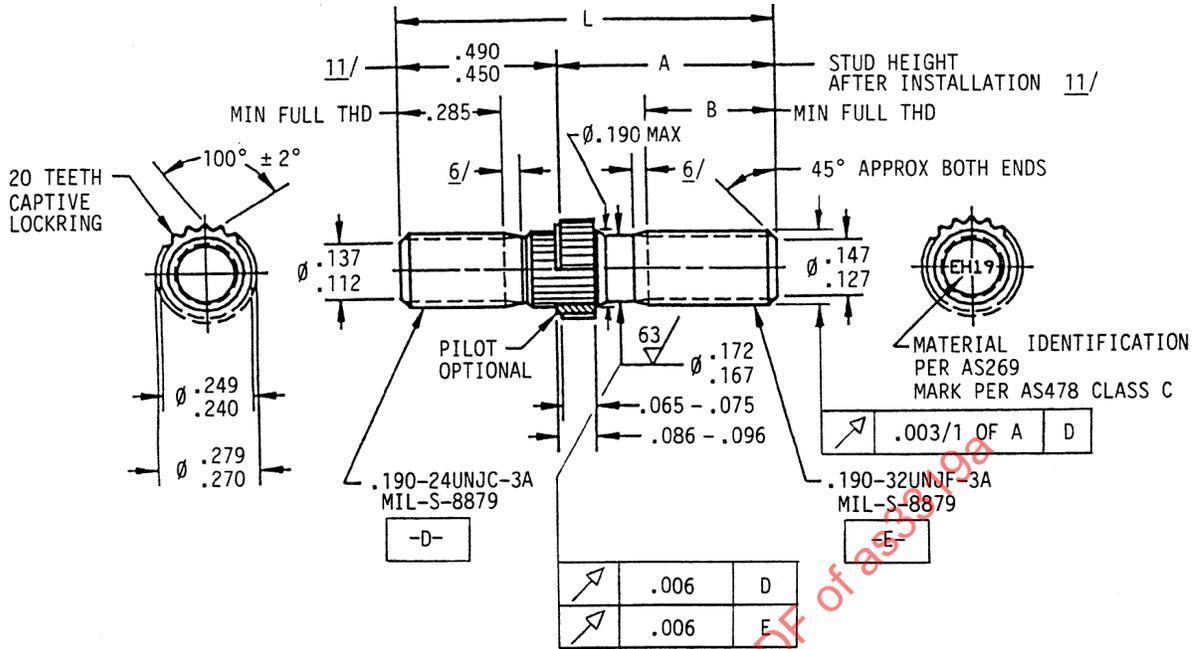


REV.  
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AS3319

FEDERAL SUPPLY CLASS  
5307



NOTES:

1. MATERIAL: STUD - CORROSION AND HEAT RESISTANT STEEL, AMS-5731. (UNS S66286)  
LOCKRING - CRES, AMS-5640. (UNS S30300)
2. HEAT TREATMENT: STUD - SOLUTION AND PRECIPITATION HEAT TREATED. SEE PROCUREMENT SPECIFICATION.
3. HARDNESS: 24-37 HRC, 247-344 HB, OR 260-363 HV.
4. FINISH: STUD AND LOCKRING - CLEANED (PASSIVATED) PER PROCUREMENT SPECIFICATION.
5. FLUORESCENT PENETRANT INSPECTION: AMS-2645, EXCEPT LOCKRING. ACCEPTANCE CRITERIA PER AMS-7482.
- 6/ PROCUREMENT SPECIFICATION: AMS-7482, EXCEPT STRESS RUPTURE TEST IS WAIVED, AND SPECIAL STUD END THREAD REQUIREMENTS OF AS3062 ARE NOT APPLICABLE. INCOMPLETE LEAD AND RUNOUT THREAD REQUIREMENTS ON BOTH THREADS SHALL BE AS SPECIFIED IN AS3062 FOR BOLTS.

(A) ENTIRE STANDARD REVISED

AS AND AMS ARE SAE PUBLICATIONS.  
ANSI IS AMERICAN NATIONAL STANDARDS INSTITUTE PUBLICATION.

THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE E-25, GENERAL STANDARDS FOR AEROSPACE PROPULSION SYSTEMS

SOURCE CONTROL DRAWING

**SAE** The Engineering Society  
For Advancing Mobility  
Land Sea Air and Space  
**INTERNATIONAL**  
400 Commonwealth Drive, Warrendale, PA 15096-0001

**AEROSPACE STANDARD**

STUD - STRAIGHT, RING LOCKED, CRES AMS-5731  
0.190-24UNJC X 0.190-32UNJF

**AS3319**  
SHEET 1 OF 3

**REV.**  
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ISSUED 1979-09 REVISED 1990-08 REAFFIRMED 2001-11

REV.  
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AS3319

7. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36-1978; REQUIREMENTS PER ANSI/ASME B46.1-1985. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125  $\mu\text{in Ra}$ , EXCEPT SERRATIONS TO BE 250  $\mu\text{in Ra}$ , AND THREAD FLANKS AND ROOT TO BE 32  $\mu\text{in Ra}$ .
8. BREAK EDGES 0.003-0.015, EXCEPT LOCKRING.
9. DIMENSIONING AND TOLERANCING: ANSI Y14.5M-1982.
10. DIMENSIONS IN INCHES.
- 11/ LOCKRING INTERNAL SERRATIONS TO HAVE FREE MOVEMENT ALONG STUD AXIS. DIMENSIONS APPLY WHEN LOCKRING IS AGAINST STOP TOWARD 0.190-32 THREAD.
12. MARK AEROSPACE STANDARD IDENTIFICATION NUMBER AND MANUFACTURER'S IDENTIFICATION ON CONTAINER.
13. DO NOT USE UNASSIGNED AEROSPACE STANDARD IDENTIFICATION NUMBERS.
14. STUD TO BE INSTALLED IN ACCORDANCE WITH AS1561 INTO TAPPED HOLE PER AS1620.

SOURCE OF SUPPLY:

REXNORD/ROSAN PRODUCTS  
3130 W. HARVARD ST.  
P.O. BOX 25225  
SANTA ANA, CA 92799  
MANUFACTURER'S CAGE CODE 83324

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ONLY THE ITEM DESCRIBED ON THIS DRAWING WHEN PROCURED FROM THE VENDOR LISTED HEREON IS APPROVED FOR USE IN THE APPLICATIONS SPECIFYING THIS AEROSPACE STANDARD IDENTIFICATION NUMBER. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR TESTING AND APPROVAL BY THE DESIGN ACTIVITY RESPONSIBLE FOR THE APPLICATION.