

REV.
C

RATIONALE

UPDATE TO ASME Y14.5-2018, REVISE THREAD CALLOUT TO ASME B1.1 AND ASME B1.3 SYSTEM 22.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD AN115851 THRU AN115900, REVISION 3. THIS SAE STANDARD MAY RETAIN THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

ANY REQUIREMENTS ASSOCIATED WITH QUALIFIED PRODUCTS LISTS (QPL'S) MAY CONTINUE TO BE MANDATORY FOR DoD CONTRACTS. REQUIREMENTS RELATING TO QPL'S HAVE NOT BEEN ADOPTED BY THE SAE FOR THIS STANDARD AND ARE NOT PART OF THIS SAE DOCUMENT.

AS115851™ THRU
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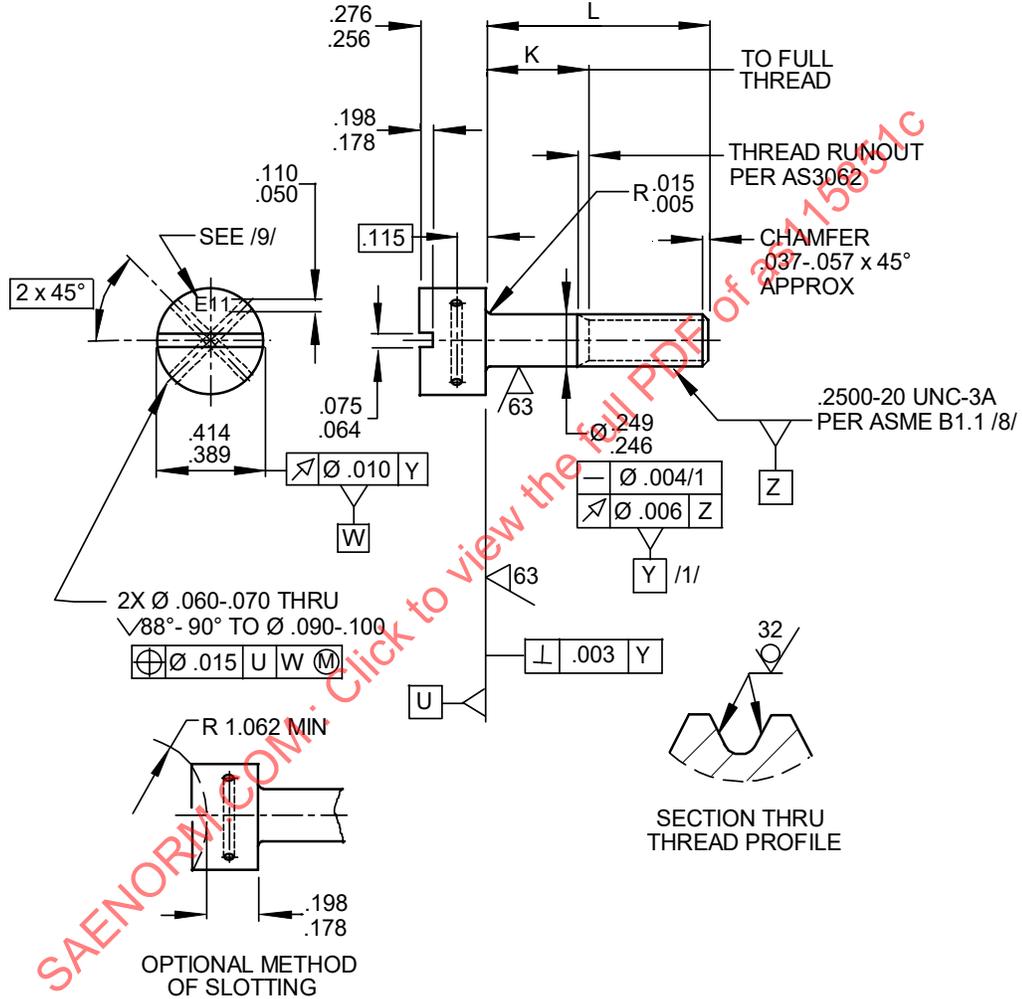
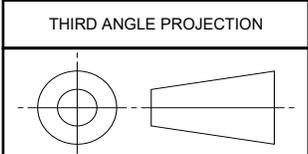


FIGURE 1 - SCREW

For more information on this standard, visit
<https://www.sae.org/standards/content/AS115851C/>



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7452



AEROSPACE STANDARD

SCREW - FLAT FILLISTER, DRILLED HEAD,
CADMIUM PLATED, STEEL UNS G87400, 125 KSI MIN
.2500-20 UNC - 3A

AS115851™ THRU
AS115900™
SHEET 1 OF 3

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TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NUMBER	L	K	PART NUMBER	L	K
AN115855	.365- .385	/10/	AN115870	1.302-1.322	.502- .562
AN115856	.428- .448	/10/	AN115871	1.365-1.385	.565- .625
AN115857	.490- .510	/10/	AN115872	1.428-1.448	.628- .688
AN115858	.552- .572	/10/	AN115873	1.490-1.510	.690- .750
AN115859	.615- .635	/10/	AN115874	1.552-1.572	.752- .812
AN115860	.678- .698	/10/	AN115875	1.615-1.635	.815- .875
AN115861	.740- .760	/10/	AN115876	1.678-1.698	.878- .938
AN115862	.802- .822	/10/	AN115877	1.740-1.760	.940-1.000
AN115863	.865- .885	.065-.125	AN115878	1.865-1.885	1.065-1.125
AN115864	.928- .948	.128-.188	AN115879	1.990-2.010	1.190-1.250
AN115865	.990-1.010	.190-.250	AN115880	2.115-2.135	1.315-1.375
AN115866	1.052-1.072	.252-.312	AN115881	2.240-2.260	1.440-1.500
AN115867	1.115-1.135	.315-.375	AN115882	2.365-2.385	1.565-1.625
AN115868	1.178-1.198	.378-.438	AN115883	2.490-2.510	1.690-1.750
AN115869	1.240-1.260	.440-.500	AN115884	2.615-2.635	1.815-1.875
			AN115885	2.740-2.760	1.940-2.000
			AN115886	2.865-2.885	2.065-2.125
			AN115887	2.990-3.010	2.190-2.250

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

- /1/ FOR PART NUMBERS AN115855 THRU AN115865, THE THREAD PD DATUM Z SHALL REPLACE DATUM Y.
2. MATERIAL: STEEL PER AMS6322 (COMPOSITION SIMILAR TO UNS G87400).
3. PROCUREMENT SPECIFICATION: AS7452.
4. HARDNESS: 26 TO 32 HRC.
5. MAGNETIC PARTICLE INSPECTION PER ASTM E1444/E1444M.
6. FINISH: CADMIUM PLATE PER AMS2400.
7. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
8. SCREW THREADS PER ASME B1.1 AND ACCEPTABILITY REQUIREMENTS PER ASME B1.3 SYSTEM 22.
- /9/ MARK MATERIAL CODE "E11" AS SHOWN PER AS269 AND MANUFACTURER'S IDENTIFICATION RAISED OR DEPRESSED .010 MAX PER AS478 CLASS A.
- /10/ THREAD TO HEAD IN ACCORDANCE WITH AS3062.
11. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS ARE IN INCHES.
13. DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982 (ASME PUBLICATION).
14. UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

	AEROSPACE STANDARD	AS115851™ THRU AS115900™ SHEET 2 OF 3	REV. C
	SCREW - FLAT FILLISTER, DRILLED HEAD, CADMIUM PLATED, STEEL UNS G87400, 125 KSI MIN .2500-20 UNC - 3A		