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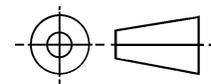
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THIRD ANGLE PROJECTION



ISSUED 1998-08 REAFFIRMED 2003-10

PREPARED BY COMMITTEE E-25

PROCUREMENT SPECIFICATION: AMS 7452-73



AEROSPACE STANDARD

STUD, SHOULDERED AND STEPPED, HEXAGON
WRENCHING, DRILLED, STEEL,
.250-28 UNF-3A X .3125-24 UNF-3A

AS9311
SHEET 1 OF 4

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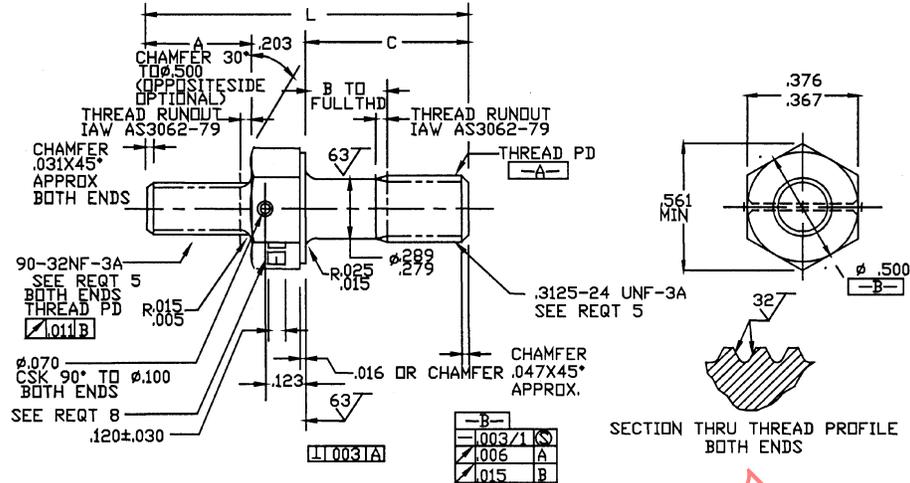


TABLE 1. DASH NUMBER AND DIMENSIONS

| 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 | .438 | 1/ | .500 | 1.141 | 2.57 | -050 | .500 | 1/ | .500 | 1.203 | 2.68 |
| -002 | .438 | 1/ | .562 | 1.203 | 2.68 | -051 | .500 | 1/ | .562 | 1.266 | 2.80 |
| -003 | .438 | 1/ | .625 | 1.266 | 2.80 | -052 | .500 | 1/ | .625 | 1.328 | 2.91 |
| -004 | .438 | 1/ | .688 | 1.328 | 2.91 | -053 | .500 | 1/ | .688 | 1.391 | 3.02 |
| -005 | .438 | 1/ | .750 | 1.391 | 3.02 | -054 | .500 | 1/ | .750 | 1.453 | 3.14 |
| -006 | .438 | 1/ | .812 | 1.453 | 3.14 | -055 | .500 | 1/ | .812 | 1.516 | 3.25 |
| -007 | .438 | 1/ | .875 | 1.516 | 3.25 | -056 | .500 | 1/ | .875 | 1.578 | 3.36 |
| -008 | .438 | 1/ | .938 | 1.578 | 3.36 | -057 | .500 | 1/ | .938 | 1.641 | 3.48 |
| -009 | .438 | .125 | 1.000 | 1.641 | 3.48 | -058 | .500 | .125 | 1.000 | 1.703 | 3.59 |
| -010 | .438 | .188 | 1.062 | 1.703 | 3.59 | -059 | .500 | .188 | 1.062 | 1.766 | 3.70 |
| -011 | .438 | .250 | 1.125 | 1.766 | 3.70 | -060 | .500 | .250 | 1.125 | 1.828 | 3.84 |
| -012 | .438 | .312 | 1.188 | 1.828 | 3.84 | -061 | .500 | .312 | 1.188 | 1.891 | 3.93 |
| -013 | .438 | .375 | 1.250 | 1.891 | 3.93 | -062 | .500 | .375 | 1.250 | 1.953 | 4.04 |
| -014 | .438 | .438 | 1.312 | 1.953 | 4.04 | -063 | .500 | .438 | 1.312 | 2.016 | 4.16 |
| -015 | .438 | .500 | 1.375 | 2.016 | 4.16 | -064 | .500 | .500 | 1.375 | 2.078 | 4.27 |
| -016 | .438 | .562 | 1.438 | 2.078 | 4.27 | -065 | .500 | .562 | 1.438 | 2.141 | 4.38 |
| -017 | .438 | .625 | 1.500 | 2.141 | 4.38 | -066 | .500 | .625 | 1.500 | 2.203 | 4.49 |
| -018 | .438 | .688 | 1.562 | 2.203 | 4.49 | -067 | .500 | .688 | 1.562 | 2.266 | 4.60 |
| -019 | .438 | .750 | 1.625 | 2.266 | 4.60 | -068 | .500 | .750 | 1.625 | 2.328 | 4.72 |
| -020 | .438 | .812 | 1.688 | 2.328 | 4.72 | -069 | .500 | .812 | 1.688 | 2.391 | 4.83 |
| -021 | .438 | .875 | 1.750 | 2.391 | 4.82 | -070 | .500 | .875 | 1.750 | 2.453 | 4.95 |
| -022 | .438 | .938 | 1.812 | 2.453 | 4.95 | -071 | .500 | .938 | 1.812 | 2.516 | 5.06 |
| -023 | .438 | 1.000 | 1.875 | 2.516 | 5.06 | -072 | .500 | 1.000 | 1.875 | 2.578 | 5.17 |
| -024 | .438 | 1.062 | 1.938 | 2.578 | 5.17 | -073 | .500 | 1.062 | 1.938 | 2.641 | 5.29 |
| -025 | .438 | 1.125 | 2.000 | 2.641 | 5.29 | -074 | .500 | 1.125 | 2.000 | 2.703 | 5.35 |

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

TABLE 1. DASH NUMBER 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 | .562 | 1/ | .500 | 1.266 | 2.80 | -150 | .625 | 1/ | .500 | 1.328 | 2.91 |
| .101 | .562 | 1/ | .562 | 1.328 | 2.91 | -151 | .625 | 1/ | .562 | 1.391 | 3.02 |
| .102 | .562 | 1/ | .625 | 1.391 | 3.02 | -152 | .625 | 1/ | .625 | 1.453 | 3.14 |
| .103 | .562 | 1/ | .688 | 1.453 | 3.14 | -153 | .625 | 1/ | .688 | 1.516 | 3.25 |
| -104 | .562 | 1/ | .750 | 1.516 | 3.25 | -154 | .625 | 1/ | .750 | 1.578 | 3.36 |
| -105 | .562 | 1/ | .812 | 1.578 | 3.36 | -155 | .625 | 1/ | .812 | 1.641 | 3.48 |
| -106 | .562 | 1/ | .875 | 1.641 | 3.48 | -156 | .625 | 1/ | .875 | 1.703 | 3.59 |
| -107 | .562 | 1/ | .938 | 1.703 | 3.59 | -157 | .625 | 1/ | .938 | 1.766 | 3.70 |
| -108 | .562 | .125 | 1.000 | 1.766 | 3.70 | -158 | .625 | .125 | 1.000 | 1.828 | 3.84 |
| -109 | .562 | .188 | 1.062 | 1.828 | 3.84 | -159 | .625 | .188 | 1.062 | 1.891 | 3.93 |
| -110 | .562 | .250 | 1.125 | 1.891 | 3.93 | -160 | .625 | .250 | 1.125 | 1.953 | 4.04 |
| -111 | .562 | .312 | 1.188 | 1.953 | 4.04 | -161 | .625 | .312 | 1.188 | 2.016 | 4.16 |
| -112 | .562 | .375 | 1.250 | 2.016 | 4.16 | -162 | .625 | .375 | 1.250 | 2.078 | 4.27 |
| -113 | .562 | .438 | 1.312 | 2.078 | 4.27 | -163 | .625 | .438 | 1.312 | 2.141 | 4.38 |
| -114 | .562 | .500 | 1.375 | 2.141 | 4.38 | -164 | .625 | .500 | 1.375 | 2.203 | 4.49 |
| -115 | .562 | .562 | 1.438 | 2.203 | 4.49 | -165 | .625 | .562 | 1.438 | 2.266 | 4.60 |
| -116 | .562 | .625 | 1.500 | 2.266 | 4.60 | -166 | .625 | .625 | 1.500 | 2.328 | 4.72 |
| -117 | .562 | .688 | 1.562 | 2.328 | 4.72 | -167 | .625 | .688 | 1.562 | 2.391 | 4.83 |
| -118 | .562 | .750 | 1.625 | 2.391 | 4.83 | -168 | .625 | .750 | 1.625 | 2.453 | 4.95 |
| -119 | .562 | .812 | 1.688 | 2.453 | 4.95 | -169 | .625 | .812 | 1.688 | 2.516 | 5.06 |
| -120 | .562 | .875 | 1.750 | 2.516 | 5.06 | -170 | .625 | .875 | 1.750 | 2.578 | 5.17 |
| -121 | .562 | .938 | 1.812 | 2.578 | 5.17 | -171 | .625 | .938 | 1.812 | 2.641 | 5.29 |
| -122 | .562 | 1.000 | 1.875 | 2.641 | 5.29 | -172 | .625 | 1.000 | 1.875 | 2.703 | 5.35 |
| -123 | .562 | 1.062 | 1.938 | 2.703 | 5.35 | -173 | .625 | 1.062 | 1.938 | 2.766 | 5.40 |
| -124 | .562 | 1.125 | 2.000 | 2.766 | 5.40 | -174 | .625 | 1.125 | 2.000 | 2.828 | 5.49 |

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

REQUIREMENTS:

- MATERIAL : STEEL IN ACCORDANCE WITH AMS 6322-80.
- FINISH : CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80.
- HARDNESS : 26-32 HRC
- DIMENSIONING AND TOLERANCING : DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
- 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.
- SURFACE TEXTURE : SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH A8291-64.
- MAGNETIC PARTICLE INSPECTION : MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640-83.
- MARKING : MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2800-76. DEPRESSED .010 MAX.
- TOLERANCES : UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
- MANUFACTURING SPECIFICATION : AMS 7452