

REV.
A

SAE AS3125

RATIONALE

UPDATE SUPPLIER PART NUMBERS, CLARIFY PART MARKING, UPDATE MATERIAL USAGE AND GENERAL SAE UPDATING FOR OBSOLETE SPECIFICATIONS AND FORMATING REQUIREMENTS.

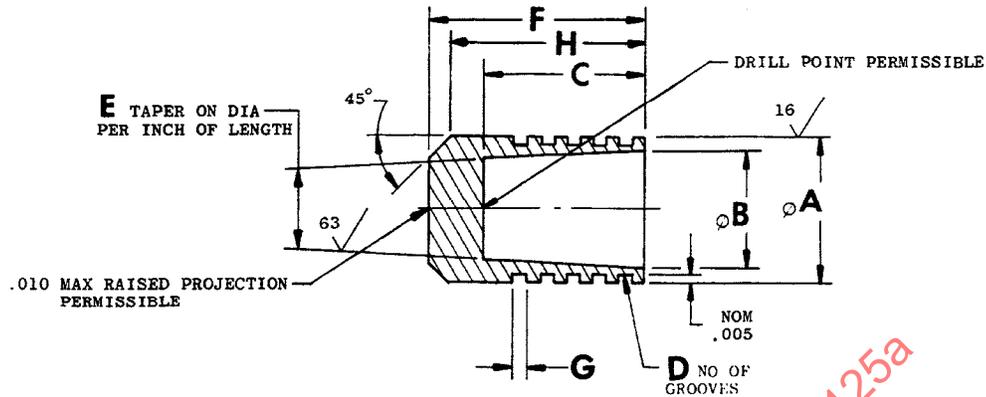


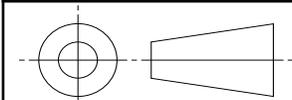
FIGURE 1

TABLE 1A – PART NUMBERS AND DIMENSIONS

STANDARD DIAMETERS			
AEROSPACE STANDARD PART NUMBER /8/	MANUFACTURER'S PART NUMBER /8/	ØA	APPROX MASS LB/100
AS3125-03	PLGA1567020A	.1553-.1562	.069
AS3125-04	PLGA1877020A	.1866-.1875	.095
AS3125-05	PLGA2187020A	.2178-.2187	.139
AS3125-06	PLGA2507020A	.2491-.2500	.207
AS3125-07	PLGA2817020A	.2803-.2812	.246
AS3125-08	PLGA3437020A	.3428-.3437	.430
AS3125-09	PLGA4067020A	.4053-.4062	.619
AS3125-10	PLGA4687020A	.4678-.4687	.828
AS3125-11	PLGA5317020A	.5303-.5312	1.061
AS3125-12	PLGA6567020A	.6553-.6562	1.923

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3125A>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD
(R) PLUG, EXPANSION - CRES, 416 OR 416SE, LONG; STD AND .010 OVERSIZE DIAMETERS, UNS S41600/UNS S41623

SAE AS3125
SHEET 1 OF 3

REV.
A

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user." SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

TABLE 1B – PART NUMBERS AND DIMENSIONS

.010 OVERSIZE DIAMETERS			
AEROSPACE STANDARD PART NUMBER /8/	MANUFACTURER'S PART NUMBER /8/	ØA	APPROX MASS LB/100
AS3125-53	PLGA1667020	.1653-.1662	.085
AS3125-54	PLGA1977020	.1966-.1975	.116
AS3125-55	PLGA2287020	.2278-.2287	.171
AS3125-56	PLGA2607020	.2591-.2600	.250
AS3125-57	PLGA2917020	.2903-.2912	.282
AS3125-58	PLGA3537020	.3528-.3537	.496
AS3125-59	PLGA4167020	.4153-.4162	.711
AS3125-60	PLGA4787020	.4778-.4787	.949
AS3125-61	PLGA5417020	.5403-.5412	1.185
AS3125-62	PLGA6667020	.6653-.6662	2.171

TABLE 1C – PART NUMBERS AND DIMENSIONS

AEROSPACE STANDARD PART NUMBER /8/	ØB NOM	C NOM	D	ØE NOM	F	G NOM	H
AS3125-03 & 53	.115	.187	8	.0417	.238-.252	.010	.198-.232
AS3125-04 & 54	.146	.205	8	.0417	.253-.267	.010	.227-.243
AS3125-05 & 55	.178	.250	8	.0417	.300-.314	.010	.260-.294
AS3125-06 & 56	.204	.300	8	.0417	.358-.372	.015	.324-.342
AS3125-07 & 57	.240	.312	8	.0417	.363-.377	.013	.323-.357
AS3125-08 & 58	.303	.375	8	.0208	.493-.507	.020	.393-.427
AS3125-09 & 59	.365	.437	9	.0208	.558-.572	.020	.448-.482
AS3125-10 & 60	.428	.500	10	.0208	.613-.627	.020	.513-.547
AS3125-11 & 61	.490	.562	12	.0156	.673-.687	.020	.573-.607
AS3125-12 & 62	.595	.625	14	.0156	.743-.757	.020	.645-.675

NOTES:

- MATERIAL: AMS5610 (416 OR 416SE CRES BAR), UNS S41600 OR UNS S41623.
- HEAT TREAT: ROCKWELL 20-34 HRC PER ASTM E 140.
- CLEANING: FINISHED PARTS SHALL BE DEGREASED AND IMMERSUED FOR 30 MINUTES IN A SOLUTION CONTAINING 40% BY VOLUME OF NITRIC ACID (SPECIFIC GRAVITY 1.42) AND 2.5% BY WEIGHT OF SODIUM DICHROMATE AT ROOM TEMPERATURE.
- GROOVE BURRS PERMITTED ON OD OF PLUG TO .001 OVER MAX ØA.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M, REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.
- BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: ANGULAR DIMENSIONS ± 2 DEGREES. DIMENSIONS APPLY AFTER FINISH.

 An SAE International Group	AEROSPACE STANDARD (R) PLUG, EXPANSION - CRES, 416 OR 416SE, LONG; STD AND .010 OVERSIZE DIAMETERS, UNS S41600/UNS S41623	SAE AS3125 SHEET 2 OF 3	REV. A