

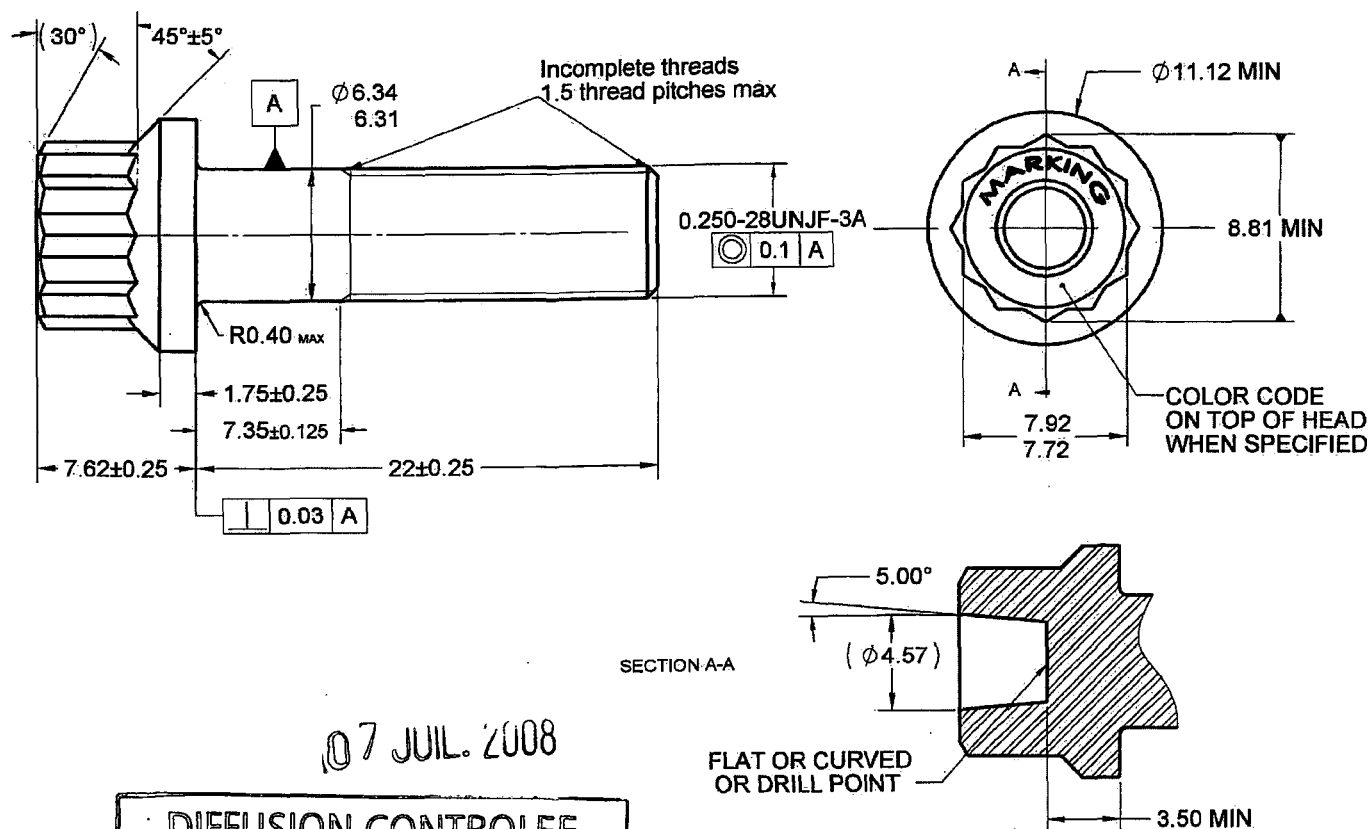
lisi AEROSPACE

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Ti-Bolt, 12 points, TA6V

BA3770

RECU 07 JUL. 2008



07 JUL. 2008

DIFFUSION CONTROLEE
A-A1-C-E-H-I-L-M-P-S-T-V

FIGURE 1

GENERAL NOTE:

UNLESS OTHERWISE SPECIFIED ON DRAWING

- i) **Units:** Dimensions and tolerances are in millimeters.
- ii) **Surface Texture :** $R_a 3.2 \sqrt{\text{ }}$ per ASME B46.1
- iii) **Break sharp edges:** 0.05mm/0.2mm. Bolt shall be free from blur and slivers.
- iv) **Fillets :** R 0.2mm / 0.4mm
- v) **Thread:** Per AS8879
- vi) **Tolerance:** ± 0.2 mm and $\pm 2^\circ$

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 1/3	R. LEMERCIER		03 Jul 2008	F. VERDIER		03 Jul 08	A



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1. Bolt definition

Configuration- Dimensions- Tolerances- Masses

For 0.250-28UNJF-3A (diameter code 04), see figure 1.

Material & Heat Treatment

Ti6Al4V per AMS4967 heat treated to 1100MPa

Surface Treatment

Code A : MOS2 coating per AS1701 class I+ cetyl alcohol per MIL-L-87132

Code B : HiKote®1 NC per EN4473 + cetyl alcohol per MIL-L-87132 with color code white on top of head.

Code C : LBC *

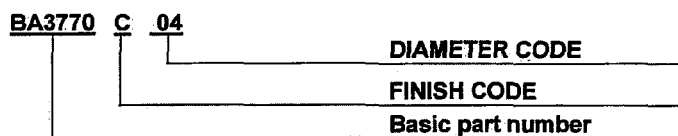
(* contact the Technical Center for information)

Service Temperature Limit

150°C

2. Designation

Example:



3. Marking

per EN2424 style A

4. Technical Specification

AS7460

5. Installation Specification

Mating Nut shall be per BA1550 or BA1551

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Revision Date	Name	Modifications	Justification
DRAFT2 8APR2008	R.LEMERCIER	New document	Etude Techspace Aero
DRAFT3 20MAY2008	R.LEMERCIER	Grip length was = 7.938mm Total length under pin head was = 20mm Painting for Color code added for finish A and B	Etude Techspace Aero
A 3JUL2008	R.LEMERCIER	Diffusion Controlée Page 1, note 1 was : "dimension to be met before coating". Deleted Page 2, Surface treatment, : "dry film" replaced by "coating" "HiKote 4@" replace by "HiKote 1@ NC + cetyl alcohol" For LBC coating, "cetyl alcohol" deleted	Etude Techspace Aero

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