FEDERAL SUPPLY CLASS
5310

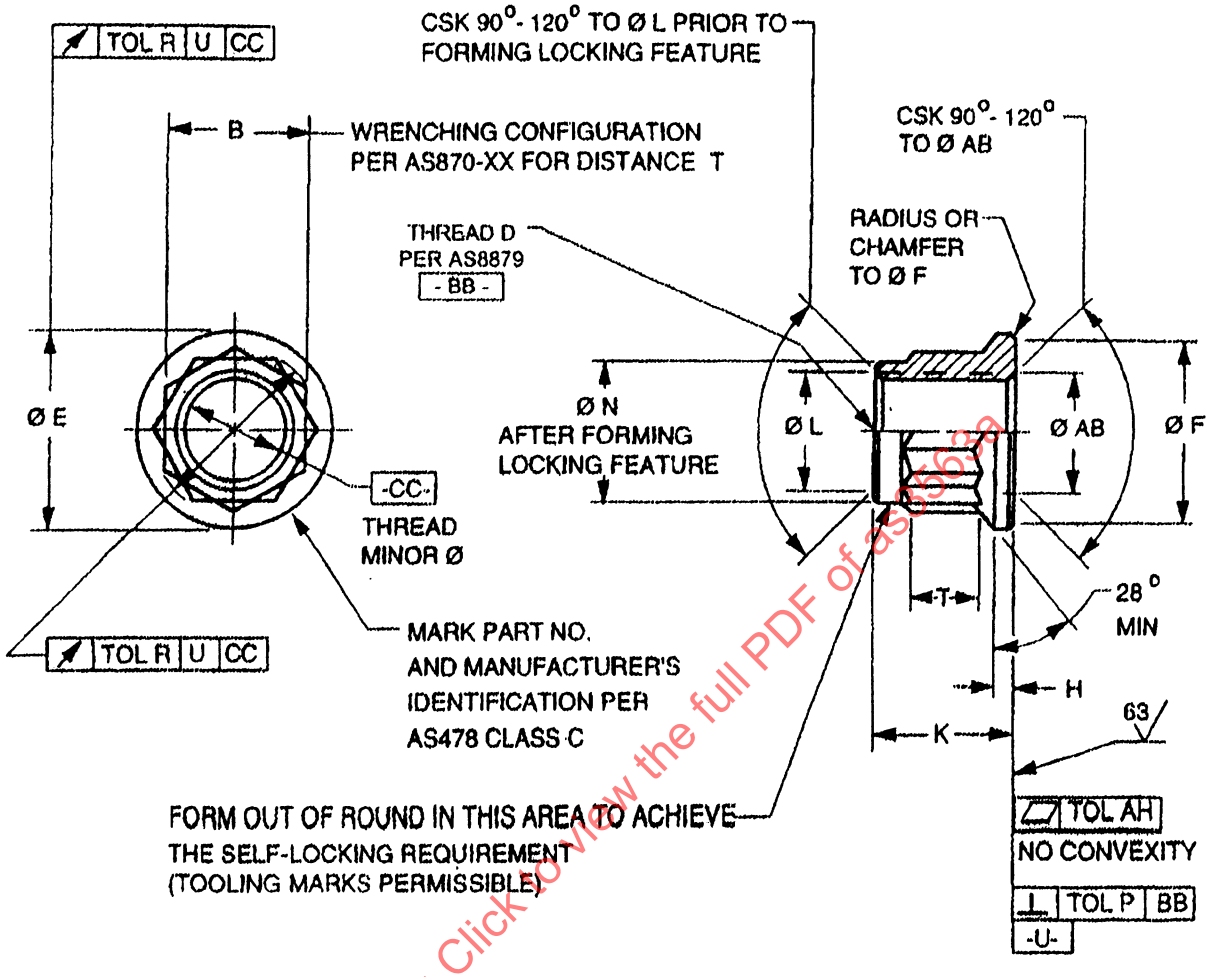
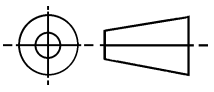


FIGURE 1

THIRD ANGLE PROJECTION



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PREPARED BY SAE COMMITTEE E-25, GENERAL STANDARDS FOR AEROSPACE PROPULSION SYSTEMS

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AEROSPACE STANDARD

(R) NUT, SELF-LOCKING, DOUBLE HEXAGON, SOLID FILM LUBRICATED, EXTENDED WRENCH PAD, 160 ksi, 800 °F, UNS S66286

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TABLE 1A

PART NUMBER	THREAD D	B NOM	DASH NO.	E MAX	F MIN	AB	H MIN	K MAX
AS3563-09	.190-32 UNJF-3B	.2500	08	.340	.325	.190-.220	.045	.305
AS3563-10	.250-28 UNJF-3B	.3125	10	.450	.410	.250-.280	.045	.400
AS3563-11	.3125-24 UNJF-3B	.3750	12	.525	.495	.312-.342	.060	.455
AS3563-12	.375-24 UNJF-3B	.4375	14	.600	.560	.375-.405	.070	.520
AS3563-13	.4375-20 UNJF-3B	.5625	18	.690	.650	.438-.468	.080	.595
AS3563-14	.500-20 UNJF-3B	.6250	20	.780	.740	.500-.532	.100	.680
AS3563-15	.5625-18 UNJF-3B	.6875	22	.880	.840	.562-.597	.110	.758
AS3563-16	.625-18 UNJF-3B	.7812	25	.970	.925	.625-.660	.120	.850
AS3563-17	.750-16 UNJF-3B	.9375	30	1.230	1.180	.750-.785	.130	1.032

TABLE 1B

PART NUMBER	L	N MAX	T MIN	P	R	AH	APPROX MASS LB/100
AS3563-09	.190-.210	.262	.082	.004	.006	.0014	.28
AS3563-10	.250-.270	.326	.130	.005	.007	.0014	.51
AS3563-11	.312-.332	.392	.170	.005	.008	.0016	.83
AS3563-12	.375-.395	.458	.210	.005	.009	.0016	1.34
AS3563-13	.438-.458	.588	.230	.005	.010	.0020	2.74
AS3563-14	.500-.520	.654	.260	.006	.012	.0020	3.34
AS3563-15	.562-.582	.720	.320	.006	.014	.0020	4.92
AS3563-16	.625-.645	.817	.370	.007	.015	.0020	7.12
AS3563-17	.750-.770	.980	.500	.007	.016	.0020	13.01

NOTES:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5731 OR 5734 (UNS S66286).
   HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE PRECIPITATION HEAT TREATED PER AMS 2754/3 TO MEET THE HARDNESS SPECIFIED IN NOTE 4.
2. PROCUREMENT SPECIFICATION: AS4393 EXCEPT AS FOLLOWS:
   a. COATING: SOLID FILM LUBRICANT PER AS1701, TYPE VI, IN LIEU OF SILVER PLATE PER AMS 2411.
   b. PRETREATMENT: PRIOR TO APPLYING THE SOLID FILM LUBRICANT, NUTS MAY BE PLATED WITH COPPER (AMS 2418) OR NICKEL (AMS 2403) TO .0001 MAXIMUM THICKNESS.
   c. DIMENSIONS APPLY AFTER PRETREATMENT PLATING AND BEFORE COATING WITH SOLID FILM LUBRICANT.
   d. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F FOR NUTS TESTED AFTER BAKE.
3. HARDNESS: 32 TO 39 HRC.
4. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
5. FLUORESCENT PENETRANT INSPECTION PER ASTM E 1417, TYPE 1, SENSITIVITY LEVEL 2, PRIOR TO PRETREATMENT OR COATING. ACCEPTANCE CRITERIA PER AS3071.
6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 µin Ra.
7. DIMENSIONING AND TOLERANCING: ANSI Y14.5-1982 (ASME PUBLICATION).