

REV.  
C

SAE AS3247

FEDERAL SUPPLY CLASS  
5306

# RATIONALE

REVISE WRENCHING ELEMENT RUNOUT CALLOUT (RELOCATE FROM WRENCH FLATS TO POINTS). REVISE THREAD SPECIFICATION TO AS8879. REVISE LIGHTENING HOLE CONFIGURATION (ADD SECTION VIEW) TO ALLOW OPTIONAL SHAPE AT BOTTOM OF HOLE, ADD SYMBOL FOR Ø AND MMC TO POSITION TOLERANCE FOR SAFETY WIRE HOLES, DELETE .015 MIN RADIUS AT BASE OF WRENCH PAD, AND FIGURE 1 REDRAWN.

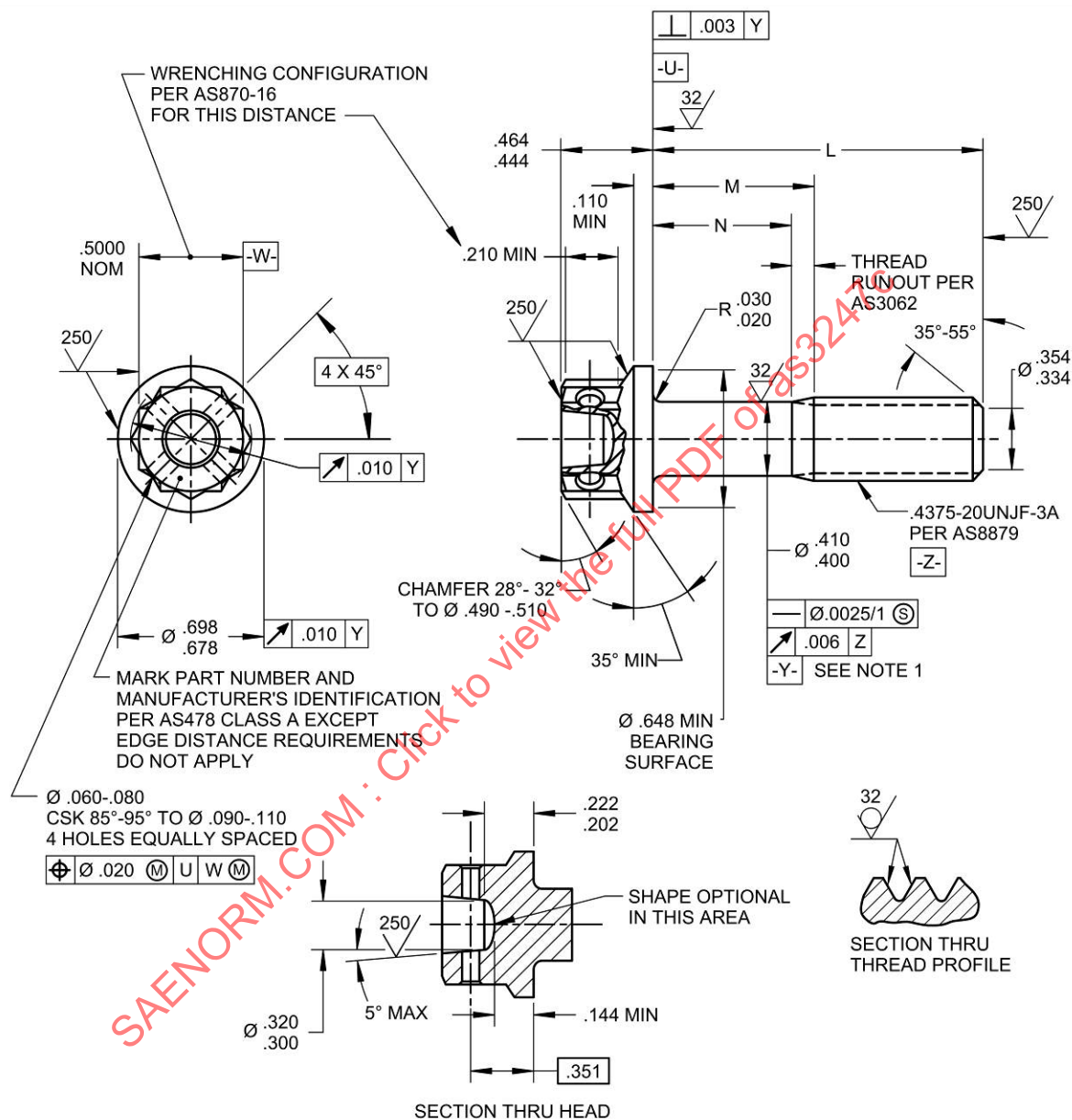
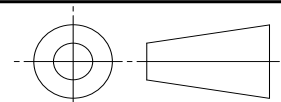


FIGURE 1 - BOLT

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3247C>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS7466

**SAE Aerospace**  
An SAE International Group

## AEROSPACE STANDARD

(R) BOLT, MACHINE - DOUBLE HEXAGON EXTENDED WASHER HEAD, DRILLED, PD SHANK, NICKEL ALLOY, UNS N07718, 185 KSI MIN, .4375-20 UNJF-3A

**SAE AS3247**  
SHEET 1 OF 3

REV.  
C

TABLE 1 - PART NUMBERS AND DIMENSIONS

| PART NO.  | L           | N<br>MIN | M<br>MAX | APPROX.<br>MASS<br>LB/100 | PART NO.  | L           | N<br>MIN | M<br>MAX | APPROX.<br>MASS<br>LB/100 |
|-----------|-------------|----------|----------|---------------------------|-----------|-------------|----------|----------|---------------------------|
| AS3247-04 | .678- .698  | .030     | .125     | 5.21                      | AS3247-31 | 2.740-2.760 | 1.465    | 1.625    | 13.13                     |
| AS3247-05 | .740- .760  | .030     | .125     | 5.46                      | AS3247-32 | 2.865-2.885 | 1.590    | 1.750    | 13.61                     |
| AS3247-06 | .802- .822  | .030     | .125     | 5.70                      | AS3247-33 | 2.990-3.010 | 1.715    | 1.875    | 14.09                     |
| AS3247-07 | .865- .885  | .030     | .125     | 5.94                      | AS3247-34 | 3.115-3.135 | 1.840    | 2.000    | 14.57                     |
| AS3247-08 | .928- .948  | .030     | .125     | 6.18                      | AS3247-35 | 3.240-3.260 | 1.965    | 2.125    | 15.05                     |
| AS3247-09 | .990-1.010  | .030     | .125     | 6.42                      | AS3247-36 | 3.365-3.385 | 2.090    | 2.250    | 15.53                     |
| AS3247-10 | 1.052-1.072 | .030     | .125     | 6.65                      | AS3247-37 | 3.490-3.510 | 2.215    | 2.375    | 16.01                     |
| AS3247-11 | 1.115-1.135 | .030     | .125     | 6.89                      | AS3247-38 | 3.615-3.635 | 2.340    | 2.500    | 16.48                     |
| AS3247-12 | 1.178-1.198 | .030     | .125     | 7.13                      | AS3247-39 | 3.740-3.760 | 2.465    | 2.625    | 16.97                     |
| AS3247-13 | 1.240-1.260 | .030     | .125     | 7.37                      | AS3247-40 | 3.865-3.885 | 2.590    | 2.750    | 17.45                     |
| AS3247-14 | 1.302-1.322 | .030     | .188     | 7.62                      | AS3247-41 | 3.990-4.010 | 2.715    | 2.875    | 17.93                     |
| AS3247-15 | 1.365-1.385 | .090     | .250     | 7.86                      | AS3247-42 | 4.115-4.135 | 2.840    | 3.000    | 18.40                     |
| AS3247-16 | 1.428-1.448 | .153     | .312     | 8.10                      | AS3247-43 | 4.240-4.260 | 2.965    | 3.125    | 18.89                     |
| AS3247-17 | 1.490-1.510 | .215     | .375     | 8.34                      | AS3247-44 | 4.365-4.385 | 3.090    | 3.250    | 19.37                     |
| AS3247-18 | 1.552-1.572 | .277     | .438     | 8.57                      | AS3247-45 | 4.490-4.510 | 3.215    | 3.375    | 19.85                     |
| AS3247-19 | 1.615-1.635 | .340     | .500     | 8.81                      | AS3247-46 | 4.615-4.635 | 3.340    | 3.500    | 20.32                     |
| AS3247-20 | 1.678-1.698 | .403     | .562     | 9.05                      | AS3247-47 | 4.740-4.760 | 3.465    | 3.625    | 20.80                     |
| AS3247-21 | 1.740-1.760 | .465     | .625     | 9.27                      | AS3247-48 | 4.865-4.885 | 3.590    | 3.750    | 21.89                     |
| AS3247-22 | 1.802-1.822 | .527     | .688     | 9.53                      | AS3247-49 | 4.990-5.010 | 3.715    | 3.875    | 21.77                     |
| AS3247-23 | 1.865-1.885 | .590     | .750     | 9.77                      | AS3247-50 | 5.115-5.135 | 3.840    | 4.000    | 22.24                     |
| AS3247-24 | 1.928-1.948 | .653     | .812     | 10.02                     | AS3247-51 | 5.240-5.260 | 3.965    | 4.125    | 22.72                     |
| AS3247-25 | 1.990-2.010 | .715     | .875     | 10.26                     | AS3247-52 | 5.365-5.385 | 4.090    | 4.250    | 23.21                     |
| AS3247-26 | 2.115-2.135 | .840     | 1.000    | 10.73                     | AS3247-53 | 5.490-5.510 | 4.215    | 4.375    | 23.69                     |
| AS3247-27 | 2.240-2.260 | .965     | 1.125    | 11.21                     | AS3247-54 | 5.615-5.635 | 4.340    | 4.500    | 24.18                     |
| AS3247-28 | 2.365-2.385 | 1.090    | 1.250    | 11.69                     | AS3247-55 | 5.740-5.760 | 4.465    | 4.625    | 24.67                     |
| AS3247-29 | 2.490-2.510 | 1.215    | 1.375    | 12.18                     | AS3247-56 | 5.865-5.885 | 4.590    | 4.750    | 25.16                     |
| AS3247-30 | 2.615-2.635 | 1.340    | 1.500    | 12.65                     | AS3247-57 | 5.990-6.010 | 4.715    | 4.875    | 25.64                     |

## NOTES:

- FOR PART NUMBERS AS3247-04 THRU AS3247-24 THE THREAD PD (DATUM **Z** ) SHALL REPLACE DATUM **Y** .
- MATERIAL: CORROSION AND HEAT RESISTANT NICKEL ALLOY PER AMS5662 (UNS N07718).
- PROCUREMENT SPECIFICATION: AS7466.
- FLUORESCENT PENETRANT INSPECTION PER ASTM E1417/E1417M, TYPE 1, SENSITIVITY LEVEL 2.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
- BREAK SHARP EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES.
- DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982 (ASME PUBLICATION).
- DO NOT USE UNASSIGNED PART NUMBERS.

|                                                                                                                   |                                                                                                                                           |                                   |                         |
|-------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|-------------------------|
| <br>An SAE International Group | <b>AEROSPACE STANDARD</b>                                                                                                                 | <b>SAE AS3247</b><br>SHEET 2 OF 3 | <b>REV.</b><br><b>C</b> |
|                                                                                                                   | (R) BOLT, MACHINE - DOUBLE HEXAGON EXTENDED<br>WASHER HEAD, DRILLED, PD SHANK, NICKEL ALLOY,<br>UNS N07718, 185 KSI MIN, .4375-20 UNJF-3A |                                   |                         |