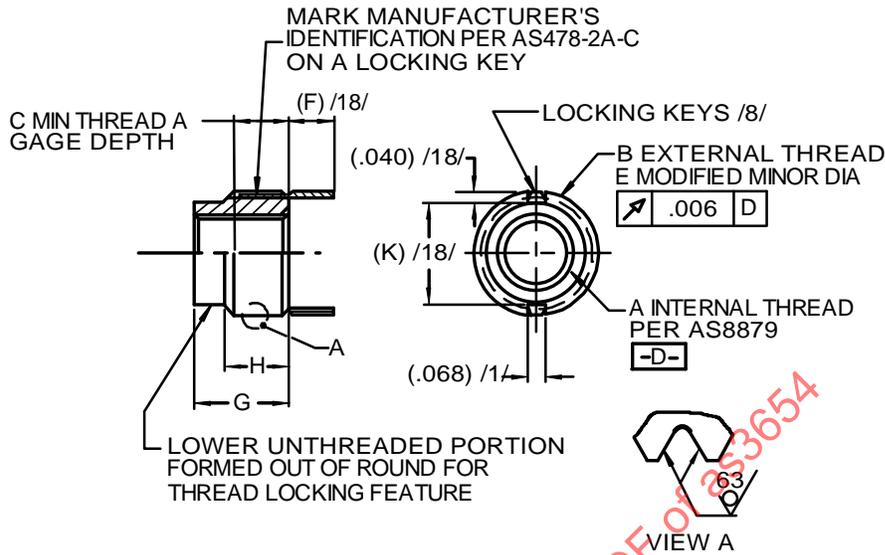


RATIONALE

PROVIDE INDUSTRY WITH A KEY LOCKED INSERT THAT INCORPORATES A BOTTOM LOCKING FEATURE PROVIDING IMPROVED NUMBER OF BOLT INSTALLATION AND REMOVAL CYCLES. THIS INSERT IS ALSO USED FOR REPAIR OF THE STANDARD SIZE INSERT.

AS3654



/18/ DIMENSION APPLIES TO LOCKING KEYS

FIGURE 1 - INSERT

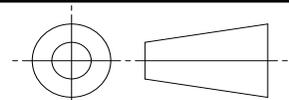
TABLE 1 - DIMENSIONS

PART NUMBER	A INTERNAL THREAD AS8879 UNJF-3B	B EXTERNAL THREAD AS8879 EXCEPT MODIFIED MINOR DIAMETER	EXTERNAL THREAD MODIFIED MINOR DIAMETER E	F REF	G	H	K REF	C MIN GAGE DEPTH	NO OF KEYS /8/
AS3654-3	.1900 - 32	.4375-14 UNJC-3A	.375 - .383	.160	.360 - .390	.256 - .285	.344	.226	2
AS3654-4	.2500 - 28	.5000-13 UNJC-3A	.432 - .440	.190	.497 - .527	.360 - .390	.407	.324	2
AS3654-5	.3125 - 24	.5625-12 UNJC-3A	.495 - .503	.190	.695 - .725	.520 - .550	.469	.475	4
AS3654-6	.3750 - 24	.6250-11 UNJC-3A	.551 - .565	.190	.784 - .814	.581 - .611	.532	.536	4
AS3654-7	.4375 - 20	.6875-12 UNJ-3A	.615 - .625	.190	.875 - .905	.620 - .680	.594	.593	4
AS3654-8	.5000 - 20	.8125-16 UNJ-3A	.744 - .752	.190	.983 - 1.093	.723 - .753	.720	.666	4

PART NUMBER	APPROX MASS LB/100
AS3654-3	.72
AS3654-4	1.12
AS3654-5	1.78
AS3654-6	2.07
AS3654-7	2.64
AS3654-8	5.28

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3654>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS5887



AEROSPACE STANDARD

INSERT, SCREW THREAD, SELF-LOCKING, KEY LOCKED, HEAVY DUTY, OVERSIZE SELF-BROACHING KEYS, UNS S66286

AS3654
SHEET 1 OF 2

ISSUED 2014-01

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