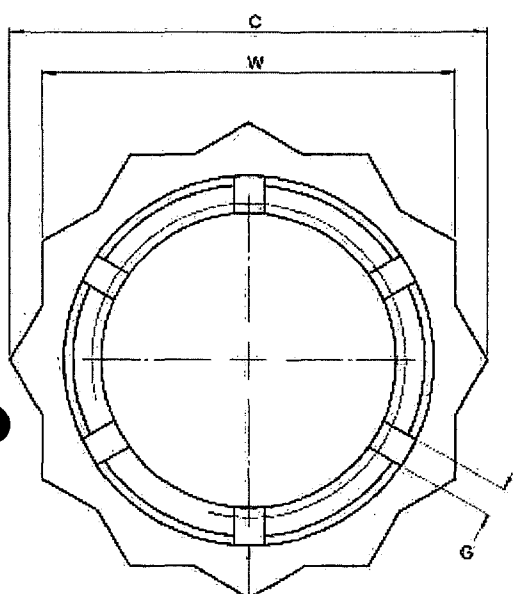




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NUT. SHEAR. DOUBLE HEXAGON SLOTTED. SELF-LOCKING INCO718

BA1520



OPPOSITE SLOTS MUST
COINCIDE WITHIN .005.
SLOT CENTERLINE
MUST BE WITHIN .005R.
OF THD. AXIS

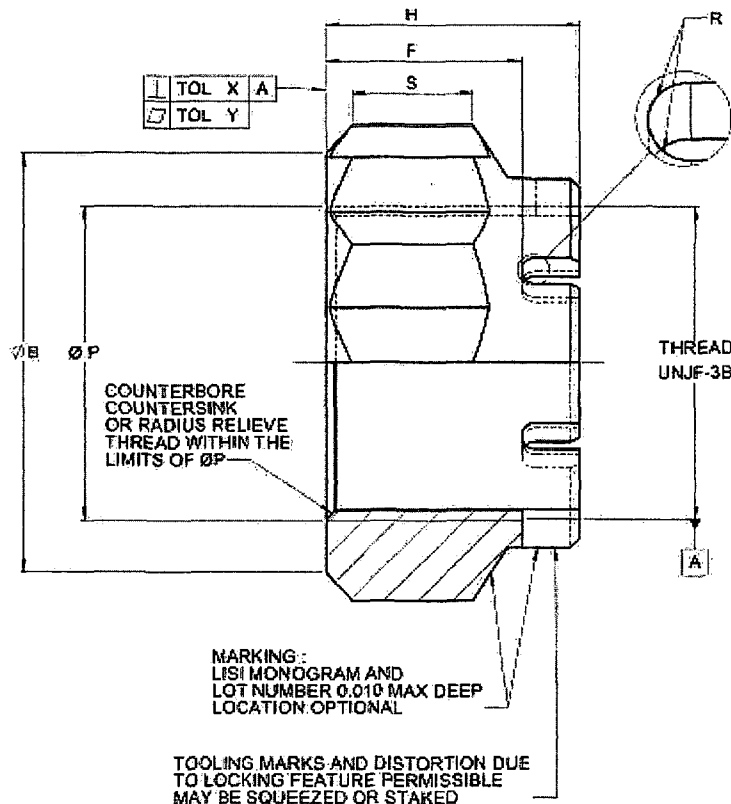


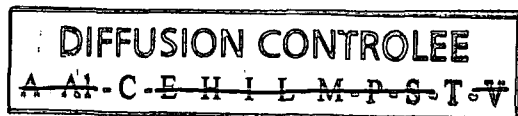
FIGURE 1

GENERAL NOTE:

UNLESS OTHERWISE SPECIFIED

- i) Units: Dimensions and tolerances are in inches. Dimensions to be met after finish.
- ii) Surface Texture : 125 $\sqrt{\text{max}}$ per ASME B46.1
- iii) Break sharp edges: 0.003 - 0.015
- iv) Fillets : R 0.005 / 0.020
- v) Thread: Per AMS8879
- vi) Tolerance: See Table 1
- vii) Drawing interpretations: ASME Y 14.5M-1994

01 FEB. 2008



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Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 1/3	R. LEMERCIER		11 JAN 08	F. VERDIER		11 JAN 08	A



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1. Nut definition

Configuration- Dimensions- Tolerances- Masses : see figure 1 and table 1

DIA DASH NUMBER	THREAD UNJF-3B	ØB min	C min	F±.015	G +.031 -.000	H Max	ØP Max	R Max	S Min	W		X Per NASM25027	Y Flat to Concave	AXIAL TENSILE STRENGTH LBS. MIN
										Max	Min			
03	.1900-32	.367	.419	.078	.078	.151	.210	.035	.028	.376	.367	.005	.002	1,800
04	.2500-28	.430	.491	.093	.078	.199	.270	.035	.053	.439	.430	.006	.002	3,230
05	.3125-24	.492	.561	.093	.078	.245	.332	.035	.075	.502	.492	.007	.002	5,120
06	.3750-24	.553	.631	.109	.125	.294	.405	.053	.098	.564	.553	.008	.002	7,600
07	.4375-20	.679	.775	.154	.125	.344	.467	.053	.110	.690	.679	.009	.003	10,300
08	.5000-20	.741	.846	.178	.125	.394	.530	.053	.129	.752	.741	.010	.003	13,700
09	.5625-18	.865	.987	.195	.156	.447	.597	.063	.137	.877	.865	.011	.003	17,400
10	.6250-18	.928	1.059	.237	.156	.499	.660	.063	.156	.940	.928	.012	.003	21,800
12	.7500-16	1.052	1.200	.332	.156	.608	.781	.063	.290	1.064	1.052	.014	.003	31,600
14	.8750-14	1.239	1.414	.388	.156	.717	.906	.071	.337	1.252	1.239	.017	.004	43,100
16	1.000-12	1.427	1.628	.453	.156	.829	1.031	.071	.394	1.440	1.427	.019	.004	56,000
18	1.1250-12	1.614	1.842	.557	.156	.945	1.156	.071	.466	1.627	1.614	.021	.005	72,000
20	1.2500-12	1.801	2.056	.592	.156	1.060	1.281	.071	.507	1.814	1.801	.024	.006	89,900
22	1.3750-12	1.988	2.269	.644	.156	1.187	1.406	.071	.561	2.002	1.988	.027	.006	109,600
24	1.5000-12	2.176	2.484	.714	.156	1.311	1.531	.071	.623	2.190	2.176	.030	.007	131,000

Table 1. DIMENSIONS AND TOLERANCES

Material

INCO718 per AMS 5662 or AMS 5663. Heat treated to 220 KSI minimum. Hardness : 48HRC maximum.

Surface Treatment

"-" Code : Silver plate per AMS2410

"M" Code : Molybdenum disulfide dry film lubricant per AS5272 type 1 or type 2.

2. Designation

Example: BA1520 M 10

Dia Dash Code

Surface Treatment Code

Basic part number

3. Marking

Manufacturer monogram and lot number 0.010 inch Max deep.

4. Technical Specification

Per spec NASM25027.

Performance of the locking feature per NASM25027 when tested on inconel 718 bolts or studs with AS8879, class 3A cross drilled threads. Reuse test limited to 5 cycles.

Fluorescent Penetrant inspect 100% per ASTM E 1417.

5. Installation Specification

N/A

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INCO718**

BA1520

Revision Date	Name	Modifications	Justification
DRAFT 02NOV2006	S.MARRY	New Document	-
ISSUE A 19NOV2007	R.LEMERCIER	Change in standard form and standard number	-
11.01.08			

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