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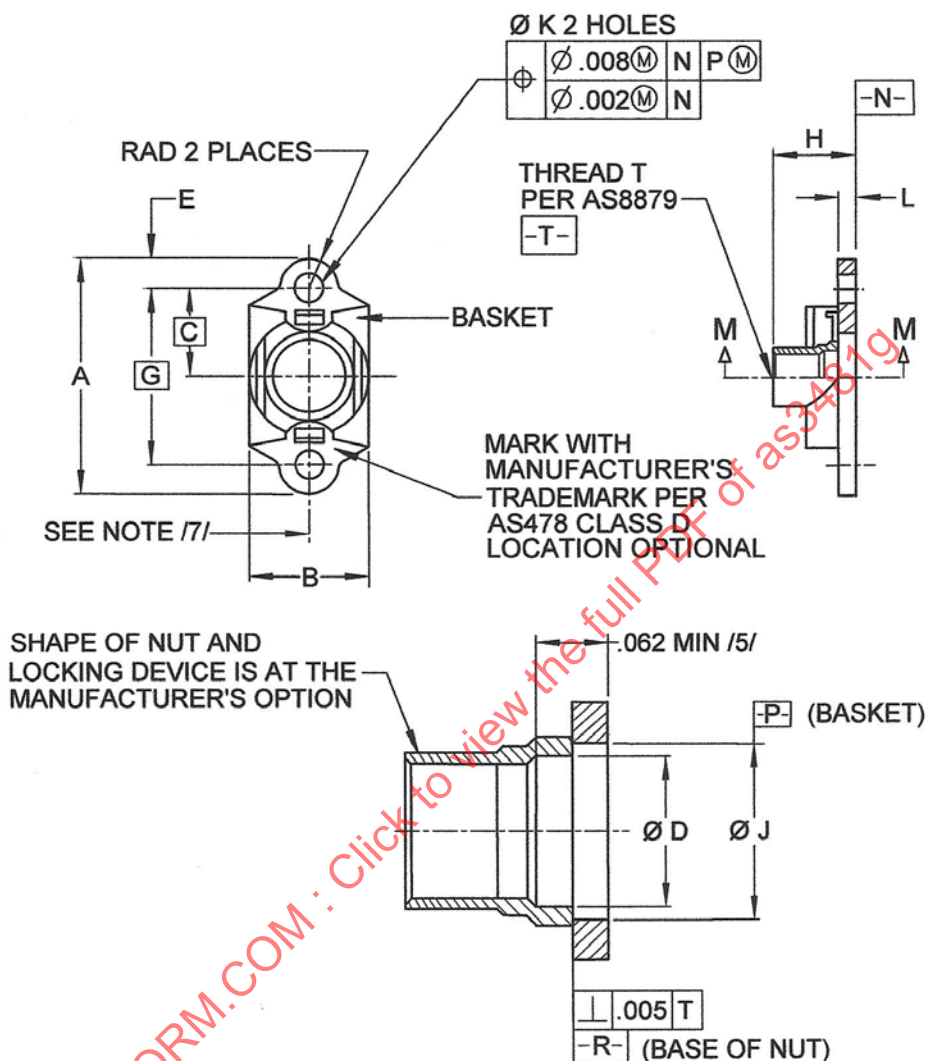
REV.
G

AS3481™

FEDERAL SUPPLY CLASS
5310

RATIONALE

SILVER PLATING SPEC CORRECTED TO SHOW AS2411.

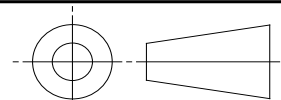


SECTION M - M

FIGURE 1

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3481G>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS4393



AEROSPACE STANDARD

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

AS3481™
SHEET 1 OF 3

REV.
G

TABLE 1 - DIMENSIONS T TO H

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

TABLE 1 - DIMENSIONS G TO MASS

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

NOTES:

1. MATERIAL:

- a. NUT: CORROSION AND HEAT RESISTANT STEEL AMS5525, AMS5731, OR AMS5734.
- b. BASKET: CORROSION AND HEAT RESISTANT STEEL AMS5525.

2. HEAT TREATMENT: AFTER FORMING, PLATE NUTS SHALL BE PRECIPITATION HEAT TREATED TO A HARDNESS NOT TO EXCEED THAT SPECIFIED IN NOTE 4b.

3. FINISH:

- a. NUT: SILVER PLATE PER AS2411; 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 AMS2700 TYPE 2 OR 8.

4. PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS NOTED:

- a. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F ± 15 °F FOR NUTS TESTED AFTER BAKE.
- b. HARDNESS: 44 HRC MAXIMUM

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

6. RADIAL FLOAT OF NUT THREADS RELATIVE TO BASKET ØJ, .020 MINIMUM.

/7/ ØJ TO BE CENTERED ON WIDTH B WITHIN ±.010.

8. REMOVE BURRS AND SHARP EDGES.

9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.

10. DIMENSIONING AND TOLERANCING: ANSI Y14.5M-1982 (ASME PUBLICATION)

	AEROSPACE STANDARD	AS3481™ SHEET 2 OF 3	REV. G
	NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING, REDUCED RIVET SPACING, LOW HEIGHT, UNS S66286, CLASS: 125 KSI/800 °F		