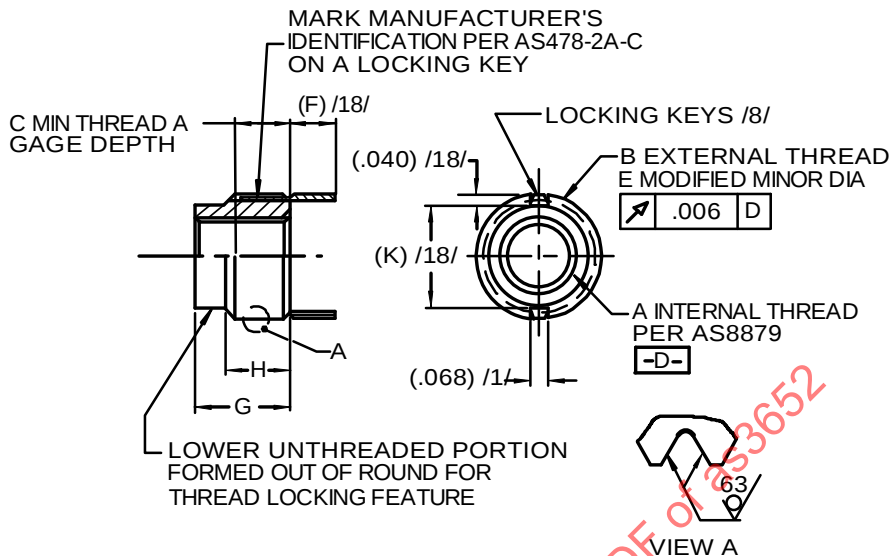


AS3652

RATIONALE

FEDERAL SUPPLY CLASS
5970

PROVIDE INDUSTRY WITH A KEY LOCKED INSERT THAT INCORPORATES A BOTTOM LOCKING FEATURE PROVIDING IMPROVED NUMBER OF BOLT INSTALLATION AND REMOVAL CYCLES. THIS INSERT IS ALSO USED FOR REPAIR OF THE STANDARD SIZE INSERT.



/18/ DIMENSION APPLIES TO LOCKING KEYS

FIGURE 1 - INSERT

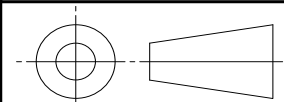
TABLE 1 - DIMENSIONS

PART NUMBER	A INTERNAL THREAD AS8879 UNJF-3B	B EXTERNAL THREAD AS8879 EXCEPT MODIFIED MINOR DIAMETER	EXTERNAL THREAD MODIFIED MINOR DIAMETER E	F REF	G	H	K REF	C MIN GAGE DEPTH	NO OF KEYS /8/
AS3652-3	.1900 - .32	.4375-14 UNJC-3A	.375 - .383	.160	.335 - .365	.230 - .260	.344	.201	2
AS3652-4	.2500 - .28	.5000-13 UNJC-3A	.432 - .440	.190	.385 - .415	.248 - .278	.407	.212	2
AS3652-5	.3125 - .24	.5625-12 UNJC-3A	.495 - .503	.190	.465 - .495	.290 - .320	.469	.245	4
AS3652-6	.3750 - .24	.6250-11 UNJC-3A	.551 - .565	.190	.525 - .555	.328 - .358	.532	.283	4
AS3652-7	.4375 - .20	.6875-12 UNJ-3A	.615 - .625	.190	.605 - .635	.380 - .410	.594	.323	4
AS3652-8	.5000 - .20	.8125-16 UNJ-3A	.744 - .752	.190	.665 - .695	.405 - .435	.720	.348	4

PART NUMBER	APPROX MASS LB/100
AS3652-3	.89
AS3652-4	1.23
AS3652-5	1.69
AS3652-6	2.24
AS3652-7	3.04
AS3652-8	5.34

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3652>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS5887



AEROSPACE STANDARD

INSERT, SCREW THREAD, SHORT, SELF-LOCKING, KEY LOCKED, STANDARD DUTY, OVERSIZE SELF-BROACHING KEYS, UNS S66286

AS3652
SHEET 1 OF 2