

REV.  
C

AS3486

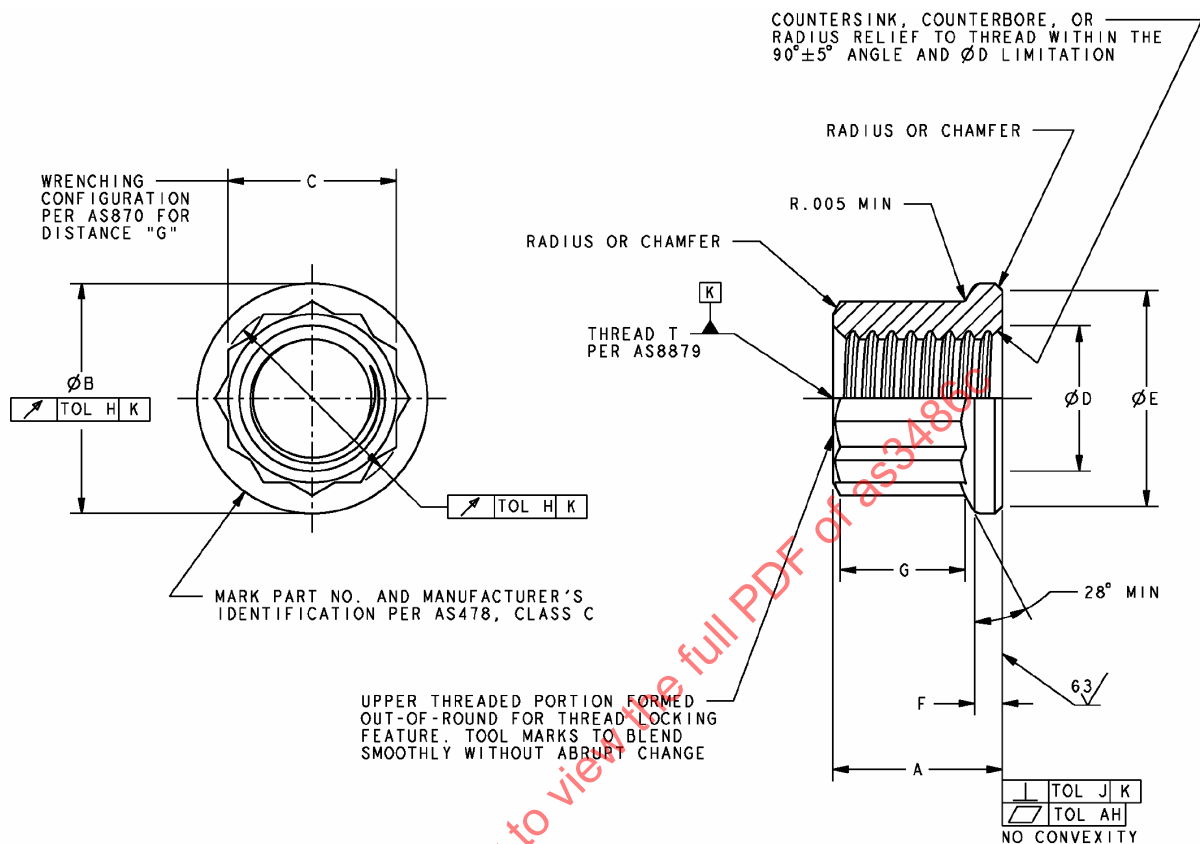
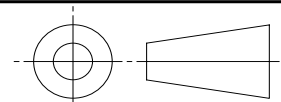
FEDERAL SUPPLY CLASS  
5310

FIGURE 1

THIRD ANGLE PROJECTION



CUSTODIAN: SAE E-25

**SAE Aerospace**  
 An SAE International Group
**AEROSPACE STANDARD**
 NUT, SELF-LOCKING, EXTENDED DOUBLE  
 HEXAGON, REDUCED FLANGE, DRY FILM LUBE,  
 UNS S66286, CLASS: 160 KSI/800 °F

**AS3486**  
 SHEET 1 OF 3

**REV.**  
**C**

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ISSUED 1992-04 REVISED 2004-07

TABLE 1A

| PART<br>NUMBER | T<br>THREAD     | A<br>+.005/-0.010 | ØB<br>MAX | C<br>NOM | DASH<br>NO. | ØD<br>MAX |
|----------------|-----------------|-------------------|-----------|----------|-------------|-----------|
| AS3486-09      | .1900-32UNJF-3B | .245              | .340      | .2500    | 08          | .220      |
| AS3486-10      | .2500-28UNJF-3B | .317              | .430      | .3125    | 10          | .280      |
| AS3486-11      | .3125-24UNJF-3B | .355              | .515      | .3750    | 12          | .345      |
| AS3486-12      | .3750-24UNJF-3B | .453              | .586      | .4375    | 14          | .405      |

TABLE 1B

| PART<br>NUMBER | ØE<br>MIN | F         | G<br>MIN | H    | J    | AH    | APPROX<br>MASS<br>LB/100 |
|----------------|-----------|-----------|----------|------|------|-------|--------------------------|
| AS3486-09      | .310      | .035-.057 | .125     | .006 | .004 | .0014 | .20                      |
| AS3486-10      | .400      | .045-.057 | .185     | .007 | .005 | .0014 | .40                      |
| AS3486-11      | .485      | .055-.068 | .195     | .008 | .005 | .0016 | .70                      |
| AS3486-12      | .558      | .075-.100 | .250     | .009 | .005 | .0016 | 1.00                     |

## NOTES:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL PER AMS 5731 OR AMS 5734 (UNS S66286).  
HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE PRECIPITATION HEAT TREATED PER AMS 2759/3 TO MEET THE HARDNESS SPECIFIED IN NOTE 3.
2. PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS FOLLOWS:
  - a. COATING: SOLID FILM LUBRICANT PER AS1701, TYPE VI, IN LIEU OF SILVER PLATE PER AMS 2411.
  - b. PRETREATMENT: PRIOR TO APPLYING THE SOLID FILM LUBRICANT, NUTS MAY BE PLATED WITH COPPER (AMS 2418) OR NICKEL (AMS 2403) TO .0001 MAXIMUM THICKNESS.
  - c. DIMENSIONS APPLY AFTER PRETREATMENT PLATING AND BEFORE COATING WITH SOLID FILM LUBRICANT.
  - d. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F FOR NUTS TESTED AFTER BAKE.
3. HARDNESS: 37 TO 45 HRC.
4. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
5. FLUORESCENT PENETRANT INSPECTION PER ASTM E 1417, TYPE I, SENSITIVITY LEVEL 2, PRIOR TO PRETREATMENT OR COATING. ACCEPTANCE CRITERIA PER AS3071.
6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 µin Ra.
7. DIMENSIONING AND TOLERANCING: ANSI Y14.5-1982 (ASME PUBLICATION).
8. DIMENSIONS ARE IN INCHES.
9. DO NOT USE UNASSIGNED NUMBERS.