

RATIONALE

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

REV.
B

AS3129

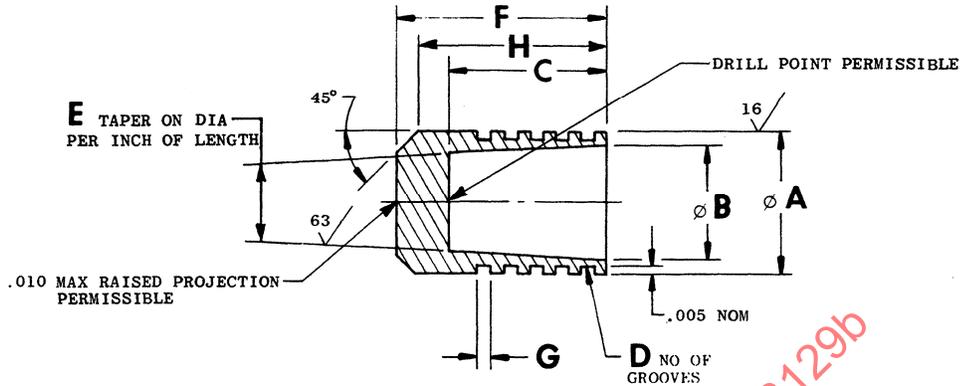


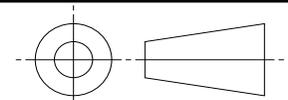
FIGURE 1

TABLE 1A - PART NUMBERS AND DIMENSIONS

STANDARD DIAMETERS			
AEROSPACE STANDARD PART NUMBER /B/	MANUFACTURER'S PART NUMBER /B/	ØA	APPROX MASS LB/100
AS3129-03	PLGA1567030A	.1553-.1562	.069
AS3129-04	PLGA1877030 A	.1866-.1875	.095
AS3129-05	PLGA2187030 A	.2178-.2187	.139
AS3129-06	PLGA2507030 A	.2491-.2500	.207
AS3129-07	PLGA2817030 A	.2803-.2812	.246
AS3129-08	PLGA3437030 A	.3428-.3437	.430
AS3129-09	PLGA4067030 A	.4053-.4062	.619
AS3129-10	PLGA4687030 A	.4678-.4687	.828
AS3129-11	PLGA5317030 A	.5303-.5312	1.061
AS3129-12	PLGA6567030 A	.6553-.6562	1.923

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THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

PLUG, EXPANSION - CRES, 303, LONG; STD AND .010 OVERSIZE DIAMETERS, UNS S30300

AS3129
SHEET 1 OF 3

REV. B

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TABLE 1B - PART NUMBERS AND DIMENSIONS

.010 OVERSIZE DIAMETERS			
AEROSPACE STANDARD PART NUMBER /8/	MANUFACTURER'S PART NUMBER /8/	ØA	APPROX MASS LB/100
AS3129-53	PLGA1667030A	.1653-.1662	.085
AS3129-54	PLGA1977030A	.1966-.1975	.116
AS3129-55	PLGA2287030A	.2278-.2287	.171
AS3129-56	PLGA2607030A	.2591-.2600	.250
AS3129-57	PLGA2917030A	.2903-.2912	.282
AS3129-58	PLGA3537030A	.3528-.3537	.496
AS3129-59	PLGA4167030A	.4153-.4162	.711
AS3129-60	PLGA4787030A	.4778-.4787	.949
AS3129-61	PLGA5417030A	.5403-.5412	1.185
AS3129-62	PLGA6667030A	.6653-.6662	2.171

TABLE 1C - PART NUMBERS AND DIMENSIONS

AEROSPACE STANDARD PART NUMBER	ØB NOM	C NOM	D	ØE NOM	F	G NOM	H
AS3129-03 & 53	.115	.187	8	.0417	.238-.252	.010	.198-.232
AS3129-04 & 54	.146	.205	8	.0417	.253-.267	.010	.227-.243
AS3129-05 & 55	.178	.250	8	.0417	.300-.314	.010	.260-.294
AS3129-06 & 56	.204	.300	8	.0417	.358-.372	.015	.324-.342
AS3129-07 & 57	.240	.312	8	.0417	.363-.377	.013	.323-.357
AS3129-08 & 58	.303	.375	8	.0208	.493-.507	.020	.393-.427
AS3129-09 & 59	.365	.437	9	.0208	.558-.572	.020	.448-.482
AS3129-10 & 60	.428	.500	10	.0208	.613-.627	.020	.513-.547
AS3129-11 & 61	.490	.562	12	.0156	.673-.687	.020	.573-.607
AS3129-12 & 62	.595	.625	14	.0156	.743-.757	.020	.645-.675

NOTES:

- MATERIAL: 303 CRES BAR PER AMS5640, TYPE 1 (UNS S30300).
 - HEAT TREAT: PER AMS5640.
 - 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 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, TOLERANCE: ANGULAR DIMENSIONS ±2 DEGREES. DIMENSIONS APPLY AFTER FINISH.
- /8/ MARK AS3129-() PART NUMBER AND MANUFACTURER'S PART NUMBER ON PACKAGE IN ACCORDANCE WITH AS478, METHOD 37. IN ADDITION PACKAGES FOR OVERSIZE PLUGS SHALL INCLUDE "OVERSIZE 303SS" IN A RECTANGULAR BLOCK.

	AEROSPACE STANDARD	AS3129 SHEET 2 OF 3	REV. B
	PLUG, EXPANSION - CRES, 303, LONG; STD AND .010 OVERSIZE DIAMETERS, UNS S30300		