

REV.  
B

AS3131

RATIONALE

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

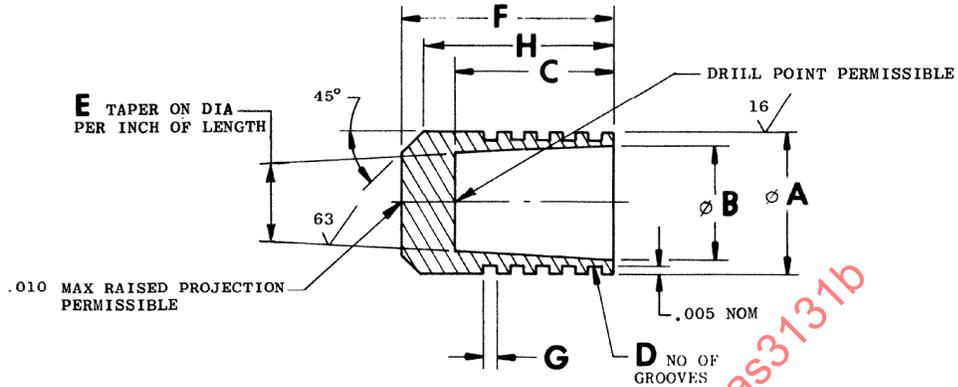


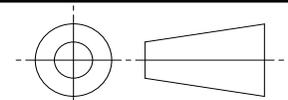
FIGURE 1

TABLE 1A – PART NUMBERS AND DIMENSIONS

STANDARD DIAMETERS			
AEROSPACE STANDARD PART NUMBER /B/	MANUFACTURER'S PART NUMBER /B/	ØA	APPROX MASS LB/100
AS3131-01	PLGA0935030A	.0928-.0937	.011
AS3131-02	PLGA1255030A	.1241-.1250	.022
AS3131-03	PLGA1565030A	.1553-.1562	.040
AS3131-04	PLGA1875030A	.1866-.1875	.056
AS3131-05	PLGA2185030A	.2178-.2187	.088
AS3131-06	PLGA2505030A	.2491-.2500	.129
AS3131-07	PLGA2815030A	.2803-.2812	.178
AS3131-08	PLGA3435030A	.3428-.3437	.289
AS3131-09	PLGA4065030A	.4053-.4062	.462
AS3131-10	PLGA4685030A	.4678-.4687	.568
AS3131-11	PLGA5315030A	.5303-.5312	.986
AS3131-12	PLGA6565030A	.6553-.6562	1.675

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THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



**AEROSPACE STANDARD**

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

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SHEET 1 OF 3

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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
AS3131-51	PLGA1035030A	.1028-.1037	.013
AS3131-52	PLGA1355030A	.1341-.1350	.029
AS3131-53	PLGA1665030A	.1653-.1662	.047
AS3131-54	PLGA1975030A	.1966-.1975	.068
AS3131-55	PLGA2285030A	.2278-.2287	.108
AS3131-56	PLGA2605030A	.2591-.2600	.150
AS3131-57	PLGA2915030A	.2903-.2912	.203
AS3131-58	PLGA3535030A	.3528-.3537	.329
AS3131-59	PLGA4165030A	.4153-.4162	.527
AS3131-60	PLGA4785030 A	.4778-.4787	.645
AS3131-61	PLGA5415030 A	.5403-.5412	1.080
AS3131-62	PLGA6665030 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
AS3131-01 & 51	.062	.069	3	.0417	.093-.102	.010	.070-.085
AS3131-02 & 52	.088	.104	4	.0417	.123-.132	.010	.100-.115
AS3131-03 & 53	.110	.090	4	.0417	.118-.132	.010	.100-.120
AS3131-04 & 54	.146	.128	4	.0417	.154-.166	.010	.128-.142
AS3131-05 & 55	.173	.157	5	.0417	.180-.194	.010	.157-.177
AS3131-06 & 56	.204	.183	4	.0417	.218-.232	.015	.184-.202
AS3131-07 & 57	.240	.205	5	.0313	.248-.262	.010	.220-.240
AS3131-08 & 58	.300	.242	5	.0208	.300-.314	.020	.262-.282
AS3131-09 & 59	.358	.279	12	.0208	.358-.372	.010	.295-.315
AS3131-10 & 60	.428	.305	6	.0208	.383-.397	.020	.320-.340
AS3131-11 & 61	.486	.410	8	.0156	.513-.527	.020	.445-.475
AS3131-12 & 62	.592	.425	9	.0182	.543-.557	.020	.460-.480

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 MICRINCHES Ra.

	<b>AEROSPACE STANDARD</b>	<b>AS3131</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	PLUG, EXPANSION - CRES, 303, SHORT; STD AND .010 OVERSIZE DIAMETERS, UNS S30300		