

REV.
B

AS3486

SAE Technical Standards Board 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 reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

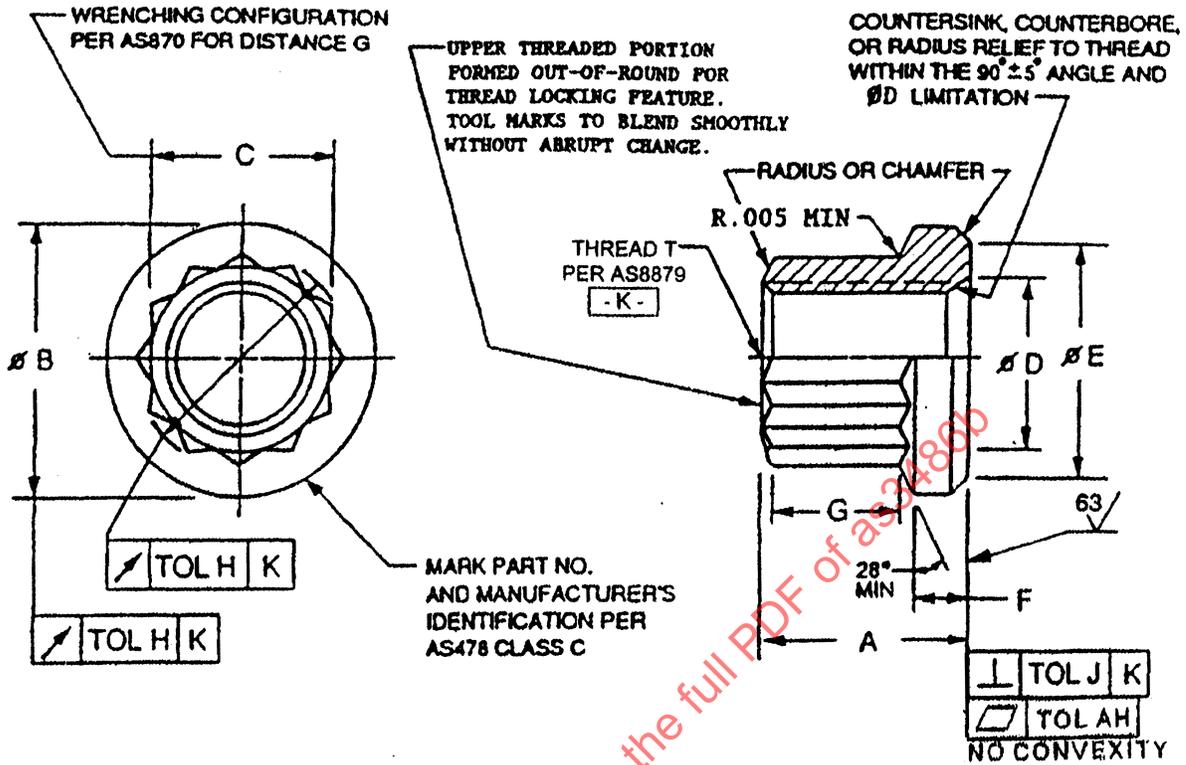
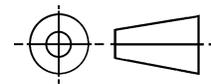


FIGURE 1

SAENORM.COM : Click to view the full PDF of as3486

THIRD ANGLE PROJECTION



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

AS3486
SHEET 1 OF 3

REV. B

ISSUED 1992-04 REVISED 2002-06

REV.
B

AS3486

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.

AEROSPACE STANDARD

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

AS3486
SHEET 2 OF 3

REV.
B