

REV.
B

AS3564

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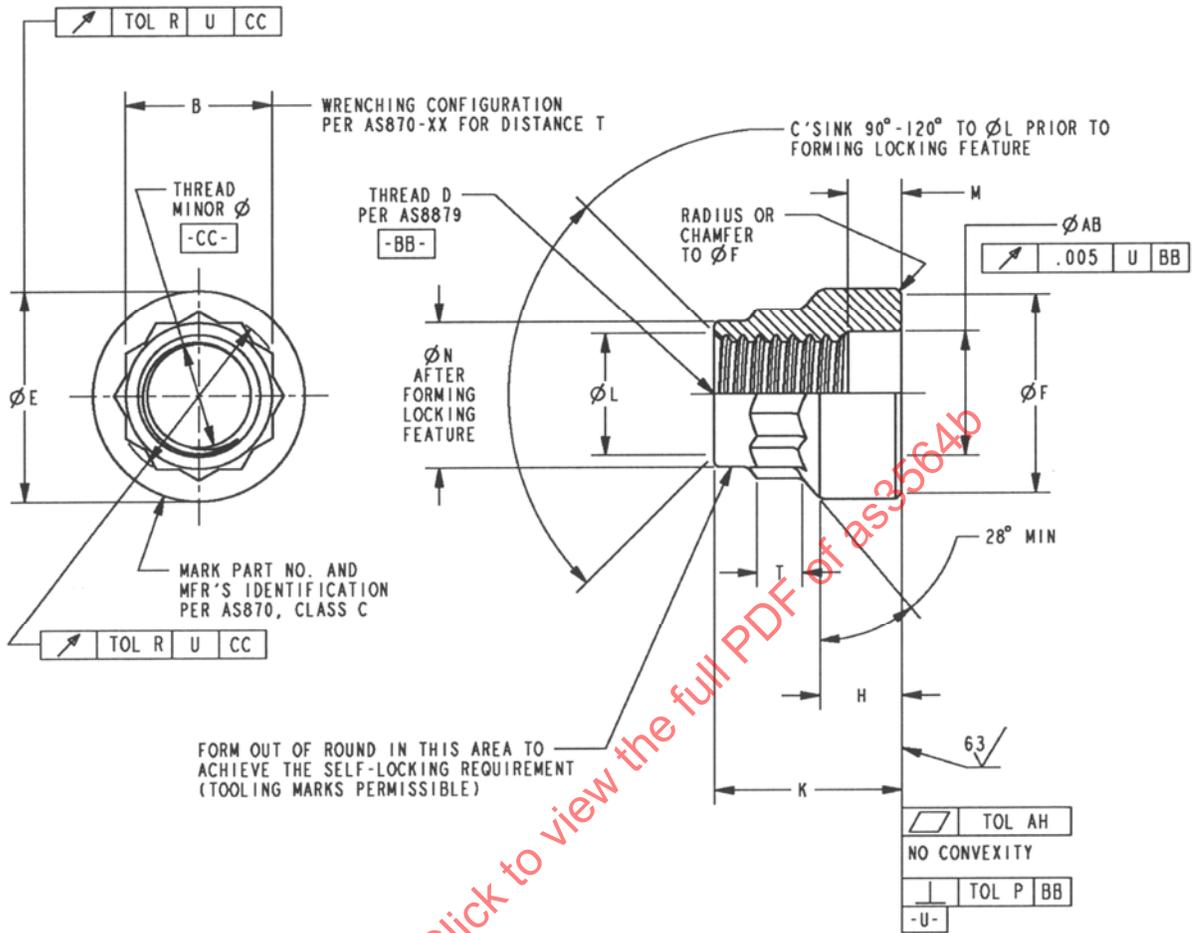
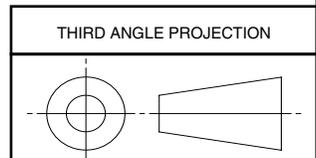


FIGURE 1

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CUSTODIAN: SAE E-25

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AEROSPACE STANDARD

NUT, SELF-LOCKING, DOUBLE HEXAGON, SOLID
FILM LUBRICATED, COUNTERBORED,
160 KSI, 800 °F, UNS S66286

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SHEET 1 OF 3

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TABLE 1A

PART NUMBER	THREAD D	B NOM	DASH NO.	ØE MAX	ØF MIN	ØAB	H MIN	K MAX
AS3564-09	.1900-32UNJF-3B	.2500	08	.340	.325	.200-.210	.125	.400
AS3564-10	.2500-28UNJF-3B	.3125	10	.450	.410	.260-.270	.170	.510
AS3564-11	.3125-24UNJF-3B	.3750	12	.525	.495	.323-.333	.175	.580
AS3564-12	.3750-24UNJF-3B	.4375	14	.600	.560	.385-.395	.195	.645
AS3564-13	.4375-20UNJF-3B	.5625	18	.690	.650	.448-.458	.220	.745
AS3564-14	.5000-20UNJF-3B	.6250	20	.780	.740	.510-.525	.240	.830
AS3564-15	.5625-18UNJF-3B	.6875	22	.880	.840	.573-.583	.270	.928
AS3564-16	.6250-18UNJF-3B	.7812	25	.970	.925	.635-.645	.290	1.020
AS3564-17	.7500-16UNJF-3B	.9375	30	1.230	1.180	.760-.770	.320	1.222

TABLE 1B

PART NUMBER	ØL	ØM MAX	ØN MAX	T MIN	P	R	AH	APPROX MASS LB/100
AS3564-09	.190-.210	.085-.105	.262	.082	.004	.006	.0014	.44
AS3564-10	.250-.270	.100-.120	.326	.130	.005	.007	.0014	.77
AS3564-11	.312-.332	.115-.135	.392	.170	.005	.008	.0016	1.22
AS3564-12	.375-.395	.115-.135	.458	.210	.005	.009	.0016	1.90
AS3564-13	.438-.458	.140-.160	.588	.230	.005	.010	.0020	3.31
AS3564-14	.500-.520	.140-.160	.654	.260	.006	.012	.0020	4.42
AS3564-15	.562-.582	.160-.180	.720	.320	.006	.014	.0020	7.96
AS3564-16	.625-.645	.160-.180	.817	.370	.007	.015	.0020	10.80
AS3564-17	.750-.770	.180-.200	.980	.500	.007	.016	.0020	19.57

NOTES:

MATERIAL: CORROSION AND HEAT RESISTANT STEEL PER AMS 5731 OR AMS 5734 (UNS S66286).
HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE HEAT TREATED PER AMS 2759/3 TO MEET THE HARDNESS SPECIFIED IN NOTE 3.

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 -42 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.

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