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Insert, self-locking, self-broaching keys, floating, 425°C max.

SCD203

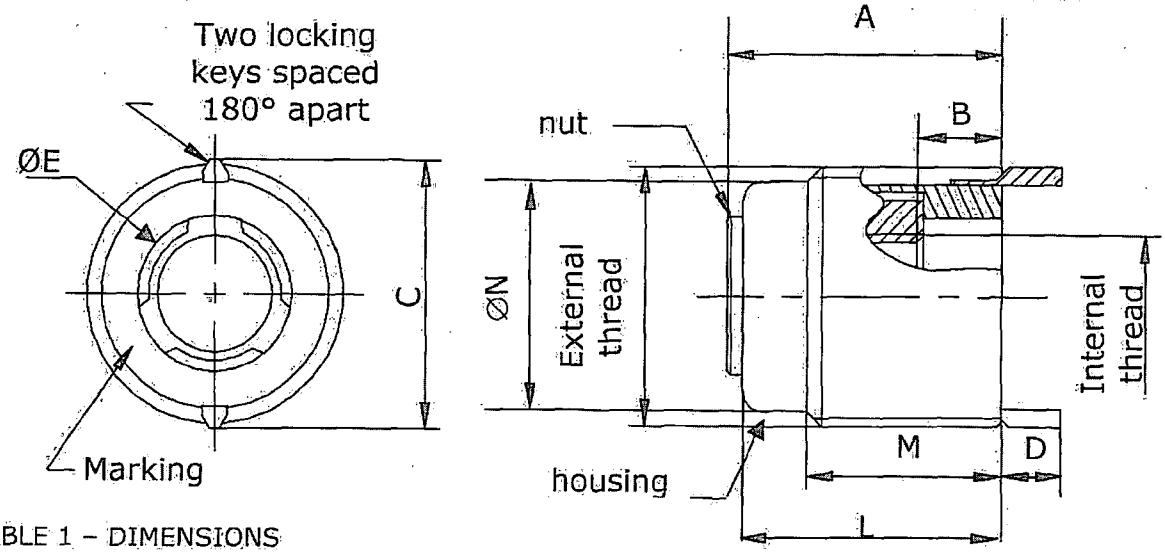

TABLE 1 – DIMENSIONS

Diameter code		064
Internal thread		.250-28 UNJF-3B
External thread (Minor dia. modified)	UNS – 2A	.500-20
	Minor dia.	11,68 11,58
	Pitch dia.	11,84 11,73
	Major dia.	12,67 12,46

Diameter code	064
A±0,3	12,9
B min. (1)	3,55
C max.	12,85
D min.	3,15
ØE	7,45 7,40
L max.	13,2
M	9,25 8,00
ØN max.	11,50

(1) Measured when the nut is in contact with the housing.

DIFFUSION CONTROLEE
~~A-AI-C-E-G-H-I-L-M-P-S-T-V~~
20 JUIL. 2006

REÇU 20 JUIL. 2006

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Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Issue
PAGE 1/3	Y.DOUARD		19 Juil 06	F.VERDIER		19 Juil 06	A

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Materials :

Nut and housing : A286 as per AMS5737 or AMS5731 (160 KSI), hardness 36 HRC min.

Keys : Corrosion resistant steel – Heat treatment to final hardness HV>650.

Finish: Passivated as per AMS-QQ-P-35.

Lubrication : Dry film lubricant on nut only, as per AS 1701 Class V or VI.

Internal thread: in accordance with AS8879.

External thread: in accordance with ASME B1.1 except modified minor diameter per TABLE 1.

Marking : Manufacturer's symbol " T ".

Technical specification : MIL-I-45914.

The insert shall accept a minimum free rotation of four turns on a corresponding test bolt having class 3A thread.

Minimum radial float: 0,5 mm.

A light bead is accepted at bottom of external thread intersecting longitudinal slots , subject to pass free in a go threaded gage according to TABLE 2, and not to be detrimental to driving in locking keys during insert installation.

Temperature class : 425°C.

Part number designation : SCD203-064
SCD203 designates basic part number and 064 designates diameter code.
Use SCD204 for oversize replacement.

TABLE 2 – GO THREADED GAGE FOR EXTERNAL THREAD.

Diameter code	064
Minor dia. +0,05 0	11,80
Pitch dia. +0,05 0	11,87
Major dia. +0,05 0	12,70

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Issue	Date	Name	Modification(s)	Justification(s)
-	10/11/2004	A. BERTON	New document	-
A	19/07/2006	Y.DOUARD	-Dmini=3,15 instead of D=3,96±0,25 -Add of ØE	-According to production -Functional dimension to fit tooling

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