

**Bolts and Screws, Titanium Alloy
6Al - 4V
Procurement Specification For**

FSC 5306

1. SCOPE:

1.1 Type:

This procurement specification covers aircraft-quality bolts and screws made of 6Al-4V titanium alloy and of 160 ksi tensile strength at room temperature.

1.2 Application:

Primarily for aerospace propulsion system applications where high strength, light weight fasteners are required for use up to approximately 600 °F.

1.3 Safety - Hazardous Materials:

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

2. REFERENCES:

2.1 Applicable Documents:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other documents shall be the issue in effect on the date of the purchase order.

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2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

2.1.1.1 Aerospace Material Specifications:

AMS 2645	Fluorescent Penetrant Inspection
AMS 2750	Pyrometry
AMS 4967	Titanium Alloy Bars and Forgings, 6Al-4V, Annealed, Heat Treatable

2.1.1.2 Aerospace Standards:

AS1132	Design Parameters for Bolts and Screws, External Wrenching, Unified Thread Inch Series
AS1814	Terminology for Titanium Microstructures
AS3062	Bolts, Screws, and Studs, Screw Thread Requirements
AS3063	Bolts, Screws, and Studs, Geometric Control Requirements

2.1.2 U.S. Government Publications: Available from Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

2.1.2.1 Military Specification:

MIL-S-8879	Screw Threads, Controlled Radius Root With Increased Minor Diameter; General Specification for
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2.1.2.2 Military Standards:

MIL-STD-1312	Fastener, Test Methods
MIL-STD-2073-1	DoD Materiel, Procedures for Development and Application of Packaging Requirements

2.1.3 ASTM Publications: Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM E 8	Tension Testing of Metallic Materials
ASTM B 600	Descaling and Cleaning Titanium and Titanium Alloy Surfaces

2.1.4 ANSI Publication: Available from American National Standards Institute, 11 West 42nd Street, 13th Floor, New York, NY 10036.

ANSI/ASME B46.1 Surface Texture (Surface Roughness, Waviness, and Lay)

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2.2 Definitions:

PRODUCTION INSPECTION LOT: Shall be all finished parts of the same part number, made from a single heat of alloy, heat treated at the same time to the same specified condition, produced as one continuous run, and submitted for vendor's inspection at the same time.

Refer to AS1814 for titanium microstructure terms and definitions.

2.3 Unit Symbols:

° - degree, angle

° Baume' - hydrometer scale unit for measuring specific gravity of liquids

°F - degree Fahrenheit

% - percent (1% = 1/100)

lbf - pound-force

ksi - kips (1000 pounds) per square inch

sp gr - specific gravity

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Shall be AMS 4967 titanium alloy.

3.2 Design:

Finished (completely manufactured) parts shall conform to the following requirements:

3.2.1 Dimensions: The dimensions of finished parts, after all processing, shall conform to the part drawing. Dimensions apply before any required coating with dry film lubricants.

3.2.2 Surface Texture: Surface texture of finished parts, prior to any required coating, shall conform to the requirements as specified on the part drawing, determined in accordance with ANSI/ASME B46.1.

3.2.3 Threads: Screw thread UNJ profile and dimensions shall be in accordance with MIL-S-8879, unless otherwise specified on the part drawing.

3.2.3.1 Incomplete Threads: Incomplete threads are permissible at the chamfered end and the juncture of the unthreaded portion of the shank or adjacent to the head as specified in AS3062.

3.2.3.2 Chamfer: The entering end of the thread shall be chamfered as specified on the part drawing.

3.2.4 Geometric Tolerances: Part features shall be within the geometric tolerances specified on the part drawing and, where applicable, controlled in accordance with AS3063.

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3.3 Fabrication:

3.3.1 Blanks: Heads shall be formed by hot forming or machining.

3.3.1.1 Cleaning: Blanks shall be cleaned prior to heat treatment in accordance with ASTM B 600, or other methods approved by the purchaser. Blank surfaces shall be free of halogen compounds, such as residue from halogenated solvents and coolants, and salt from sweaty hands. Surfaces of parts, fixtures, racks, etc. shall be clean and free of dirt, water, oil, grease, paint, ink, crayon markings, dye pickup, finger prints, and other foreign material. After cleaning and prior to heat treatment, personnel handling blanks shall wear clean white cotton gloves or equivalent.

3.3.2 Heat Treatment: Headed and machined blanks after cleaning as in 3.3.1.1 shall, before finishing the shank and the bearing surface of the head, cold working the head-to-shank fillet radius when specified, and rolling the threads, be heat treated as follows:

3.3.2.1 Heating Equipment: Furnaces may be any type ensuring uniform temperature throughout the blanks being heated and shall be equipped with, and operated by, automatic temperature controllers and data recorders conforming to AMS 2750. The heating medium or atmosphere shall cause neither surface hardening nor embrittlement unless blanks are machined after heat treatment, to remove surface hardening.

3.3.2.2 Solution Heat Treatment: Blanks shall be uniformly heated to a temperature within the range 1650 to 1750 °F, held at the selected temperature within ± 15 °F for 30 to 60 minutes, and quenched in water.

3.3.2.3 Precipitation Heat Treatment: Solution heat treated blanks shall be heated to a temperature within the range 900 to 1100 °F, held at the selected temperature within ± 10 °F for 4 to 8 hours, and cooled in air.

3.3.3 Contamination Removal: The solution and precipitation heat treated blanks, before cold working the fillet radius when specified and rolling the threads, shall have the full body, head-to-shank fillet, and bearing surface of the head free from surface contamination and contamination penetration caused by prior heat treatment. The removal process shall produce no intergranular attack or corrosion, or changes of structure of the blanks. The metal removed from the bearing surface of the head and the full body diameter of the shank shall be as little as practicable to obtain a clean, smooth surface, and in no case shall be so great as to produce more cutting of flow lines in the head-to-shank junction of upset headed blanks than shown in Figure 1B.

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3.3.4 Cold Working of Fillet Radius: After removal of contamination as in 3.3.3, the head-to-shank fillet radius of parts having the radius complete throughout the circumference of the part shall, when specified, be cold worked sufficiently to remove all visual evidence of grinding or tool marks. Distortion due to cold working shall conform to Figure 2, unless otherwise specified on the part drawing. It shall not raise metal more than 0.002 inch above the contour at "A" or depress metal more than 0.002 inch below the contour at "B" as shown in Figure 2; distorted areas shall not extend beyond "C" as shown in Figure 2. In configurations having an undercut associated with the fillet radius, the cold working will be required only for 90° of fillet arc, starting at the point of tangency of the fillet radius and the bearing surface of the head. For shouldered bolts, having an unthreaded shank diameter larger than the thread major diameter and having an undercut associated with a fillet between the threaded shank and the shoulder of the unthreaded shank, the cold working will be required only for 90° of fillet arc, starting at the point of tangency of the fillet radius and the shouldered surface of the unthreaded shank. For parts with compound fillet radii between head and shank, cold work only the radius that blends with the head.

3.3.5 Thread Rolling: Threads shall be formed on the heat treated and finished blanks by a single rolling process after removal of contamination as in 3.3.3.

3.4 Product Marking:

Each part shall be identification marked as specified on the part drawing. The markings may be formed by forging or stamping, raised or depressed 0.010 inch maximum, with rounded root form on depressed characters.

3.5 Mechanical Properties:

Parts shall conform to the requirements of 3.5.1. Threaded members of gripping fixtures for tensile tests shall be of sufficient size and strength to develop the full strength of the part without stripping the thread. The loaded portion of the shank shall have a minimum of three full thread turns from the thread runout exposed between the loading fixtures during the tensile test. Finished parts shall be tested for ultimate tensile strength in accordance with MIL-STD-1312-8.

3.5.1 Ultimate Tensile Strength at Room Temperature:

3.5.1.1 Finished Parts: Parts shall have an ultimate tensile load not lower than that specified in Table 2 and shall be tested to failure, first measuring and recording the maximum tensile load achieved. If the size or shape of the part is such that failure would occur outside the threaded section but the part can be tested satisfactorily, such as parts having a shank diameter equal to or less than the thread root diameter or having an undercut, parts shall conform to only the ultimate tensile strength requirements of 3.5.1.2; for such parts, the diameter of the area on which stress is based shall be the actual measured minimum diameter of the part. Tension fasteners with either standard double hexagon drive or hexagon-type heads having a minimum metal condition in the head equal to the design parameters specified in AS1132 shall not fracture in the head-to-shank fillet radius except when this radius is associated with an undercut or with a shank diameter less than the minimum pitch diameter of the thread.

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3.5.1.2 Machined Test Specimens: If the size or shape of the part is such that a tensile test cannot be made on the part, tensile tests shall be conducted in accordance with ASTM E 8 on specimens prepared as in 4.5.6. Tests on such specimens shall be conducted at a strain rate of 0.003 to 0.007 inch/inch/minute through the 0.2% offset after which the rate shall be increased so as to produce failure in approximately one additional minute. Specimens shall meet the following requirements:

- a. Ultimate tensile strength, minimum: 160 ksi
- b. Elongation in 2 inches or 4D, minimum: 8%
- c. Reduction of area, minimum: 20%

3.6 Quality:

Parts shall be uniform in quality and condition, clean, sound, smooth, and free from burrs and foreign materials, and from imperfections detrimental to usage of the parts.

3.6.1 Macroscopic Examination: Parts or sections of parts as applicable, shall be etched in a solution consisting of:

- a. 15% \pm 2% by volume, technical grade nitric acid, 42° Baume'
- b. 10% \pm 1.5% by volume, hydrofluoric acid (48%)
- c. Balance water

(or other suitable etchant) for sufficient time to reveal flow lines but not longer than 5 minutes and then be examined at a magnification of approximately 20X to determine conformance to the following requirements.

3.6.1.1 Flow Lines:

3.6.1.1.1 Head-to-Shank: If parts have forged heads, examination of a longitudinal section through the part shall show flow lines in the shank, head-to-shank fillet, and bearing surface which follow the contour of the part as shown in Figure 1A, except that slight cutting of flow lines by the contamination removal process of 3.3.3 is permissible, as shown in Figure 1B; excessive cutting of flow lines in the shank, head-to-shank fillet, and bearing surface, as shown in Figure 1C, is not permissible except when an undercut is associated with the fillet radius. The head style shown in Figures 1A through 1C is for illustrative purposes only but other symmetrical head styles shall conform to the above requirements. Flow lines in heads on parts having special heads, such as Dee- or Tee-shaped heads or thinner than AS1132 standard heads, shall be as agreed upon by purchaser and vendor.

3.6.1.1.2 Threads: Flow lines in threads shall be continuous, shall follow the general thread contour, and shall be of maximum density at root of thread (see Figure 3).

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- 3.6.1.2 Internal Defects: Examination of longitudinal sections of the head and shank and of the threads shall reveal no cracks, laps, or porosity except laps in threads as permitted in 3.6.2.3.3 and 3.6.2.3.4. The head and shank section shall extend not less than $D/2$ from the bearing surface of the head and the threaded section shall extend not less than $D/2$ beyond the thread runout where "D" is the nominal diameter of the shank after heading. If the two sections would overlap, the entire length of the part shall be sectioned and examined as a whole.
- 3.6.2 Microscopic Examination: Specimens cut from parts shall be polished, etched with Kroll's reagent [5% hydrofluoric acid (sp gr 1.15), 12% nitric acid (sp gr 1.42), 83% water] and then be examined at a magnification not lower than 100X to determine conformance to the requirements of 3.6.2.1, 3.6.2.2, and 3.6.2.3.
- 3.6.2.1 Microstructure: Parts shall have microstructure free from indications of overheating resulting from heating above the beta transus without subsequent working in the alpha-beta temperature range. Alpha case or evidence of slight overheating on non-bearing surfaces of the head is permissible if the depth of overheating or case is not greater than 0.003 inch. Measurements shall be made normal to the surface. A structure showing outlines of equiaxed beta grains and no primary alpha grains will be cause for rejection.
- 3.6.2.2 Surface Hardening: Parts shall have no change in hardness from core to surface except as produced during cold working of the head-to-shank fillet radius when specified and during rolling of threads. In case of dispute over results of the microscopic examination, micro-hardness testing in accordance with MIL-STD-1312-6 shall be used as a referee method; a Vickers hardness reading within 0.003 inch of an unrolled surface which exceeds the reading in the core by more than 30 points shall be evidence of nonconformance to this requirement.
- 3.6.2.3 Threads:
- 3.6.2.3.1 Root defects such as laps, seams, notches, slivers, folds, roughness, and oxide scale are not permissible (see Figure 4).
- 3.6.2.3.2 Multiple laps on the flanks of threads are not permissible regardless of location. Single laps on the flanks of threads that extend toward the root are not permissible (see Figures 5 and 6).
- 3.6.2.3.3 There shall be no laps along the flank of the thread below the pitch diameter (see Figure 7). A single lap is permissible along the flank of the thread above the pitch diameter on either the pressure or nonpressure flank (one lap at any cross-section through the thread) provided it extends toward the crest and generally parallel to the flank (see Figure 7).
- 3.6.2.3.4 Crest craters, crest laps, or a crest lap in combination with a crest crater are permissible provided that the imperfections do not extend deeper than 20% of the basic thread height (see Table 1) as measured from the thread crest when the thread major diameter is at minimum size (see Figure 8). The major diameter of the thread shall be measured prior to sectioning. As the major diameter of the thread approaches maximum size, values for depth of crest crater and crest lap imperfections listed in Table 1 may be increased by one-half of the difference between the minimum major diameter and the actual major diameter as measured on the part.

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3.6.3 Fluorescent Penetrant Inspection: Parts shall be subject to fluorescent penetrant inspection in accordance with AMS 2645; use of higher sensitivity penetrant is permissible. Any required coating shall be removed for this inspection.

3.6.3.1 The following conditions shall be cause for rejection of parts inspected:

3.6.3.1.1 Discontinuities transverse to grain flow (i.e., at an angle of more than 10° to the axis of the shank), such as grinding checks and quench cracks.

3.6.3.1.2 Longitudinal indications (i.e., at an angle of 10° or less to the axis of the shank) due to imperfections other than seams, forming laps, and nonmetallic inclusions.

3.6.3.2 The following conditions shall be considered acceptable on parts inspected.

3.6.3.2.1 Parts having longitudinal indications (i.e., at an angle of 10° or less to the axis of the shank) of seams and forming laps parallel to the grain flow that are within the limits specified in 3.6.3.2.2 through 3.6.3.2.5 provided the separation between indications in all directions is not less than 0.062 inch.

3.6.3.2.2 Sides of Head: There shall be not more than three indications per head. The length of each indication may be the full height of the surface but no indication shall break over either edge to a depth greater than 0.031 inch or the equivalent of the basic thread height (see Table 1), whichever is less.

3.6.3.2.3 Shank or Stem: There shall be not more than five indications. The length of any indication may be the full length of the surface but the total length of all indications shall not exceed twice the length of the surface. No indication shall break into a fillet or over an edge.

3.6.3.2.4 Threads: There shall be no indications, except as permitted in 3.6.2.3.

3.6.3.2.5 Top of Head and End of Stem: The number of indications is not restricted but the depth of any individual indication shall not exceed 0.010 inch, as shown by sectioning representative samples. No indication, except those of 3.6.3.2.2, shall break over an edge.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of parts shall supply all samples and shall be responsible for performing all required tests. Purchaser reserves the right to perform such confirmatory testing as deemed necessary to ensure that the parts conform to the requirements of this specification.

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4.2 Responsibility for Compliance:

The manufacturer's system for parts production shall be based on preventing product defects, rather than detecting the defects at final inspection and then requiring corrective action to be invoked. An effective manufacturing in-process control system shall be established, subject to the approval of the purchaser, and used during production of parts.

4.3 Production Acceptance Tests:

The purpose of production acceptance tests is to check, as simply as possible, using a method which is inexpensive and representative of the part usage, with the uncertainty inherent in random sampling, that the parts comprising a production inspection lot satisfy the requirements of this specification.

4.4 Acceptance Tests:

Tests for all technical requirements are acceptance tests and shall be performed on each production inspection lot. A summary of acceptance tests is specified in Table 3.

4.5 Acceptance Tests Sampling:

4.5.1 Material: In accordance with AMS 4967.

4.5.2 Nondestructive Tests - Visual and Dimensional: A random sample of parts shall be taken from each production inspection lot, the size of the sample to be as specified in Table 4. The classification of dimensional characteristics shall be as specified in Table 5. All dimensional characteristics are considered defective when out of tolerance.

4.5.3 Fluorescent Penetrant Inspection: A random sample shall be selected from each production inspection lot; the size of the sample shall be as specified in Table 4 and classified as in Table 5. The sample units may be selected from those that have been subjected to and passed the visual and dimensional inspection, with additional units selected at random from the production inspection lot as necessary.

4.5.4 Destructive Tests: A random sample shall be selected from each production inspection lot; the size of the sample shall be as specified in Table 6. The sample units may be selected from those that have been subjected to and passed the nondestructive tests and the fluorescent penetrant inspection, with additional units selected at random from the production inspection lot as necessary.

4.5.5 Acceptance Quality: Of random samples tested, acceptance quality shall be based on zero defectives.

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4.5.6 Test Specimens: Specimens for tensile testing of machined test specimens shall be of standard proportions in accordance with ASTM E 8 with either 0.250 inch diameter at the reduced parallel gage section or smaller specimens proportional to the standard when required. Specimens shall be machined from finished parts or coupons of the same lot of alloy and be processed together with the parts they represent. Specimens shall be machined from the center of parts 0.750 inch and under in diameter, from the center of coupons 0.800 inch and under in nominal diameter or distance between parallel sides, and from mid-radius of larger parts or coupons.

4.6 Reports:

The vendor of parts shall furnish with each shipment a report stating that the chemical composition of the parts conform to the applicable material specification, showing the results of tests to determine conformance to the room temperature ultimate tensile strength requirements, and stating that the parts conform to the other technical requirements of this specification. This report shall include the purchase order number, AS7460, lot number, contractor or other direct supplier of material, part number, nominal size, and quantity.

4.7 Rejected Lots:

If a production inspection lot is rejected, the vendor of parts may perform corrective action to screen out or rework the defective parts, and resubmit for acceptance tests inspection as in 4.4. Resubmitted lots shall be clearly identified as re-inspected lots.

5. PREPARATION FOR DELIVERY:

5.1 Packaging and Identification:

5.1.1 Parts having different part numbers shall be packed in separate containers.

5.1.2 Each container of parts shall be marked to show not less than the following information:

- a. FASTENERS, TITANIUM ALLOY, 6Al-4V
- b. AS7460
- c. PART NUMBER
- d. LOT NUMBER
- e. PURCHASE ORDER NUMBER
- f. QUANTITY
- g. MANUFACTURER'S IDENTIFICATION

5.1.3 Threaded fasteners shall be suitably protected from abrasion and chafing during handling, transportation and storage.

5.1.4 Containers of parts shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the product to ensure carrier acceptance and safe delivery.

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5.1.5 For direct U.S. Military procurement, packaging shall be in accordance with MIL-STD-2073-1, industrial packaging, unless level A is specified in the request for procurement.

6. ACKNOWLEDGMENT:

A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.

7. REJECTIONS:

Parts not conforming to this specification, or to modifications authorized by purchaser, will be subject to rejection.

8. NOTES:

8.1 Direct U.S. Military Procurement:

Purchase documents should specify the following:

- a. Title, number, and date of this specification
- b. Part number of parts desired
- c. Quantity of parts desired
- d. Level A packaging, if required (see 5.1.5)

8.2 Equipment:

8.2.1 The tank for the solution of 3.6.1 must be lined with polyvinyl chloride or comparable lining material.

8.2.2 Adequate ventilation is necessary because of the production of gaseous fumes due to vigorous reaction.

8.2.3 Fixtures, racks, and baskets shall be coated with acid resistant material that will not react with the nitric-hydrofluoric acid solution.

8.3 Key Words:

Bolts, screws, procurement specification

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GENERAL STANDARDS FOR AEROSPACE PROPULSION SYSTEMS

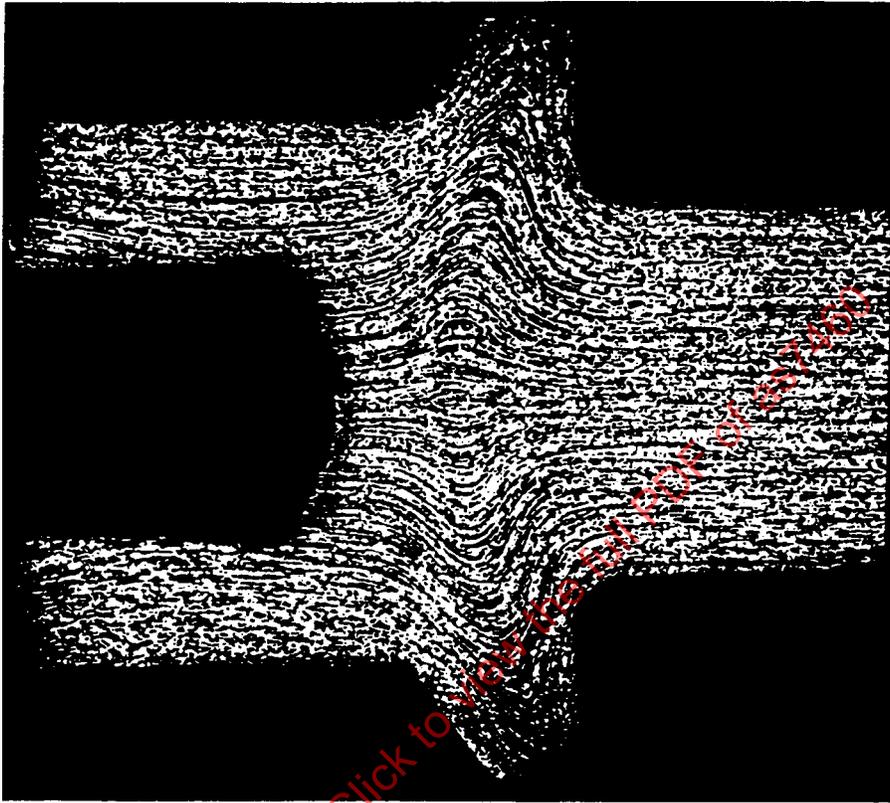


FIGURE 1A - Satisfactory Grain Flow

Showing a smooth, well formed grain flow following the contour of the under head fillet radius.

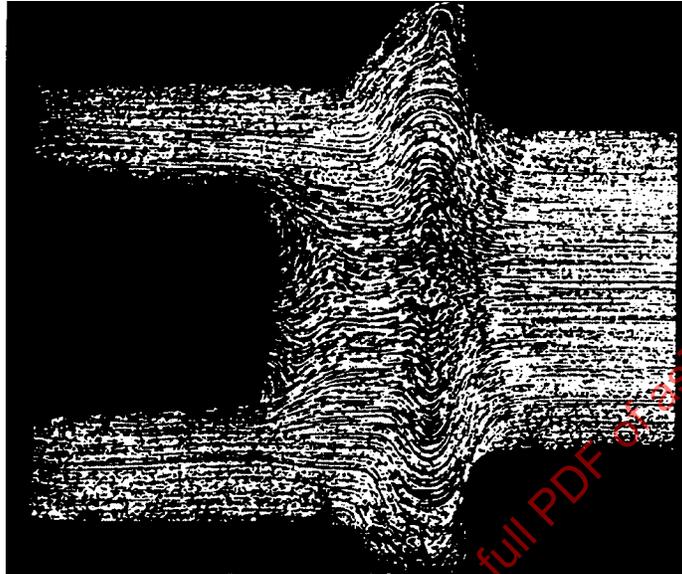


FIGURE 1B - Minimum Acceptable Standard

Showing maximum permissible cutting of grain flow after machining to remove contamination oxide.

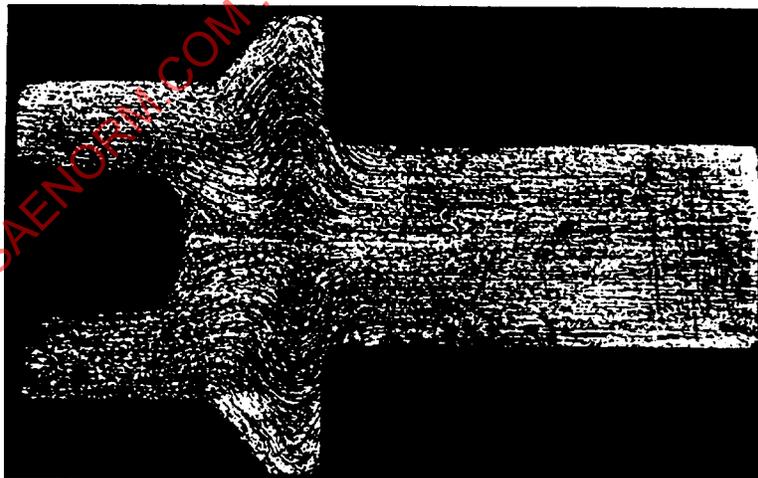
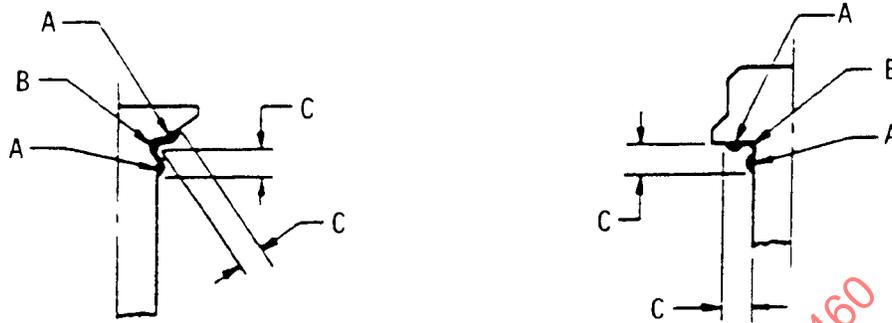


FIGURE 1C - Unacceptable Grain Flow

Showing excessive cutting of grain flow in the shank, fillet and bearing surface which is not permissible.

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Nominal Bolt Diameter, inch	C max inch
Up to 0.3125, excl	0.062
0.3125 and 0.375	0.094
0.4375 to 0.625, incl	0.125
0.750 to 1.000, incl	0.156
Over 1.000	0.188

FIGURE 2 - Permissible Distortion From Fillet Working



FIGURE 3 - Flow Lines, Rolled Thread

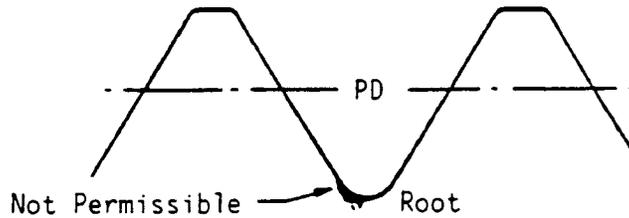


FIGURE 4 - Root Defects, Rolled Thread

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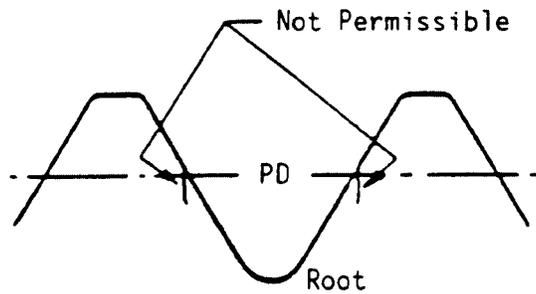


FIGURE 5 - Laps Below PD Extending Toward Root, Rolled Thread

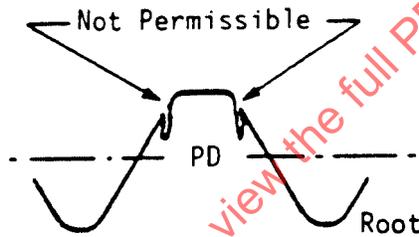


FIGURE 6 - Laps Above PD Extending Toward Root, Rolled Thread

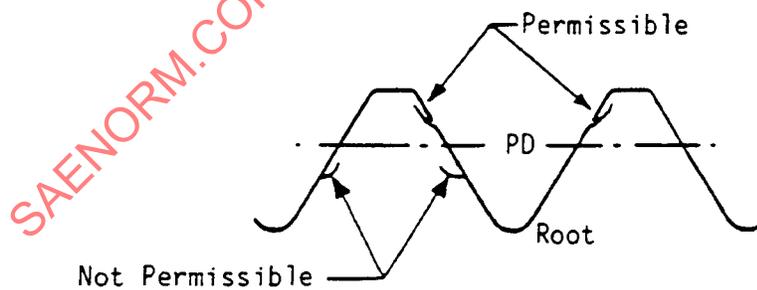
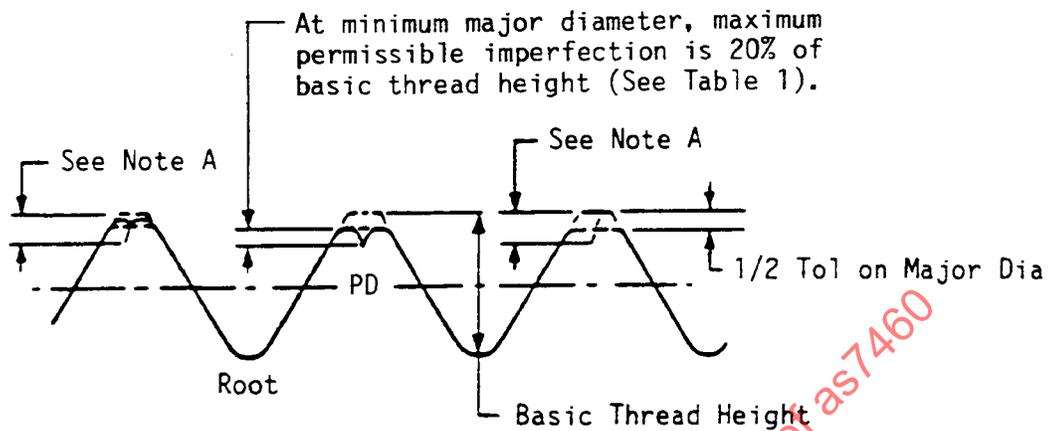


FIGURE 7 - Laps Extending Towards Crest, Rolled Thread

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Note A: Maximum depth of imperfection equals 20% of basic thread height plus 1/2 the difference of the actual major diameter and minimum major diameter.

FIGURE 8 - Crest Craters and Crest Laps, Rolled Thread

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