

SAE Executive Standards Committee 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 revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

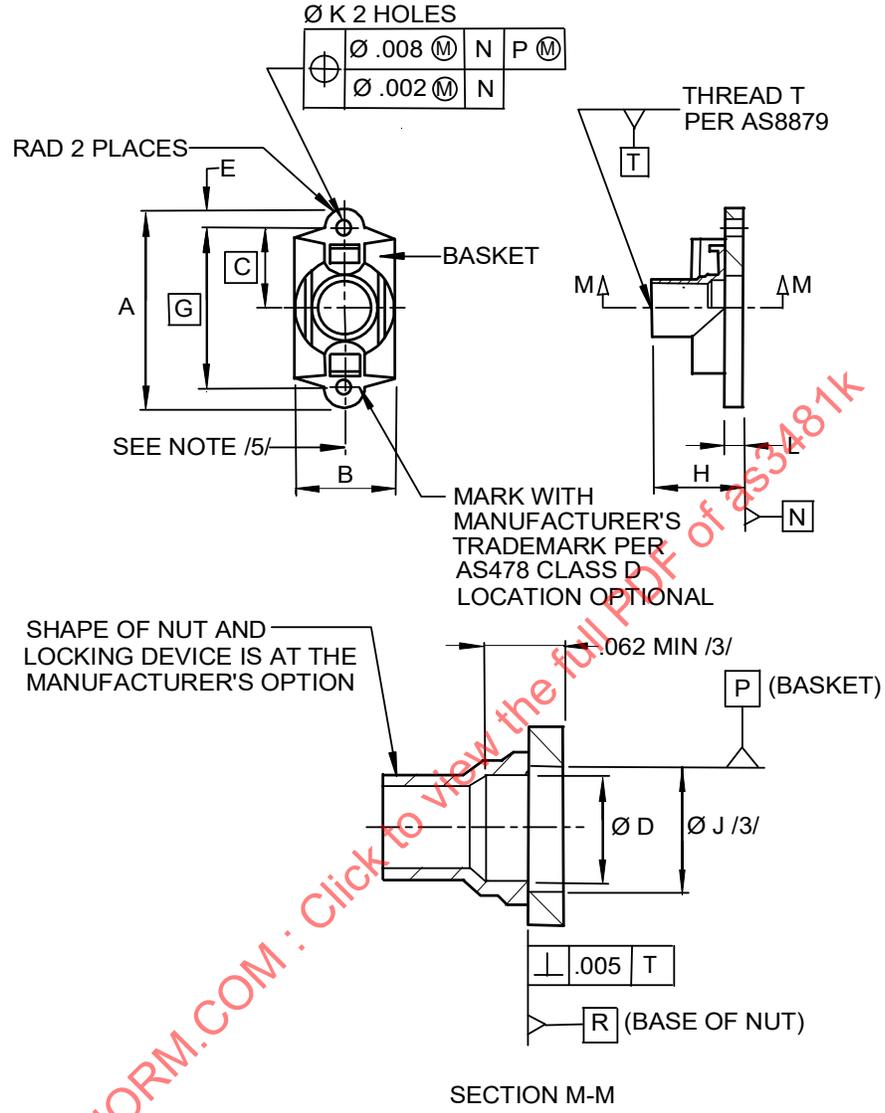
**REV. K**

**AS3481™**

FEDERAL SUPPLY CLASS  
5310

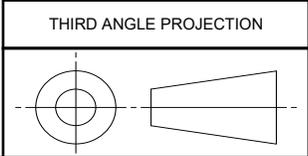
RATIONALE

LIMITED SCOPE REVISION. CHANGE SILVER PLATING SPEC FROM AS2411 TO AMS2411.



SAENORM.COM : Click to view the full PDF of AS3481K

For more information on this standard, visit  
<https://www.sae.org/standards/content/AS3481K/>



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS4393



**AEROSPACE STANDARD**  
 NUT, SELF-LOCKING, PLATE, TWO LUG,  
 FLOATING, REDUCED RIVET SPACING, LOW HEIGHT,  
 UNS S66286, CLASS: 125 KSI/800 °F

**AS3481™**  
 SHEET 1 OF 3

**REV. K**

ISSUED 1991-02 REAFFIRMED 2007-06 REVISED 2023-05

**TABLE 1A - DIMENSIONS T TO H**

PART NUMBER	T THREAD	A MAX	B	C	ØD COUNTERBORE MIN	E MIN	H MAX
AS3481-01	.1380-32UNJC-3B	.682	.290-.357	.218	--	.070	.171
AS3481-02	.1640-32UNJC-3B	.707	.290-.367	.234	.168	.100	.250
AS3481-03	.1900-32UNJF-3B	.739	.290-.416	.250	.194	.100	.250
AS3481-04	.2500-28UNJF-3B	.801	.350-.500	.281	.254	.100	.281
AS3481-05	.3125-24UNJF-3B	1.010	.412-.581	.359	.317	.117	.328

**TABLE 1B - DIMENSIONS G TO MASS**

PART NUMBER	G BASIC	ØK +.005 -0.000	ØJ /3/ /5/	L	AXIAL STRENGTH LBF MIN	APPROX MASS LB/100
AS3481-01	.437	.098	.178-.270	.020-.090	1130	.32
AS3481-02	.468	.098	.204-.270	.025-.090	1720	.36
AS3481-03	.500	.098	.230-.270	.025-.090	2460	.39
AS3481-04	.562	.098	.290-.330	.027-.090	4580	.69
AS3481-05	.718	.130	.352-.392	.032-.105	7390	1.10

NOTES:

1. MATERIAL:

- a. NUT: CORROSION AND HEAT RESISTANT STEEL AMS5525, AMS5731, OR AMS5734.
- b. BASKET: CORROSION AND HEAT RESISTANT STEEL AMS5525 (COMPOSITION SIMILAR TO UNS S66286).

/2/ PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS NOTED:

- a. HEAT TREATMENT: AFTER FORMING, PLATE NUTS SHALL BE PRECIPITATION HEAT TREATED TO A HARDNESS NOT TO EXCEED THAT SPECIFIED IN NOTE 2d.
- b. NUT: SILVER PLATE PER AMS2411; SILVER PLATE ONLY ON THREADS, EXCEPT:  
 SIZE -01 MAY HAVE OPTIONAL COVERAGE ON COUNTERSINK.  
 SIZE -02 THROUGH -05 MAY HAVE OPTIONAL COVERAGE IN COUNTERBORE TO .030 MAXIMUM DEPTH.  
 DIMENSIONS APPLY AFTER PLATING.  
 BASKET: PASSIVATE PER AMS2700 TYPE 2 OR 8.
- c. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F ± 15 °F FOR NUTS TESTED AFTER BAKE.
- d. HARDNESS: 44 HRC MAXIMUM
- e. COMPLETELY RECRYSTALLIZED MICROSTRUCTURE IS NOT REQUIRED.

/3/ SIZE -01 MAY BE COUNTERSUNK OR RADIUSSED WITHIN ØJ. SIZE -02 AND LARGER SHALL BE COUNTERBORED TO ØD TO .062 MINIMUM DEPTH.

4. RADIAL FLOAT OF NUT THREADS RELATIVE TO BASKET ØJ, .020 MINIMUM.

/5/ ØJ TO BE CENTERED ON WIDTH B WITHIN ±.010.

6. REMOVE BURRS AND SHARP EDGES.

7. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.

8. DIMENSIONING AND TOLERANCING: ASME Y14.5-2018.

9. DIMENSIONS ARE IN INCHES.

	<b>AEROSPACE STANDARD</b>	<b>AS3481™</b> SHEET 2 OF 3	<b>REV.</b> <b>K</b>
	NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING, REDUCED RIVET SPACING, LOW HEIGHT, UNS S66286, CLASS: 125 KSI/800 °F		