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REV.
B

AS3121™

FEDERAL SUPPLY CLASS
5315

RATIONALE

REVISE ØE FOR AS3121-07 AND -57 IN TABLE 1C FROM .0313 TO .0417, ADD NEW NOTE FOR DISPOSITION OF EXISTING INVENTORY, AND MINOR EDITORIAL CHANGES.

AS3121B HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

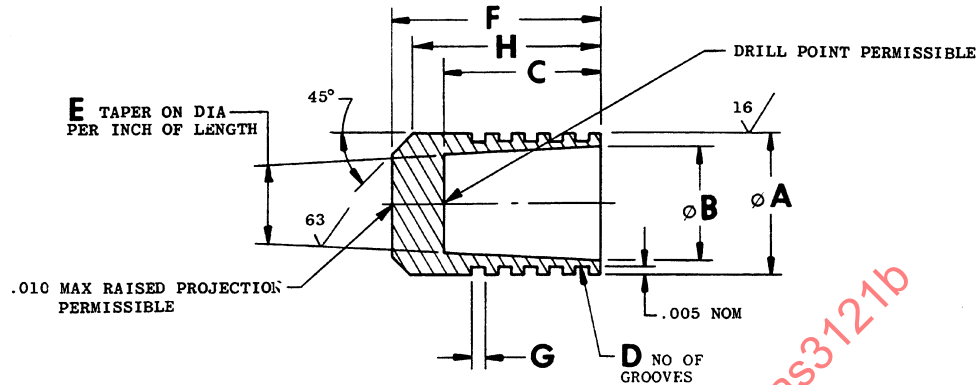


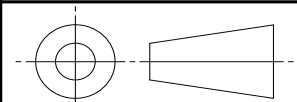
FIGURE 1 - PLUG

TABLE 1A - PART NUMBERS AND DIMENSIONS

STANDARD DIAMETER			
AEROSPACE STANDARD PART NUMBER /7/	MANUFACTURER'S PART NUMBER /7/	ØA	APPROX MASS LB/100
AS3121-03	PLGA1567010A	.1553-.1562	.025
AS3121-04	PLGA1877010A	.1866-.1875	.036
AS3121-05	PLGA2187010A	.2178-.2187	.050
AS3121-06	PLGA2507010A	.2491-.2500	.080
AS3121-07	PLGA2817010A	.2803-.2812	.085
AS3121-08	PLGA3437010A	.3428-.3437	.182
AS3121-09	PLGA4067010A	.4053-.4062	.257
AS3121-10	PLGA4687010A	.4678-.4687	.346
AS3121-11	PLGA5317010A	.5303-.5312	.449
AS3121-12	PLGA6567010A	.6553-.6562	.720

For more information on this standard, visit
<https://www.sae.org/standards/content/AS3121B/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

PLUG, EXPANSION, ALUMINUM, 2024-T4 AND
2024-T351, LONG; STD AND .010 OVERSIZE DIAMETERS
(UNS A92024)

AS3121™
SHEET 1 OF 3

REV.
B

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ISSUED 1981-02 REVISED 2019-03 REAFFIRMED 2024-04

TABLE 1B - PART NUMBERS AND DIMENSIONS

.010 OVERSIZE DIAMETER			
AEROSPACE STANDARD PART NUMBER /7/	MANUFACTURER'S PART NUMBER /7/	ØA	APPROX MASS LB/100
AS3121-53	PLGA1667010A	.1653 - .1662	.031
AS3121-54	PLGA1977010A	.1966 - .1975	.042
AS3121-55	PLGA2287010A	.2278 - .2287	.060
AS3121-56	PLGA2607010A	.2591 - .2600	.092
AS3121-57	PLGA2917010A	.2903 - .2912	.103
AS3121-58	PLGA3537010A	.3528 - .3537	.205
AS3121-59	PLGA4167010A	.4153 - .4162	.287
AS3121-60	PLGA4787010A	.4778 - .4787	.387
AS3121-61	PLGA5417010A	.5403 - .5412	.504
AS3121-62	PLGA6667010A	.6653 - .6662	.793

TABLE 1C - PART NUMBERS AND DIMENSIONS

AEROSPACE STANDARD PART NUMBER /7/	ØB NOM	C NOM	D	ØE NOM	F	G NOM	H
AS3121-03 & 53	.114	.187	8	.0417	.238 - .252	.010	.198 - .232
AS3121-04 & 54	.146	.205	8	.0417	.253 - .267	.010	.227 - .243
AS3121-05 & 55	.178	.250	8	.0417	.300 - .314	.010	.260 - .294
AS3121-06 & 56	.204	.300	8	.0417	.358 - .372	.015	.324 - .342
AS3121-07 & 57	.240	.312	8	.0417	.363 - .377	.013	.323 - .357
AS3121-08 & 58	.289	.375	8	.0208	.493 - .507	.020	.393 - .427
AS3121-09 & 59	.352	.437	9	.0208	.558 - .572	.020	.448 - .482
AS3121-10 & 60	.414	.500	10	.0208	.613 - .627	.020	.513 - .547
AS3121-11 & 61	.477	.562	12	.0156	.673 - .687	.020	.573 - .607
AS3121-12 & 62	.595	.625	14	.0156	.743 - .757	.020	.645 - .675

NOTES:

- MATERIAL: AMS4120 SIMILAR TO UNS A92024 (AL ALLOY 2024-T4; SIZES 03 THROUGH 08 AND 53 THROUGH 58, AND AL ALLOY 2024-T351; SIZES 09 THROUGH 12 AND 59 THROUGH 62), OR AMS-QQ-A-225/6 UNS A92024 (AL ALLOY 2024-T4; SIZES 03 THROUGH 08 AND 53 THROUGH 58, AND AL ALLOY 2024-T351; SIZES 09 THROUGH 12 AND 59 THROUGH 62).
 - FINISH: ANODIZE PER MIL-A-8625 TYPE IIB, CLASS 2. STANDARD PLUGS ARE DYED GREEN; .010 OVERSIZE PLUGS ARE DYED RED.
 - GROOVE BURRS PERMITTED ON OD OF PLUG TO .001 OVER MAX ØA.
 - SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.
 - BREAK EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
 - DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: ANGULAR DIMENSIONS $\pm 2^\circ$. DIMENSIONS APPLY AFTER FINISH.
- /7/ MARK AS3121-() PART NUMBER AND MANUFACTURER'S PART NUMBER ON PACKAGE IN ACCORDANCE WITH AS478, METHOD 37.
8. USE WITH AS3122 PINS. REFER TO AIR3276 HOLE PREPARATION AND AIR3277 FOR INSTALLATION PROCEDURES.

	AEROSPACE STANDARD		AS3121™ SHEET 2 OF 3	REV. B
	PLUG, EXPANSION, ALUMINUM, 2024-T4 AND 2024-T351, LONG; STD AND .010 OVERSIZE DIAMETERS (UNS A92024)			