

REV.
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AS3486

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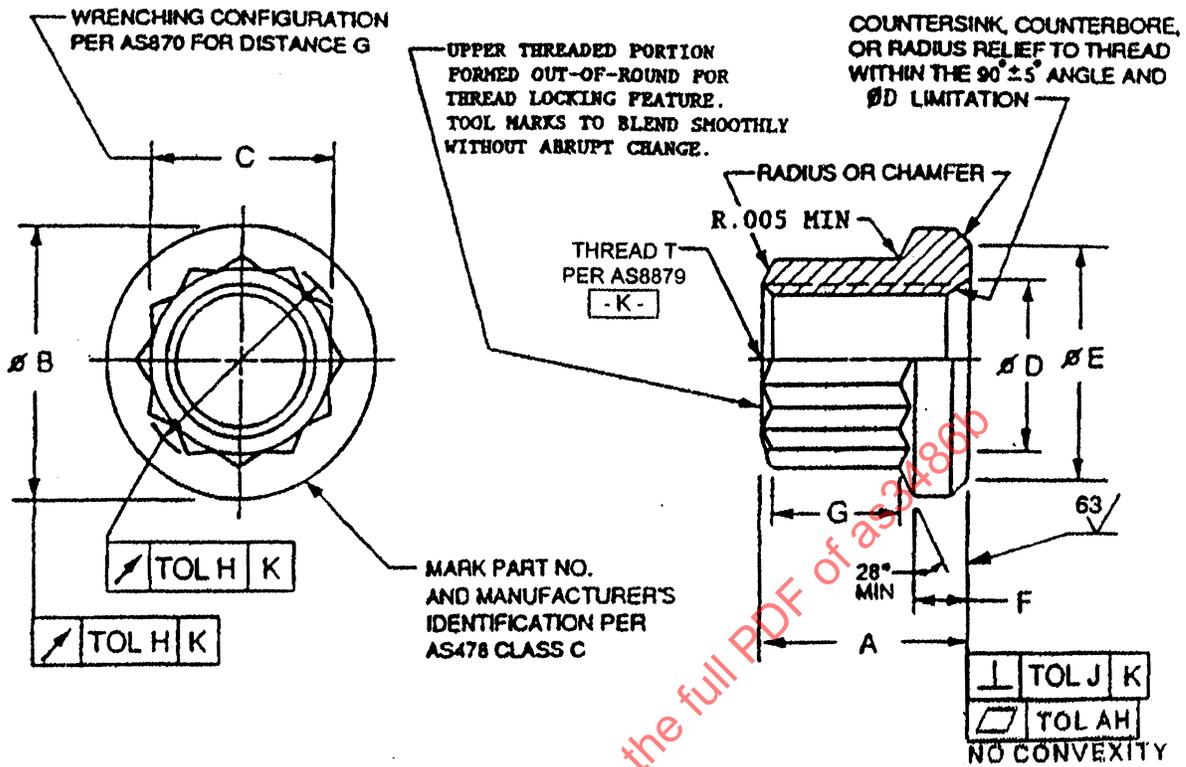
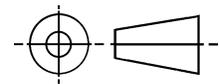


FIGURE 1

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THIRD ANGLE PROJECTION



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

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

AEROSPACE STANDARD
(R) NUT, SELF-LOCKING, EXTENDED DOUBLE
HEXAGON, REDUCED FLANGE, DRY FILM LUBE,
UNS S66286, CLASS: 160 ksi/800 °F

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TABLE 1A

PART NUMBER	T THREAD	A +.005/.010	φB MAX	C NOM	DASH NO.	φD MAX
AS3486-09	.1900-32UNJF-3B	.245	.340	.2500	08	.220
AS3486-10	.2500-28UNJF-3B	.317	.430	.3125	10	.280
AS3486-11	.3125-24UNJF-3B	.355	.515	.3750	12	.345
AS3486-12	.3750-24UNJF-3B	.453	.586	.4375	14	.405

TABLE 1B

PART NUMBER	φE MIN	F	G MIN	H	J	AH	APPROX MASS LB/100
AS3486-09	.310	.035-.057	.125	.006	.004	.0014	.20
AS3486-10	.400	.045-.057	.185	.007	.005	.0014	.40
AS3486-11	.485	.055-.068	.195	.008	.005	.0016	.70
AS3486-12	.558	.075-.100	.250	.009	.005	.0016	1.00

NOTES:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5731 OR 5734 (UNS S66286).
HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE PRECIPITATION HEAT TREATED PER AMS 2754/3 TO MEET THE HARDNESS SPECIFIED IN NOTE 4.
2. PROCUREMENT SPECIFICATION: AS4393 EXCEPT AS FOLLOWS:
 - a. COATING: SOLID FILM LUBRICANT PER AS1701 TYPE VI, IN LIEU OF SILVER PLATE PER AMS 2411.
 - b. PRETREATMENT: PRIOR TO APPLYING THE SOLID FILM LUBRICANT, NUTS MAY BE PLATED WITH COPPER (AMS 2418) OR NICKEL (AMS 2403) TO .0001 MAXIMUM THICKNESS.
 - c. DIMENSIONS APPLY AFTER PRETREATMENT PLATING AND BEFORE COATING WITH SOLID FILM LUBRICANT.
 - d. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F FOR NUTS TESTED AFTER BAKE.
3. HARDNESS: 32 TO 39 HRC.
4. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
5. FLUORESCENT PENETRANT INSPECTION PER ASTM E 1417, TYPE 1, SENSITIVITY LEVEL 2, PRIOR TO PRETREATMENT OR COATING. ACCEPTANCE CRITERIA PER AS3071.
6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 μin Ra.
7. DIMENSIONING AND TOLERANCING: ANSI Y14.5-1982 (ASME PUBLICATION).
8. DIMENSIONS ARE IN INCHES.
9. DO NOT USE UNASSIGNED NUMBERS.
10. CLASSIFICATION:
 - a. 160 ksi MINIMUM AXIAL STRENGTH AT ROOM TEMPERATURE.
 - b. 800 °F MAXIMUM BAKE TEMPERATURE FOR NUTS TESTED AFTER BAKING.

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