

TABLE 1 - DIMENSIONS A-W AND WEIGHTS

BASIC NO. AS5178 /14/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3B							LB/100	LB/100	LB/100
			A	B ±.010	C	H	W	APPROX REF AL	APPROX REF STEEL	APPROX REF TI	
02	.125	.3125-24 UNJF	.219	.542	.312	.552-	.565	.005	.459	1.27	.726
03	.188	.3750-24 UNJF	.219	.605	.375	.615-	.628	.005	.530	1.47	.839
04	.250	.4375-20 UNJF	.250	.668	.438	.678-	.691	.005	.699	1.94	1.11
05	.312	.5000-20 UNJF	.250	.730	.500	.740-	.753	.005	.785	2.18	1.24
06	.375	.5625-18 UNJF	.266	.793	.562	.803-	.816	.005	.936	2.60	1.49
08	.500	.7500-16 UNJF	.312	.980	.750	.990-1.003		.005	1.46	4.05	2.31
10	.625	.8750-14 UNJF	.359	1.103	.875	1.113-1.128		.005	1.99	5.51	3.15
12	.750	1.0625-12 UNJ	.406	1.352	1.062	1.362-1.380		.008	3.39	9.36	5.36
16	1.000	1.3125-12 UNJ	.406	1.603	1.312	1.613-1.630		.008	4.21	11.7	6.68
20	1.250	1.6250-12 UNJ	.406	1.916	1.625	1.926-1.943		.008	5.31	14.8	8.42
24	1.500	1.8750-12 UNJ	.406	2.162	1.875	2.172-2.198		.008	6.23	17.3	9.90
28	1.750	2.2500-12 UNJ	.406	2.536	2.250	2.546-2.572		.008	7.69	21.3	12.2
32	2.000	2.5000-12 UNJ	.406	2.787	2.500	2.797-2.823		.008	8.70	24.1	13.8
40	2.500	3.0000-12 UNJ	.406	3.286	3.000	3.296-3.322		.008	10.8	30.1	17.2
48	3.000	3.5000-12 UNJ	.406	3.786	3.500	3.796-3.822		.008	13.1	36.5	20.9

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/1/ MATERIAL:

- a. DASH AS CODE LETTER: TYPE 4130 ALLOY STEEL BAR PER AMS6370 OR AMS-S-6758 OR TYPE 4140 PER AMS6349 OR AMS6382 /2/.
- b. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339. /2/.
- c. CODE LETTER J: TYPE 304 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5639.
- d. CODE LETTER K: TYPE 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5648.
- e. CODE LETTER R: TYPE 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5645.
- f. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928.
- g. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124 /2/.

/2/ HEAT TREATMENT:

- a. DASH AS MATERIAL CODE LETTER: SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS D AND W: SEE ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- c. OTHER MATERIAL CODE LETTERS: NONE.

	AEROSPACE STANDARD	AS5178™ SHEET 2 OF 4	REV. E
	NUT, FITTING, BULKHEAD		

/3/ FINISH:

- a. DASH AS MATERIAL CODE LETTER:
 - (1) "-" CODE PARTS TO BE CADMIUM PLATED WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2, DYE BLACK AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
 - (2) "-" CODE PARTS TO BE PLATED WITH ZINC-NICKEL PLATING PER MIL-PRF-32647, TYPE K16 ONLY, WILL HAVE THE FINISH CODE LETTER "U" AFTER THE SIZE CODE IN THE PART NUMBER.
 - b. MATERIAL CODE LETTER D: ANODIZE PER AMS2472 OR MIL-PRF-8625, TYPE II, CLASS 2, DYE BLUE, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
 - c. MATERIAL CODE LETTERS J, K, AND R: PASSIVATE PER AMS2700 TYPE 6 OR 7.
 - d. MATERIAL CODE LETTER T: ANODIZE PER AMS2488 TYPE 2 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
 - e. MATERIAL CODE LETTER W:
 - (1) W CODE PARTS TO BE ANODIZED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE ANODIZED PER AMS2472 OR PER MIL-PRF-8625, TYPE II, CLASS 2, DYE BROWN, SIMILAR TO COLOR 10080 OF AMS-STD-595.
 - (2) W CODE PARTS TO BE COATED WITH HIGH PURITY ALUMINUM ONLY WILL HAVE THE FINISH CODE LETTER "V" AFTER THE SIZE CODE IN THE PART NUMBER. REFER TO PROCUREMENT SPECIFICATION AS4841 FOR REQUIREMENTS. /8/
- /4/ PROCUREMENT SPECIFICATION: AS4841 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) SHALL BE LISTED IN THE NADCAP QUALIFIED MANUFACTURER LIST (QML) FOR THIS PRODUCT TYPE. THE QML IS AVAILABLE AT www.eAuditNet.com.
- /5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.
- a. FOR SIZES 06 AND SMALLER: MARK TRADEMARK, CAGE CODE OR TRADEMARK, LETTERS "AS," AND MATERIAL CODE LETTER.
 - b. FOR SIZES 08 AND LARGER: MARK TRADEMARK, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, AND MATERIAL CODE LETTER.
6. INTENDED USE: THIS STANDARD IS THE FUNCTIONAL EQUIVALENT OF AN924 AND IS INTENDED TO BE SUITABLE AS A REPLACEMENT STANDARD.
- /7/ THE HEX CORNERS MAY BE ROUNDED PER ARP1942.
- /8/ FINISH CODE LETTER "V" SHALL BE PLACED AFTER SIZE CODES ONLY FOR MATERIAL CODE "W" PARTS THAT ARE TO BE COATED WITH HIGH PURITY ALUMINUM TO PROVIDE LOW ELECTRICAL CONTACT RESISTANCE.
9. INTERPRETATION OF DRAWING PER AS4296.
10. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra. SURFACES OF HEX FLATS MAY BE 250 MICROINCHES Ra.
11. BREAK EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.
13. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± 0.16 , ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.

	AEROSPACE STANDARD	AS5178™ SHEET 3 OF 4	REV. E
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