

REV.
A

SAE AS9705

RATIONALE

CORRECT THE COUNTERSINK DIMENSION FOR THE SAFETY WIRE HOLE IN THE BOLT HEAD AND UPDATE THE THREAD STANDARD.

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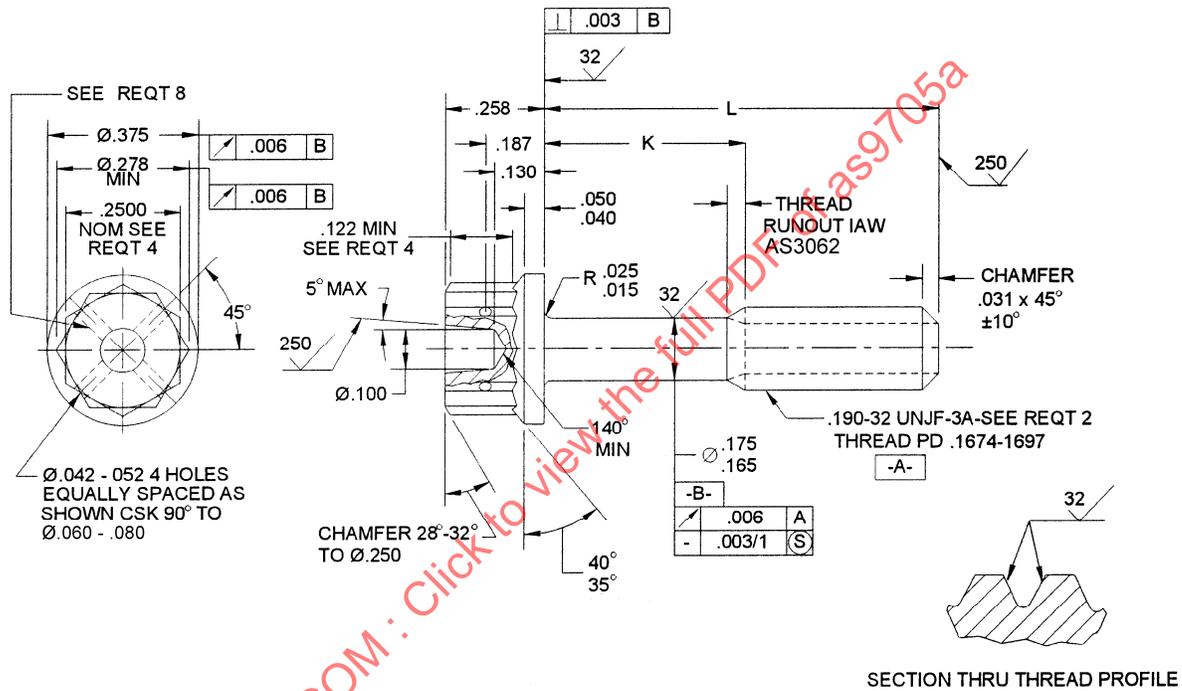
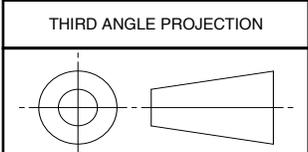


FIGURE 1

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS9705A>



CUSTODIAN: SAE E-25

PROCUREMENT SPECIFICATION: AS7471

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, DRILLED, CORROSION AND HEAT RESISTANT STEEL, .190-32 UNJF-3A

SAE AS9705
SHEET 1 OF 3

REV. A

TABLE 1 - DASH NUMBERS AND DIMENSIONS

DASH NO.	L	K	APPROX WEIGHT LB/100	DASH NO.	L	K	APPROX WEIGHT LB/100
-04	.375	.072-.092	.68	-25	1.688	.998-1.058	1.57
-05	.438	.072-.092	.73	-26	1.750	1.060-1.120	1.61
-06	.500	.072-.092	.77	-27	1.812	1.122-1.182	1.64
-07	.562	.072-.092	.81	-28	1.875	1.185-1.245	1.69
-08	.625	.072-.092	.85	-29	2.000	1.310-1.370	1.78
-09	.688	.072-.092	.90	-30	2.125	1.435-1.495	1.86
-10	.750	.072-.120	.94	-31	2.250	1.560-1.620	1.94
-11	.812	.122-.182	.98	-32	2.375	1.685-1.745	2.03
-12	.875	.185-.245	1.02	-33	2.500	1.810-1.870	2.11
-13	.938	.248-.308	1.06	-34	2.625	1.935-1.995	2.20
-14	1.000	.310-.370	1.10	-35	2.750	2.060-2.120	2.28
-15	1.062	.372-.432	1.15	-36	2.875	2.185-2.245	2.36
-16	1.125	.435-.495	1.19	-37	3.000	2.310-2.370	2.45
-17	1.188	.498-.558	1.23	-38	3.125	2.435-2.495	2.53
-18	1.250	.560-.620	1.27	-39	3.250	2.560-2.620	2.62
-19	1.312	.622-.682	1.31	-40	3.375	2.685-2.745	2.70
-20	1.375	.685-.745	1.36	-41	3.500	2.810-2.870	2.78
-21	1.438	.748-.808	1.40	-42	3.625	2.935-2.995	2.87
-22	1.500	.810-.870	1.44	-43	3.750	3.060-3.120	2.95
-23	1.562	.872-.932	1.48	-44	3.875	3.185-3.245	3.04
-24	1.625	.935-.995	1.52				

REQUIREMENTS:

1. MATERIAL: CORROSION AND HEAT RESISTANCE STEEL IN ACCORDANCE WITH AMS5708.
2. THREADS: THREADS IN ACCORDANCE WITH AS8879. INCOMPLETE THREADS NOT TO ENTER FILLET.
3. DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M-1982 (ASME PUBLICATION).
4. WRENCHING CONFIGURATION: WRENCHING CONFIGURATION IN ACCORDANCE WITH AS870-08.
5. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES, EXCEPT UPSET HEAD, IN ACCORDANCE WITH ANSI B46.1.
6. FLUORESCENT PENETRANT INSPECTION: FLUORESCENT PENETRANT INSPECTION PER ASTM E 1417.
7. HEAD TO SHANK FILLET: HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS EXCEPT DASH NUMBER SIZES -12 AND SMALLER.
8. MARKING: MARK PART NUMBER AND MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS478, CLASS A.
9. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS ± 0.10 , ANGULAR DIMENSIONS $\pm 5^\circ$.
10. EDGES: BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
11. MANUFACTURING SPECIFICATION: AS7471.

 An SAE International Group	AEROSPACE STANDARD	SAE AS9705 SHEET 2 OF 3	REV. A
	BOLT, MACHINE-DOUBLE HEXAGON, EXTENDED WASHER HEAD, DRILLED, CORROSION AND HEAT RESISTANT STEEL, .190-32 UNJF-3A		