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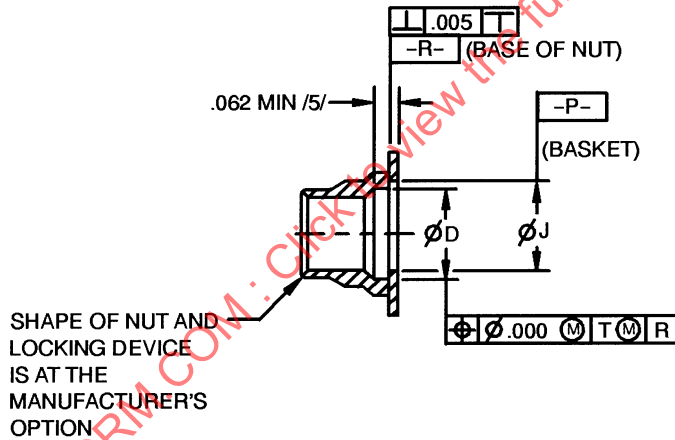
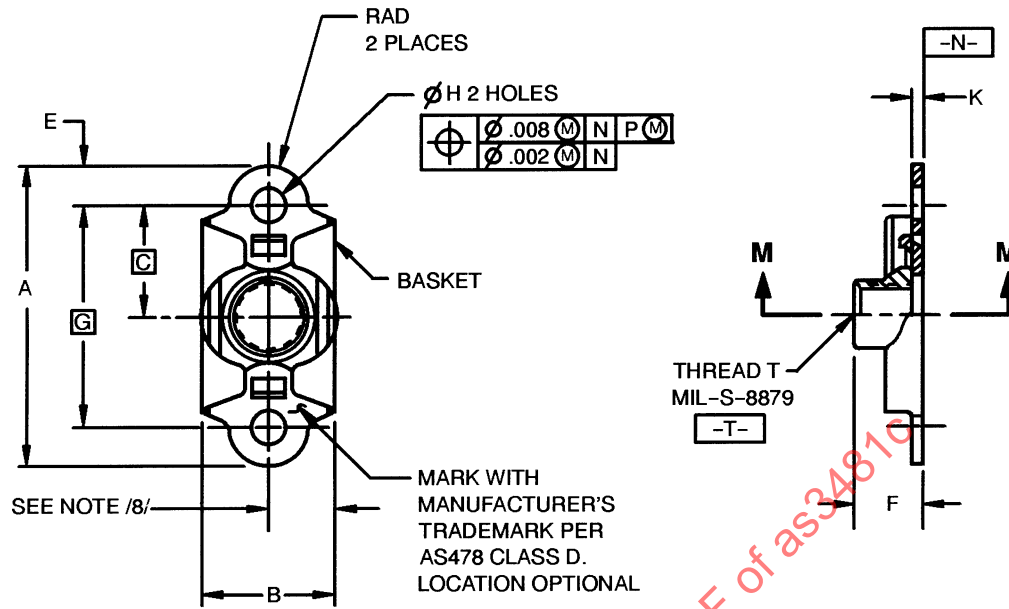
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AS3481

Submitted for recognition as an American National Standard

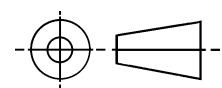
FEDERAL SUPPLY CLASS
5310



SECTION M-M

FIGURE 1

THIRD ANGLE PROJECTION



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

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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING,
REDUCED RIVET SPACING, LOW HEIGHT,
UNS S66286 CLASS: 125 ksi/800 °F

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TABLE 1A

PART NUMBER AS3481	T THREAD	A MAX	B	C BASIC	øD CBORE MIN	E MIN	F MAX
-01	.1380-32UNJC-3B	.682	.290-.357	.218	--	.070	.171
-02	.1640-32UNJC-3B	.707	.290-.367	.234	.168	.100	.250
-03	.1900-32UNJF-3B	.739	.290-.416	.250	.194	.100	.250
-04	.2500-28UNJF-3B	.801	.350-.500	.281	.254	.100	.281
-05	.3125-24UNJF-3B	1.010	.412-.581	.359	.317	.117	.328

TABLE 1B

PART NUMBER AS3481	G BASIC	øH +.005 -.000	øJ	K	AXIAL STRENGTH LBF MIN	APPROX MASS LB/100
-01	.437	.098	.178-.270	.020-.090	1130	.32
-02	.468	.098	.204-.270	.025-.090	1720	.36
-03	.500	.098	.230-.270	.025-.090	2460	.39
-04	.562	.098	.290-.330	.027-.090	4580	.69
-05	.718	.130	.352-.392	.032-.105	7390	1.10

NOTES:

1. MATERIAL:

- a. NUT: CORROSION AND HEAT RESISTANT STEEL AMS 5525, AMS 5731, OR AMS 5734.
- b. BASKET: CORROSION AND HEAT RESISTANT STEEL AMS 5525.

2. HEAT TREATMENT: AFTER FORMING, PLATE NUTS SHALL BE PRECIPITATION HEAT TREATED TO A HARDNESS NOT TO EXCEED THAT SPECIFIED IN NOTE 6.

3. FINISH:

- a. NUT: SILVER PLATE PER AMS 2411; SILVER PLATE ONLY ON THREADS, EXCEPT:

1. SIZE -01 MAY HAVE OPTIONAL COVERAGE ON COUNTERSINK.
2. SIZE -02 THROUGH -05 MAY HAVE OPTIONAL COVERAGE IN COUNTERBORE TO .030 MAXIMUM DEPTH.

DIMENSIONS APPLY AFTER PLATING.

- b. BASKET: PASSIVATE PER QQ-P-35, TYPE II OR VIII.

4. PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS FOLLOWS:

- a. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F ± 15 °F FOR NUTS TESTED AFTER BAKE.
- b. AXIAL STRENGTH LOAD IS PER MIL-N-25027. SEE SHEET 2, TABLE 1.

/5/ SIZE -01 MAY BE COUNTERSUNK OR RADIUSSED WITHIN øJ. SIZE -02 AND LARGER SHALL BE COUNTERBORED TO øD TO .062 MINIMUM DEPTH .

6. HARDNESS: 44 HRC MAXIMUM.

7. RADIAL FLOAT OF NUT THREADS RELATIVE TO BASKET øJ, .020 MINIMUM.

/8/ øJ TO BE CENTERED ON WIDTH B WITHIN ±.010.

9. REMOVE BURRS AND SHARP EDGES.

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