental to their performance.

7. SAMPLING: Shall be in accordance with the latest issue of AMS 2373.

8. REPORTS: Unless otherwise specified, the vendor of parts shall furnish with each shipment three copies of a report stating that the chemical composition of the parts conforms to the requirements of the applicable material specification. This report shall include the purchase order number, AMS 7473C, contractor or other direct supplier of material, part number, and quantity.

9. REJECTIONS: Parts not conforming to this specification or to authorized modifications will be subject to rejection.



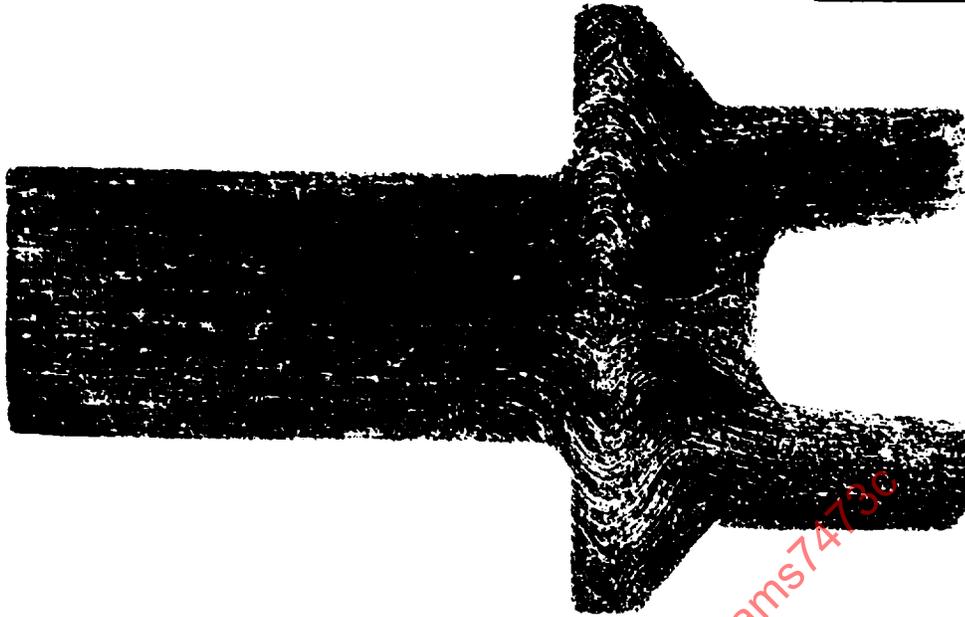
SATISFACTORY GRAIN FLOW
FIGURE 1A



MINIMUM ACCEPTABLE STANDARD

Showing maximum permissible cutting of flow lines after machining
to remove oxide and decarburization as in 4.3.

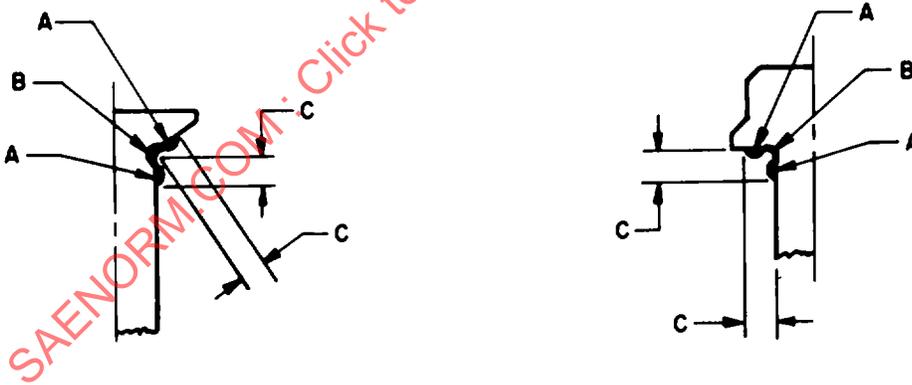
FIGURE 1B



UNACCEPTABLE GRAIN FLOW

Excessive cutting of flow lines in the shank, head to shank fillet, and bearing surface is not permissible.

FIGURE 1C

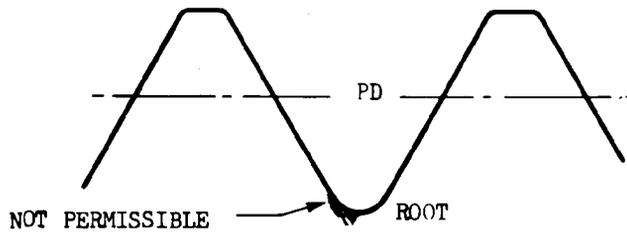


Nominal Bolt Diameter	C, max
Up to 0.3125, excl	0.062
0.3125 and 0.375	0.094
0.4375 - 0.625, incl	0.125
0.750 - 1.000, incl	0.156
Over 1.000	0.188

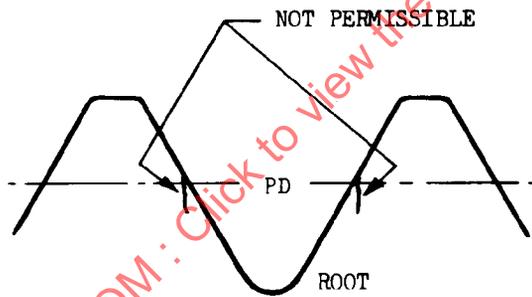
PERMISSIBLE DISTORTION FROM FILLET WORKING
FIGURE 2



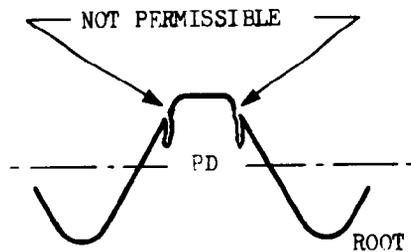
FLOW LINES, ROLLED THREAD
FIGURE 3



ROLLED THREAD
FIGURE 4



ROLLED THREAD
FIGURE 5



ROLLED THREAD
FIGURE 6

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