

REV.
B

AS81935/3

RATIONALE

THIS REVISION CORRECTS A TYPOGRAPHICAL ERROR IN THE TOLERANCE OF GROOVE DIMENSION F AND UPDATES SUPERSEDED SPECIFICATIONS.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81935.

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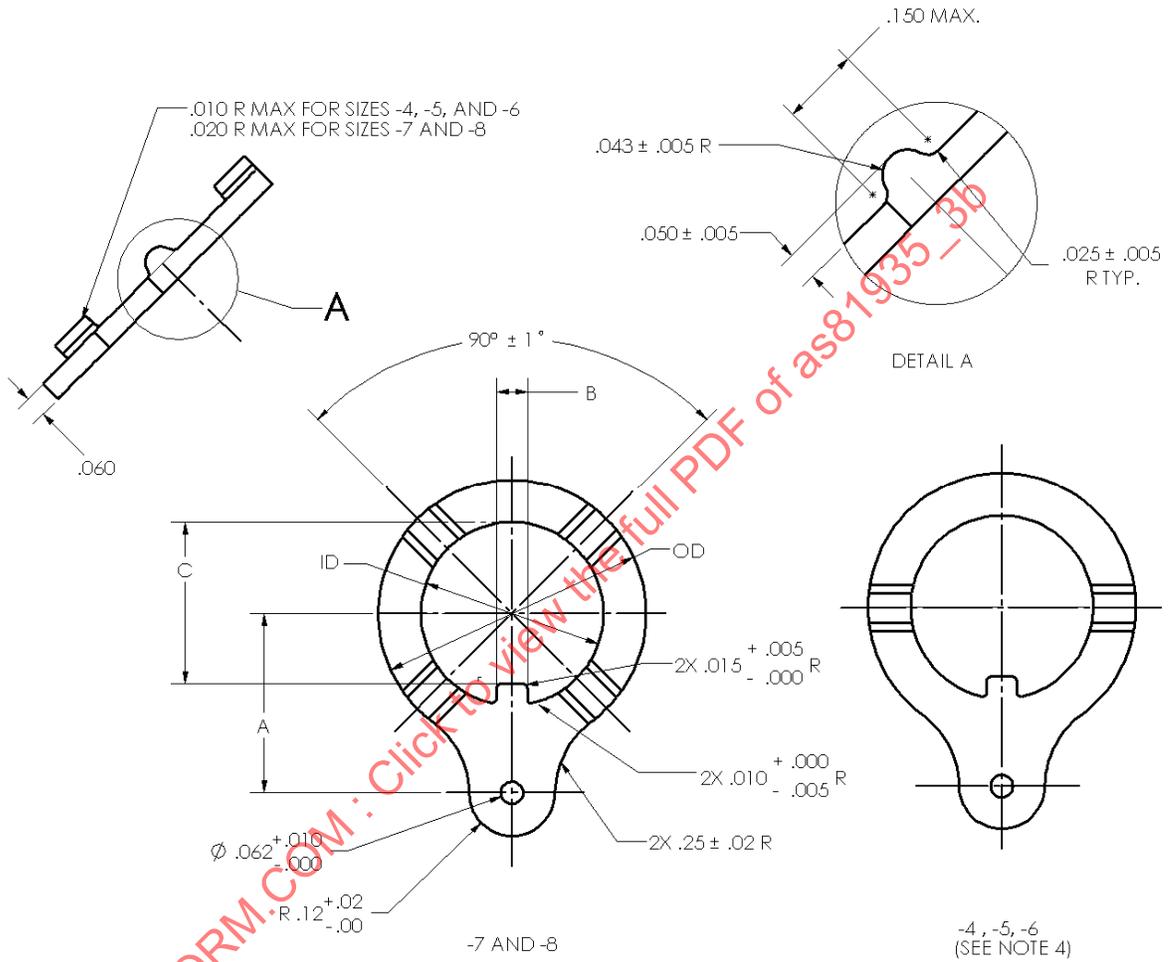
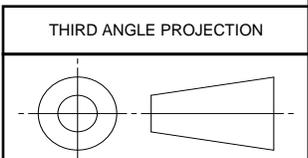


FIGURE 1 - LOCKING DEVICE

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AIR81935/3B>



CUSTODIAN: AIRFRAME CONTROL BEARINGS GROUP

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD
LOCKING DEVICES
(FOR ROD END BEARINGS)

AS81935/3
SHEET 1 OF 4

REV.
B

ISSUED 1998-03 REVISED 2014-06

TABLE 1 - APPROVED CALLOUT

PART NUMBER	ID ±.005	OD +.02 -.00	A +.02 -.00	B ±.005	C ±.005
M81935/3-4	.261	.44	.31	.055	.212
M81935/3-5	.324	.50	.35	.055	.273
M81935/3-6	.386	.56	.39	.086	.324
M81935/3-7	.449	.63	.42	.086	.388
M81935/3-8	.511	.75	.50	.086	.450

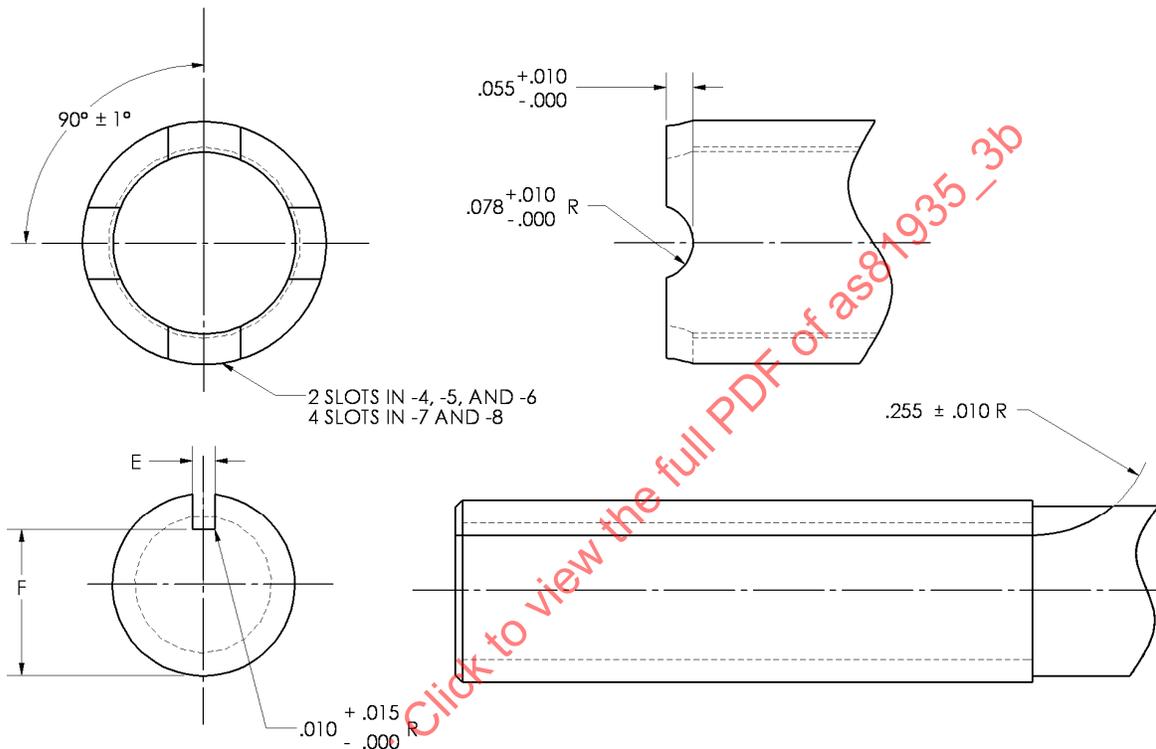


FIGURE 2 - ROD END TERMINAL DESIGN FOR USE WITH M81935/3 LOCKING DEVICE

TABLE 2 - ROD END TERMINAL DESIGN DATA

THREAD (MALE)	E	F
UNJF-3A	+.005 -.000	+.000 -.005
.2500-28	.062	.207
.3125-24	.062	.268
.3750-24	.093	.319
.4375-20	.093	.383
.5000-20	.093	.445



AEROSPACE STANDARD

LOCKING DEVICES
(FOR ROD END BEARINGS)

AS81935/3
SHEET 2 OF 4

REV.
B

REQUIREMENTS:

1. MATERIAL: NO SUFFIX INDICATES 4130 STEEL PER AMS6350, AMS6351, OR AMS6345. HEAT TREATMENT HRC 35 TO 39 IN ACCORDANCE WITH AMS-H-6875 OR AMS2759.
 "C" INDICATES A286 PER AMS5737 OR AMS5525. HARDNESS HRC 27 TO 31.
2. FINISH: NO SUFFIX CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
 "C" PASSIVATE PER AMS2700 TYPE 2.
3. THIS ROD END LOCK IS INTENDED FOR USE WITH THE NAS509 JAM NUT FOR POSITIVE LOCKING OF ROD END BEARINGS TO HYDRAULIC CYLINDER PISTON RODS.
4. FOR CLOSE ADJUSTMENT TO WITHIN .001 USE NAS1193.
5. FOR THREAD SIZES LARGER THAN .5000-20 UNJF-3A REFER TO NASM14198 OR NAS1193 AS APPLICABLE.
6. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE: DECIMALS ± 0.10 INCHES AND ANGLES $\pm 0.5^\circ$.
7. ALL INTERIOR PACKAGES SHALL BE MARKED PER MIL-STD-129.
8. PARTS SHALL BE MARKED IN ACCORDANCE WITH MIL-STD-130.
9. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ON M81935/3-4, -5, AND -6 ARE IDENTICAL TO M81935/3-7 AND -8.
10. PARTS SHALL BE FREE FROM BURRS AND FLAT WITHIN .010 INCHES ON SIZES -4, -5, AND -6 AND WITHIN .020 in ON SIZES -7 AND -8.

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. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
2. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.
3. THE PART NUMBERS FOR CANCELLED DOCUMENT MIL-B-81935/3 AND THE PART NUMBERS FOR THE SUPERSEDING DOCUMENT AS81935/3 ARE IDENTICAL. THE PART NUMBERS HAVE NOT BEEN CHANGED. SEE TABLE 3.

TABLE 3 - CROSS REFERENCE

CROSS REFERENCE EXAMPLE		
	CANCELLED	REPLACEMENT
DOCUMENT	MIL-B-81935/3	AS81935/3
PART NUMBER	M81935/3-()	M81935/3-()