

RATIONALE

AS3502 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

AS3502

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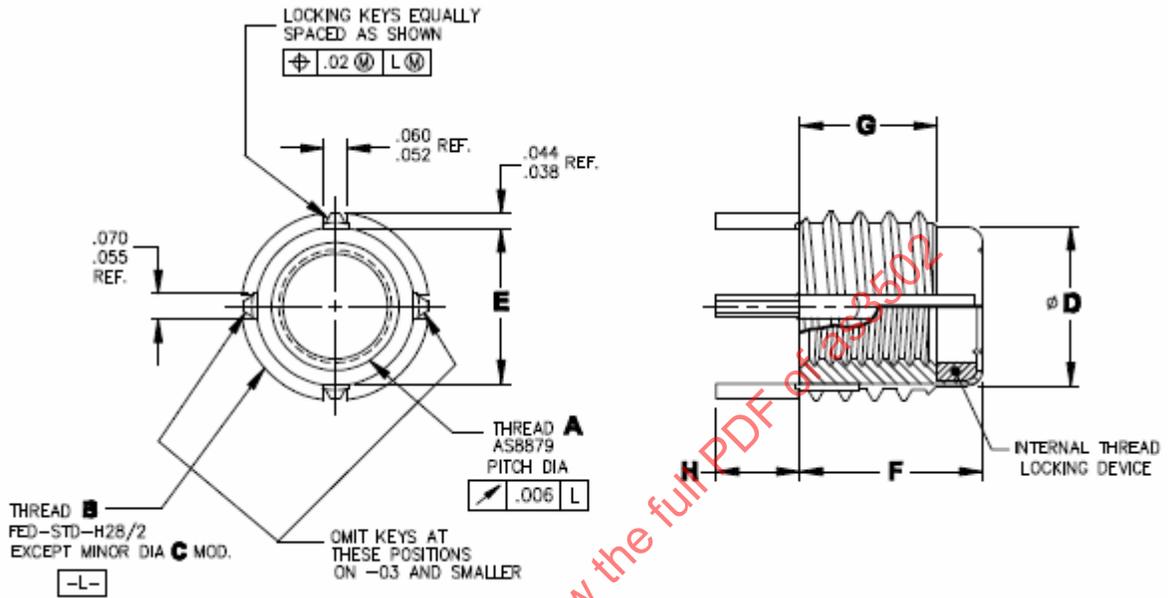
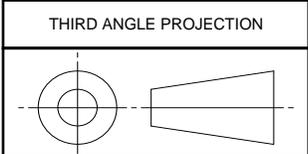


FIGURE 1

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CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS4723



AEROSPACE STANDARD

INSERT, SCREW THREAD, SELF LOCKING
PLASTIC LOCKING DEVICE, SOLID FILM LUBRICATED
SELF-BROACHING KEYS, UNS S66286

AS3502
SHEET 1 OF 3

TABLE 1

PART NUMBER	A THREAD	B THREAD		Ø D MAX	E
		SIZE	ØC		
AS3502-01	.1640-36 UNJF-3B	.3125-18 UNC-2A	.249 - .256	.249	.216 - .224
AS3502-02	.1900-32 UNJF-3B	.3750-16 UNC-2A	.312 - .320	.312	.280 - .288
AS3502-03	.2500-28 UNJF-3B	.4375-14 UNC-2A	.375 - .383	.375	.341 - .348
AS3502-04	.3125-24 UNJF-3B	.5000-13 UNC-2A	.432 - .440	.432	.403 - .411
AS3502-05	.3750-24 UNJF-3B	.5625-12 UNC-2A	.495 - .503	.495	.465 - .473
AS3502-06	.4375-20 UNJF-3B	.6250-11 UNC-2A	.551 - .565	.551	.528 - .536
AS3502-07	.5000-20 UNJF-3B	.6875-11 UNS-2A	.615 - .625	.615	.591 - .597

TABLE 1 CONTINUED

PART NUMBER	F ±.015	G ±.015	H ±.015
AS3502-01	.260	.180	.135
AS3502-02	.350	.265	.190
AS3502-03	.400	.300	.190
AS3502-04	.480	.360	.190
AS3502-05	.540	.400	.190
AS3502-06	.570	.450	.190
AS3502-07	.725	.590	.190

NOTES:

1. MATERIAL:

- a. INSERT: STEEL, CORROSION RESISTANT, TYPE A286 (UNS S66286) IN ACCORDANCE WITH AMS 5731, AMS 5734, OR AMS 5737.
- b. LOCKING KEYS: STEEL, CORROSION RESISTANT, TYPE 420, [UNS S42000] CHEMICAL COMPOSITION PER ASTM A 580/A 580M.
- c. PLASTIC LOCKING DEVICE: POLYIMIDE RESIN, AMS 3644 CLASS 1 OR CLASS 2.

2. HEAT TREATMENT:

- a. INSERT: AMS 5731 AND AMS 5734 SHALL BE HEAT TREATED TO 140,000 psi FTU MIN.
- b. LOCKING KEYS: HARDNESS TO BE HRC 54 MIN.

3. FINISH:

- a. PASSIVATE IN ACCORDANCE WITH AMS 2700 TYPE 2 OR TYPE 8.
- b. INSERT TO BE SOLID FILM LUBRICANT COATED IN ACCORDANCE WITH AS1701, CLASS III THROUGH VI PER MANUFACTURER'S OPTIONS.
- c. LOCKING KEYS MAY OR MAY NOT BE LUBRICANT COATED.

4. MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION PER AS478 METHOD 2.

5. ALL DIMENSIONS ARE AFTER SURFACE TREATMENT AND PRIOR TO THE ADDITION OF THE LUBRICANT.

	AEROSPACE STANDARD	AS3502 SHEET 2 OF 3
	INSERT, SCREW THREAD, SELF LOCKING PLASTIC LOCKING DEVICE, SOLID FILM LUBRICATED SELF-BROACHING KEYS, UNS S66286	