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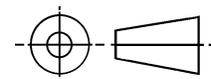
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THIRD ANGLE PROJECTION



ISSUED 1998-08 REAFFIRMED 2003-10

PREPARED BY COMMITTEE E-25

PROCUREMENT SPECIFICATION: AMS 7452-73

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

STUD, SHOULDERED AND STEPPED, HEXAGON  
WRENCHING, DRILLED, STEEL,  
.190-32 UNF-3A X .250-28 UNF-3A

**AS9309**  
SHEET 1 OF 4

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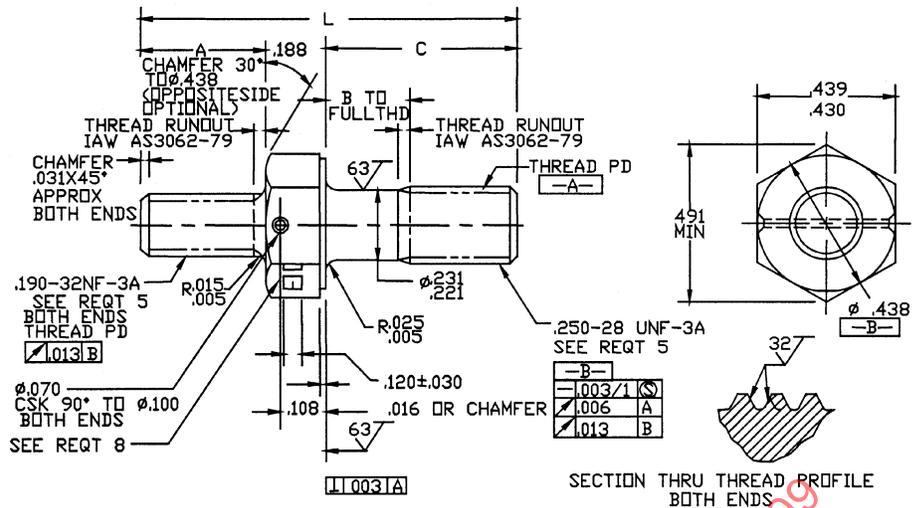


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100	DASH NO.	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100
-001	.375	1/	.500	1.062	1.61	-050	.438	1/	.500	1.125	1.66
-002	.375	1/	.562	1.125	1.66	-051	.438	1/	.562	1.188	1.75
-003	.375	1/	.625	1.188	1.75	-052	.438	1/	.625	1.250	1.83
-004	.375	1/	.688	1.250	1.83	-053	.438	1/	.688	1.312	1.89
-005	.375	1/	.750	1.312	1.89	-054	.438	1/	.750	1.375	1.95
-006	.375	1/	.812	1.375	1.95	-055	.438	1/	.812	1.438	2.03
-007	.375	.125	.875	1.438	2.03	-056	.438	.125	.875	1.500	2.09
-008	.375	.188	.938	1.500	2.09	-057	.438	.188	.938	1.562	2.17
-009	.375	.250	1.000	1.562	2.17	-058	.438	.250	1.000	1.625	2.23
-010	.375	.312	1.062	1.625	2.23	-059	.438	.312	1.062	1.688	2.32
-011	.375	.375	1.125	1.688	2.32	-060	.438	.375	1.125	1.750	2.40
-012	.375	.375	1.188	1.750	2.40	-061	.438	.438	1.188	1.812	2.46
-013	.375	.438	1.250	1.812	2.46	-062	.438	.438	1.250	1.875	2.51
-014	.375	.500	1.312	1.875	2.51	-063	.438	.500	1.312	1.938	2.60
-015	.375	.562	1.375	1.938	2.60	-064	.438	.562	1.375	2.000	2.68
-016	.375	.688	1.438	2.000	2.68	-065	.438	.688	1.375	2.062	2.74
-017	.375	.750	1.500	2.062	2.74	-066	.438	.750	1.438	2.125	2.80
-018	.375	.812	1.562	2.125	2.80	-067	.438	.812	1.500	2.188	2.89
-019	.375	.875	1.625	2.188	2.89	-068	.438	.875	1.562	2.250	2.97
-020	.375	.938	1.688	2.250	2.97	-069	.438	.938	1.688	2.312	3.02
-021	.375	1.000	1.750	2.312	3.02	-070	.438	1.000	1.750	2.375	3.08
-022	.375	1.062	1.812	2.375	3.08	-071	.438	1.062	1.812	2.438	3.16
-023	.375	1.125	1.875	2.438	3.16	-072	.438	1.125	1.875	2.500	3.25
-024	.375	1.188	1.938	2.500	3.25	-073	.438	1.188	1.938	2.562	3.28
-025	.375	1.250	2.000	2.562	3.28	-074	.438	1.250	2.000	2.625	3.31

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

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TABLE I. DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NO	A	B +.000 -*.060	C	L REF	APPROX. WEIGHT LBS/100	DASH NO.	A	B +.000 -*.060	C	L REF	APPROX. WEIGHT LBS/100
-100	.500	1/	.500	1.188	1.75	-150	.562	1/	.500	1.250	1.83
-101	.500	1/	.562	1.250	1.83	-151	.562	1/	.562	1.312	1.89
-102	.500	1/	.625	1.312	1.89	-152	.562	1/	.625	1.375	1.95
-103	.500	1/	.688	1.375	1.95	-153	.562	1/	.688	1.438	2.03
-104	.500	1/	.750	1.438	2.03	-154	.562	1/	.750	1.500	2.09
-105	.500	1/	.812	1.500	2.09	-155	.562	1/	.812	1.562	2.17
-106	.500	.125	.875	1.562	2.17	-156	.562	.125	.875	1.625	2.23
-107	.500	.188	.938	1.625	2.23	-157	.562	.188	.938	1.688	2.32
-108	.500	.250	1.000	1.688	2.32	-158	.562	.250	1.000	1.750	2.40
-109	.500	.312	1.062	1.750	2.40	-159	.562	.312	1.062	1.812	2.46
-110	.500	.375	1.125	1.812	2.46	-160	.562	.375	1.125	1.875	2.51
-111	.500	.438	1.188	1.875	2.51	-161	.562	.438	1.188	1.938	2.60
-112	.500	.500	1.250	1.938	2.60	-162	.562	.500	1.250	2.000	2.68
-113	.500	.562	1.312	2.000	2.68	-163	.562	.562	1.312	2.062	2.74
-114	.500	.625	1.375	2.062	2.74	-164	.562	.625	1.375	2.125	2.80
-115	.500	.688	1.438	2.125	2.80	-165	.562	.688	1.438	2.188	2.89
-116	.500	.750	1.500	2.188	2.89	-166	.562	.750	1.500	2.250	2.97
-117	.500	.812	1.562	2.250	2.97	-167	.562	.812	1.562	2.312	3.02
-118	.500	.875	1.625	2.312	3.02	-168	.562	.875	1.625	2.375	3.08
-119	.500	.938	1.688	2.375	3.08	-169	.562	.938	1.688	2.438	3.16
-120	.500	1.000	1.750	2.438	3.16	-170	.562	1.000	1.750	2.500	3.25
-121	.500	1.062	1.812	2.500	3.25	-171	.562	1.062	1.812	2.562	3.28
-122	.500	1.125	1.875	2.562	3.28	-172	.562	1.125	1.875	2.625	3.31
-123	.500	1.188	1.938	2.625	3.31	-173	.562	1.188	1.938	2.688	3.33
-124	.500	1.250	2.000	2.688	3.33	-174	.562	1.250	2.000	2.750	3.39

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

## REQUIREMENTS:

1. MATERIAL : STEEL IN ACCORDANCE WITH AMS 6322-80.
2. FINISH : CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80.
3. HARDNESS : 26-32 HRC
4. THREADS : THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22
5. DIMENSIONING AND TOLERANCING : DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
6. SURFACE TEXTURE : SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH AS291-64.
7. MAGNETIC PARTICLE INSPECTION : MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640-83.
8. MARKING : MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2800-76. DEPRESSED .010 MAX.
9. TOLERANCE : UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm$ .010, ANGULAR DIMENSIONS  $\pm$ 5°.
10. MANUFACTURING SPECIFICATION: AMS 7452