

REV.  
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AS3127

RATIONALE

THIS IS A LIMITED SCOPE REVISION. REVISED CLEANING REQUIREMENTS (NOTE 3) FOR CONFORMANCE TO AMS2700 OR ASTM A967/A967M.

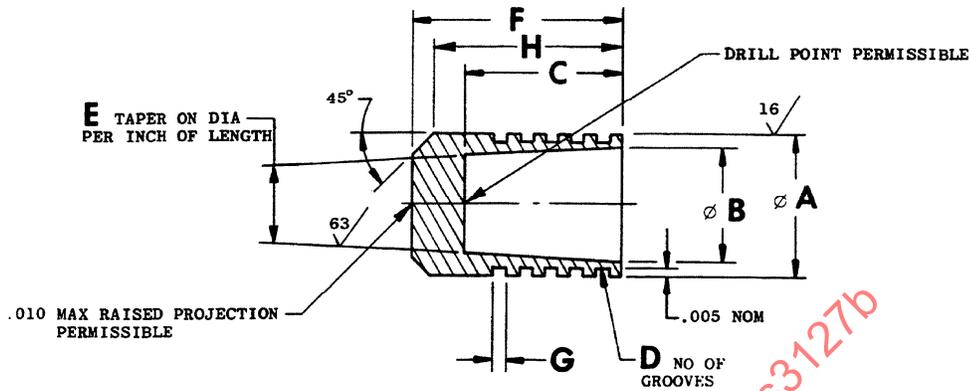


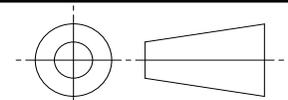
FIGURE 1

TABLE 1A – PART NUMBERS AND DIMENSIONS

STANDARD DIAMETER			
AEROSPACE STANDARD PART NUMBER /8/	MANUFACTURER'S PART NUMBER /8/	ØA	APPROX MASS LB/100
AS3127-01	PLGA0935020A	.0928-.0937	.011
AS3127-02	PLGA1255020 A	.1241-.1250	.022
AS3127-03	PLGA1565020 A	.1553-.1562	.040
AS3127-04	PLGA1875020 A	.1866-.1875	.056
AS3127-05	PLGA2185020 A	.2178-.2187	.088
AS3127-06	PLGA2505020 A	.2491-.2500	.129
AS3127-07	PLGA2815020 A	.2803-.2812	.178
AS3127-08	PLGA3435020 A	.3428-.3437	.289
AS3127-09	PLGA4065020 A	.4053-.4062	.462
AS3127-10	PLGA4685020 A	.4678-.4687	.568
AS3127-11	PLGA5315020 A	.5303-.5312	.986
AS3127-12	PLGA6565020 A	.6553-.6562	1.675

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3127B>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

PLUG, EXPANSION - CRES, 416 OR 416SE, SHORT; STD AND .010 OVERSIZE DIAMETERS, UNS S41600/UNS S41623

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SHEET 1 OF 3

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TABLE 1B – PART NUMBERS AND DIMENSIONS

.010 OVERSIZE DIAMETER			
AEROSPACE STANDARD PART NUMBER /8/	MANUFACTURER'S PART NUMBER /8/	ØA	APPROX MASS LB/100
AS3127-51	PLGA1035020A	.1028-.1037	.013
AS3127-52	PLGA1355020 A	.1341-.1350	.029
AS3127-53	PLGA1665020 A	.1653-.1662	.047
AS3127-54	PLGA1975020 A	.1966-.1975	.068
AS3127-55	PLGA2285020 A	.2278-.2287	.108
AS3127-56	PLGA2605020 A	.2591-.2600	.150
AS3127-57	PLGA2915020 A	.2903-.2912	.203
AS3127-58	PLGA3535020 A	.3528-.3537	.329
AS3127-59	PLGA4165020 A	.4153-.4162	.527
AS3127-60	PLGA4785020 A	.4778-.4787	.645
AS3127-61	PLGA5415020 A	.5403-.5412	1.080
AS3127-62	PLGA6665020 A	.6653-.6662	1.863

TABLE 1C – PART NUMBERS AND DIMENSIONS

AEROSPACE STANDARD PART NUMBER /8/	ØB NOM	C NOM	D	ØE NOM	F	G NOM	H
AS3127-01 & 51	.062	.069	3	.0417	.093-.102	.010	.070-.085
AS3127-02 & 52	.088	.104	4	.0417	.123-.132	.010	.100-.115
AS3127-03 & 53	.110	.090	4	.0417	.118-.132	.010	.100-.120
AS3127-04 & 54	.146	.128	4	.0417	.154-.166	.010	.128-.142
AS3127-05 & 55	.173	.157	5	.0417	.180-.194	.010	.157-.177
AS3127-06 & 56	.204	.183	4	.0417	.218-.232	.015	.184-.202
AS3127-07 & 57	.240	.205	5	.0313	.248-.262	.010	.220-.240
AS3127-08 & 58	.300	.242	5	.0208	.300-.314	.020	.262-.282
AS3127-09 & 59	.358	.279	12	.0208	.358-.372	.010	.295-.315
AS3127-10 & 60	.428	.305	6	.0208	.383-.397	.020	.320-.340
AS3127-11 & 61	.486	.410	8	.0156	.513-.527	.020	.445-.475
AS3127-12 & 62	.592	.425	9	.0182	.543-.557	.020	.460-.480

NOTES:

- MATERIAL: AMS5610 (416 OR 416SE CRES BAR), UNS S41600 OR UNS S41623.
- HEAT TREAT: ROCKWELL 20-34 HRC PER ASTM E140.
- CLEANING: FINISHED PARTS SHALL BE DEGREASED AND PASSIVATED PER ASTM A967/A967M OR AMS2700. A SOLUTION CONTAINING SODIUM DICHROMATE AND NOT LESS THAN 20% BY VOLUME OF NITRIC ACID MUST BE USED. A CITRIC ACID METHOD MAY BE USED AS AN ALTERNATIVE IF REQUESTED BY THE PROCURING ACTIVITY AND THE SUPPLIER AGREES.
- GROOVE BURRS PERMITTED ON OD OF PLUG TO .001 OVER MAX Ø A.
- SURFACE TEXTURE: SYMBOLS PER AMSE Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.
- BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

	<b>AEROSPACE STANDARD</b>	<b>AS3127</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	PLUG, EXPANSION - CRES, 416 OR 416SE, SHORT; STD AND .010 OVERSIZE DIAMETERS, UNS S41600/UNS S41623		