



DASH NUMBER	THREAD SIZE UNJF-3B	$\varnothing A$ MAX	$\varnothing B$ MIN	C MIN	H MAX	$\varnothing P$ MAX	S MIN	V MIN	W MAX/MIN	X	Y	"Z" INCH POUNDS MIN	AXIAL STRENGTH LBS. MIN.	WEIGHT LBS/100 APPROX
1032	.1900-32	.327	.297	.277	.259	.220	.095	.023	.251/.243	.003	.002	90	3,190	.27
428	.2500-28	.409	.379	.347	.292	.280	.086	.033	.313/.305	.003	.002	170	5,820	.43
524	.3125-24	.490	.460	.419	.336	.342	.113	.043	.376/.367	.003	.002	340	9,290	.70
624	.3750-24	.580	.550	.491	.402	.405	.137	.058	.439/.430	.003	.002	600	14,000	1.08
720	.4375-20	.650	.620	.561	.485	.473	.160	.069	.502/.492	.003	.003	860	19,000	1.58
820	.5000-20	.740	.710	.703	.565	.535	.236	.079	.627/.616	.003	.003	1,250	25,600	2.76
918	.5625-18	.830	.800	.775	.635	.597	.242	.104	.690/.679	.004	.003	1,700	32,500	4.06
1018	.6250-18	.910	.880	.846	.705	.660	.258	.145	.752/.741	.004	.003	2,300	41,000	5.11

1. MATERIAL: A286 TO THE CHEMISTRY OF AMS 5732 OR AMS 5737.
2. HARDNESS: 46 HRC MAXIMUM.
3. FINISH: SILVER PLATE PER AMS 2410.
4. FLUORESCENT PENETRANT INSPECT 100% PER ASTM E 1417. ACCEPTANCE CRITERIA PER SPS-I-700. LEVEL II.
5. LOCKING TORQUE PER AS 7250.
6. STRENGTH OF WRENCHING SURFACE TO BE SUFFICIENT TO WITHSTAND WRENCH TORQUE PER COLUMN "Z".
7. BEARING SQUARENESS: WHEN MEASURED IN ACCORDANCE WITH MIL-DTL-25027.
8. THREADS BEFORE LUBRICATION PER MIL-S-8879.
9. BREAK SHARP EDGES .003-.015.
10. CORNERS MUST HAVE FILLETS .005-.020 R.
11. UNLESS OTHERWISE SPECIFIED, ALL DIAMETERS $\sqrt[.010]{A}$.
12. DIMENSIONS ARE TO BE MET PRIOR TO LUBRICANT.
13. DIMENSIONS ARE IN INCHES.
14. PART NUMBER: CONSISTS OF A BASIC PART NUMBER PLUS DASH NUMBER
EXAMPLE: FN1216-428 = .2500-28 UNJF-3B, SILVER PLATED
15. DESIGN AND USAGE LIMITATIONS: THE ULTIMATE TENSILE STRENGTH IS BASED ON 160 KSI AND THE TENSILE STRESS AREA OF A .003 REDUCED EXTERNAL THREAD. THESE NUTS ARE DESIGNED TO BE USED ON .003 REDUCED 3A EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
16. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.
17. PART NUMBERS OTHER THAN LISTED ON THIS DRAWING SHALL NOT BE USED.

INFORMATION ON THIS DOCUMENT IS A TRADE SECRET, PROPRIETARY, AND SHALL NOT BE USED OR REPRODUCED IN WHOLE OR IN PART WITHOUT WRITTEN AUTHORIZATION OF SPS TECHNOLOGIES.

TOLERANCES $\pm .010$ AND $\pm 2^\circ$	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M	SPS TECHNOLOGIES	FSCM NO. 56878	STANDARDS AND SPECIFICATIONS AS 7250
SURFACE ROUGHNESS 125 UNLESS OTHERWISE NOTED	DATE: 12/05/90	TITLE NUT, FLEXLOC, DOUBLE HEXAGON, SELF-LOCKING A286, 160 KSI, 1200°F	CUSTODIAN: JENKINTOWN, PA.	PART NUMBER: FN1216
DRAWN BY: STEVE FOSTER	DATE: 7/26/99			SHEET 1 OF 1
APPROVED: S HUTCHINSON				
APPROVED: M LAWLER				