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REV.
K

AS3481™

FEDERAL SUPPLY CLASS
5310

RATIONALE

LIMITED SCOPE REVISION. CHANGE SILVER PLATING SPEC FROM AS2411 TO AMS2411.

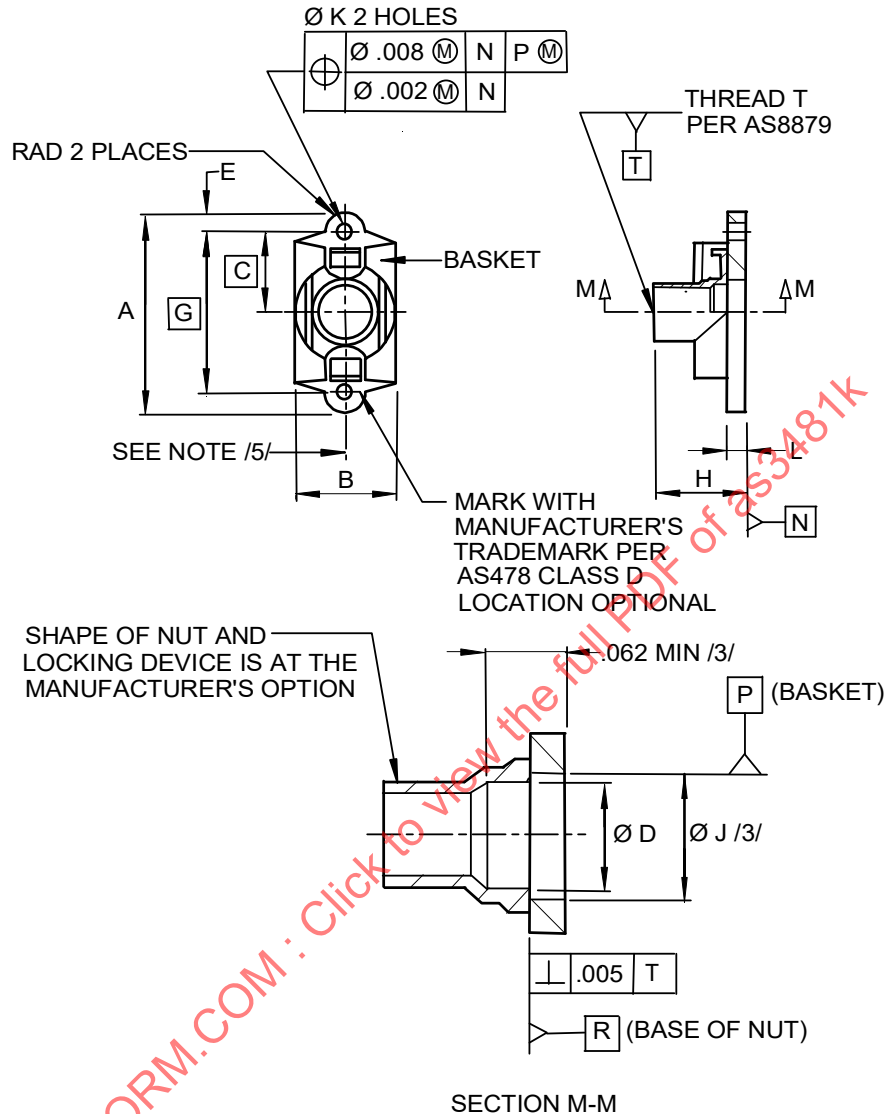
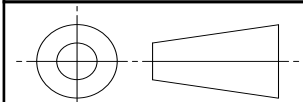


FIGURE 1

For more information on this standard, visit
<https://www.sae.org/standards/content/AS3481K/>

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

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TABLE 1A - 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 1B - DIMENSIONS G TO MASS

PART NUMBER	G BASIC	ØK +.005 -.000	ØJ /3/ /5/	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 (COMPOSITION SIMILAR TO UNS S66286).

/2/ PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS NOTED:

- a. HEAT TREATMENT: AFTER FORMING, PLATE NUTS SHALL BE PRECIPITATION HEAT TREATED TO A HARDNESS NOT TO EXCEED THAT SPECIFIED IN NOTE 2d.
- b. NUT: SILVER PLATE PER AMS2411; SILVER PLATE ONLY ON THREADS, EXCEPT:
 SIZE -01 MAY HAVE OPTIONAL COVERAGE ON COUNTERSINK.
 SIZE -02 THROUGH -05 MAY HAVE OPTIONAL COVERAGE IN COUNTERBORE TO .030 MAXIMUM DEPTH.
 DIMENSIONS APPLY AFTER PLATING.
 BASKET: PASSIVATE PER AMS2700 TYPE 2 OR 8.
- c. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F ± 15 °F FOR NUTS TESTED AFTER BAKE.
- d. HARDNESS: 44 HRC MAXIMUM
- e. COMPLETELY RECRYSTALLIZED MICROSTRUCTURE IS NOT REQUIRED.

/3/ SIZE -01 MAY BE COUNTERSUNK OR RADIUSSED WITHIN ØJ. SIZE -02 AND LARGER SHALL BE COUNTERBORED TO ØD TO .062 MINIMUM DEPTH.

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

/5/ ØJ TO BE CENTERED ON WIDTH B WITHIN ±.010.

6. REMOVE BURRS AND SHARP EDGES.

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

8. DIMENSIONING AND TOLERANCING: ASME Y14.5-2018.

9. DIMENSIONS ARE IN INCHES.

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