

REV.  
B

AS3127

FEDERAL SUPPLY CLASS  
5315

# RATIONALE

THIS IS A LIMITED SCOPE REVISION. REVISED CLEANING REQUIREMENTS (NOTE 3) FOR CONFORMANCE TO AMS2700 OR ASTM A967/A967M.

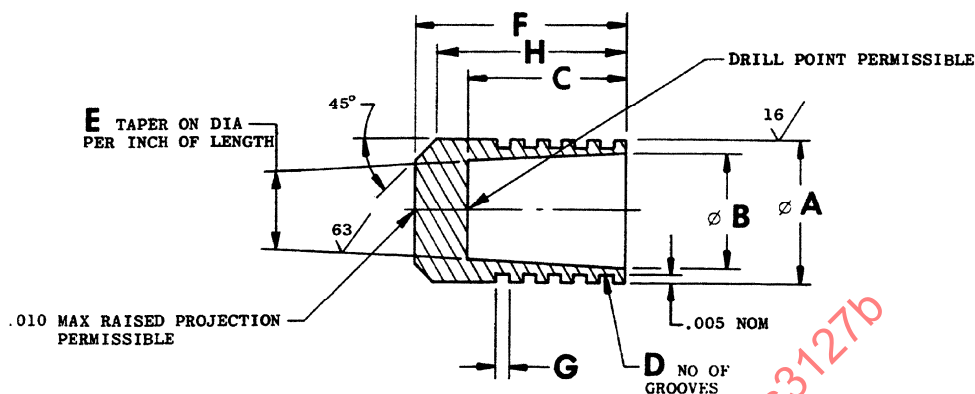


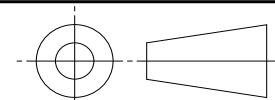
FIGURE 1

TABLE 1A – PART NUMBERS AND DIMENSIONS

| STANDARD DIAMETER                           |                                      |             |                          |
|---------------------------------------------|--------------------------------------|-------------|--------------------------|
| AEROSPACE<br>STANDARD<br>PART NUMBER<br>/8/ | MANUFACTURER'S<br>PART NUMBER<br>/8/ | ØA          | APPROX<br>MASS<br>LB/100 |
| AS3127-01                                   | PLGA0935020 A                        | .0928-.0937 | .011                     |
| AS3127-02                                   | PLGA1255020 A                        | .1241-.1250 | .022                     |
| AS3127-03                                   | PLGA1565020 A                        | .1553-.1562 | .040                     |
| AS3127-04                                   | PLGA1875020 A                        | .1866-.1875 | .056                     |
| AS3127-05                                   | PLGA2185020 A                        | .2178-.2187 | .088                     |
| AS3127-06                                   | PLGA2505020 A                        | .2491-.2500 | .129                     |
| AS3127-07                                   | PLGA2815020 A                        | .2803-.2812 | .178                     |
| AS3127-08                                   | PLGA3435020 A                        | .3428-.3437 | .289                     |
| AS3127-09                                   | PLGA4065020 A                        | .4053-.4062 | .462                     |
| AS3127-10                                   | PLGA4685020 A                        | .4678-.4687 | .568                     |
| AS3127-11                                   | PLGA5315020 A                        | .5303-.5312 | .986                     |
| AS3127-12                                   | PLGA6565020 A                        | .6553-.6562 | 1.675                    |

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THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



## AEROSPACE STANDARD

PLUG, EXPANSION - CRES, 416 OR 416SE, SHORT;  
STD AND .010 OVERSIZE DIAMETERS,  
UNS S41600/UNS S41623

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TABLE 1B – PART NUMBERS AND DIMENSIONS

| .010 OVERSIZE DIAMETER                      |                                      |             |                          |
|---------------------------------------------|--------------------------------------|-------------|--------------------------|
| AEROSPACE<br>STANDARD<br>PART NUMBER<br>/8/ | MANUFACTURER'S<br>PART NUMBER<br>/8/ | ØA          | APPROX<br>MASS<br>LB/100 |
| AS3127-51                                   | PLGA1035020A                         | .1028-.1037 | .013                     |
| AS3127-52                                   | PLGA1355020 A                        | .1341-.1350 | .029                     |
| AS3127-53                                   | PLGA1665020 A                        | .1653-.1662 | .047                     |
| AS3127-54                                   | PLGA1975020 A                        | .1966-.1975 | .068                     |
| AS3127-55                                   | PLGA2285020 A                        | .2278-.2287 | .108                     |
| AS3127-56                                   | PLGA2605020 A                        | .2591-.2600 | .150                     |
| AS3127-57                                   | PLGA2915020 A                        | .2903-.2912 | .203                     |
| AS3127-58                                   | PLGA3535020 A                        | .3528-.3537 | .329                     |
| AS3127-59                                   | PLGA4165020 A                        | .4153-.4162 | .527                     |
| AS3127-60                                   | PLGA4785020 A                        | .4778-.4787 | .645                     |
| AS3127-61                                   | PLGA5415020 A                        | .5403-.5412 | 1.080                    |
| AS3127-62                                   | PLGA6665020 A                        | .6653-.6662 | 1.863                    |

TABLE 1C – PART NUMBERS AND DIMENSIONS

| AEROSPACE<br>STANDARD<br>PART NUMBER<br>/8/ | ØB<br>NOM | C<br>NOM | D  | ØE<br>NOM | F         | G<br>NOM | H         |
|---------------------------------------------|-----------|----------|----|-----------|-----------|----------|-----------|
| AS3127-01 & 51                              | .062      | .069     | 3  | .0417     | .093-.102 | .010     | .070-.085 |
| AS3127-02 & 52                              | .088      | .104     | 4  | .0417     | .123-.132 | .010     | .100-.115 |
| AS3127-03 & 53                              | .110      | .090     | 4  | .0417     | .118-.132 | .010     | .100-.120 |
| AS3127-04 & 54                              | .146      | .128     | 4  | .0417     | .154-.166 | .010     | .128-.142 |
| AS3127-05 & 55                              | .173      | .157     | 5  | .0417     | .180-.194 | .010     | .157-.177 |
| AS3127-06 & 56                              | .204      | .183     | 4  | .0417     | .218-.232 | .015     | .184-.202 |
| AS3127-07 & 57                              | .240      | .205     | 5  | .0313     | .248-.262 | .010     | .220-.240 |
| AS3127-08 & 58                              | .300      | .242     | 5  | .0208     | .300-.314 | .020     | .262-.282 |
| AS3127-09 & 59                              | .358      | .279     | 12 | .0208     | .358-.372 | .010     | .295-.315 |
| AS3127-10 & 60                              | .428      | .305     | 6  | .0208     | .383-.397 | .020     | .320-.340 |
| AS3127-11 & 61                              | .486      | .410     | 8  | .0156     | .513-.527 | .020     | .445-.475 |
| AS3127-12 & 62                              | .592      | .425     | 9  | .0182     | .543-.557 | .020     | .460-.480 |

## NOTES:

1. MATERIAL: AMS5610 (416 OR 416SE CRES BAR), UNS S41600 OR UNS S41623.
2. HEAT TREAT: ROCKWELL 20-34 HRC PER ASTM E140.
3. CLEANING: FINISHED PARTS SHALL BE DEGREASED AND PASSIVATED PER ASTM A967/A967M OR AMS2700. A SOLUTION CONTAINING SODIUM DICHROMATE AND NOT LESS THAN 20% BY VOLUME OF NITRIC ACID MUST BE USED. A CITRIC ACID METHOD MAY BE USED AS AN ALTERNATIVE IF REQUESTED BY THE PROCURING ACTIVITY AND THE SUPPLIER AGREES.
4. GROOVE BURRS PERMITTED ON OD OF PLUG TO .001 OVER MAX Ø A.
5. SURFACE TEXTURE: SYMBOLS PER AMSE Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.
6. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

|                                                                                     |                                                                                                           |                               |                         |
|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|-------------------------------|-------------------------|
|  | <b>AEROSPACE STANDARD</b>                                                                                 | <b>AS3127</b><br>SHEET 2 OF 3 | <b>REV.</b><br><b>B</b> |
|                                                                                     | PLUG, EXPANSION - CRES, 416 OR 416SE, SHORT;<br>STD AND .010 OVERSIZE DIAMETERS,<br>UNS S41600/UNS S41623 |                               |                         |