

FIGURE 1

Notes unless otherwise specified:

- Dimensions are in inches after finish before lubrication
- Thread in accordance with AS8879
- Unless otherwise specified, tolerances are ± 0.010 , $\pm 2^\circ$, and surface roughness is $125 \sqrt{\text{in}}$.

LISI AEROSPACE
Central Seine
46/50, Quai de la Rapée
CS 11233
75583 PARIS CEDEX 12
Phone: +33 140 19 82 00

Written by

B.SOTOU-BERE

[Signature]

2022-03-28

Approved by

J. GOYER

[Signature]

2022-03-28

1. REQUIREMENTS

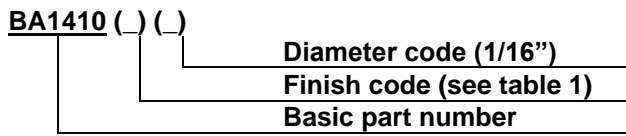
Table 1 - Material, finish and identification

FINISH CODE	MATERIAL	FINISH	LUBRICATION
-	Inconel 718 per AMS5662. Min tensile strength Rm = 220 KSI.	Passivation as per MIL-S-5002.	None
A		Dry film lubricant as per MIL-PRF-46010.	
B		Silver plating as per AMS2411 on threads only from .050" to .090" of seating surface. Thickness .0002" to .0005".	
C		Silver plating as per AMS2411 on full surface. Coating thickness shall be .0002" to .0005" on threads and bearing surface.	Cetyl alcohol per EN6117

Table 2 – Dimensions and performances

DASH NUMBER	THREAD SIZE UNJF-3B	A Max.	B	C Min.	ØD Max.	E Min.	ØF Min.	ØG Max.	UTS LBS Min.	MASS LBS/100
4	.2500-28	.300	.313 .305	.348	.438	.020	.398	.280	8900	.407
5	.3125-24	.385	.376 .367	.420	.531	.035	.491	.343	14060	.770
6	.3750-24	.455	.439 .430	.491	.649	.060	.609	.405	20900	1.270
7	.4375-20	.520	.564 .553	.633	.750	.075	.705	.473	28320	2.330
8	.5000-20	.578	.627 .616	.704	.870	.084	.825	.530	37730	3.360
9	.5625-18	.630	.690 .679	.774	.968	.097	.898	.593	48850	4.560
10	.6250-18	.692	.783 .772	.882	1.062	.126	.992	.675	59820	6.540
12	.7500-16	.786	.940 .928	1.059	1.250	.152	1.180	.805	86900	10.600
14	.8750-14	.895	1.064 1.052	1.200	1.438	.187	1.368	.930	118400	16.300
16	1.0000-12	.973	1.190 1.177	1.343	1.625	.232	1.555	1.055	155000	22.300

2. DESIGNATION



Example

BA1410B4: BA1410 Nut, Inconel, Silver plated on threads only, diameter 1/4".

3. MARKING

Manufacturer's identification .010" maximum depth, located as shown on Figure 1.

4. QUALIFICATION AND ACCEPTANCE

As per NASM25027, except as noted: nuts may be lubricated with graphite grease, for locking torque and breakaway torque test, in order to prevent nut-bolt seizure.

RECORD OF REVISIONS

Revision	Date	Modification	Justification
-	2004-02-26	Initial release.	
A	2004-08-09	Page 1: - Dimensional line for A and E has been moved from the chamfer to the flange. - Table of dimensions: UNJB-3B replaced by UNJF-3B Page 2: - Thickness added for code B.	
B	2017-03-15	- Template Updated. - Nota added to acceptance section. - MASS LBS/1000 replaced by MASS LBS/100 in Table 2 – Dimensions	
C	2021-12-03	Page 1: - Finish code C added Page 3: - Example: BA1410B3 replaced by BA1410B4	New need.
D	2022-03-28	Page 1: - Finish code C modified. Cetyl alcohol added in lubrication column Page 3: Example: "Bolt" replaced by "Nut"	