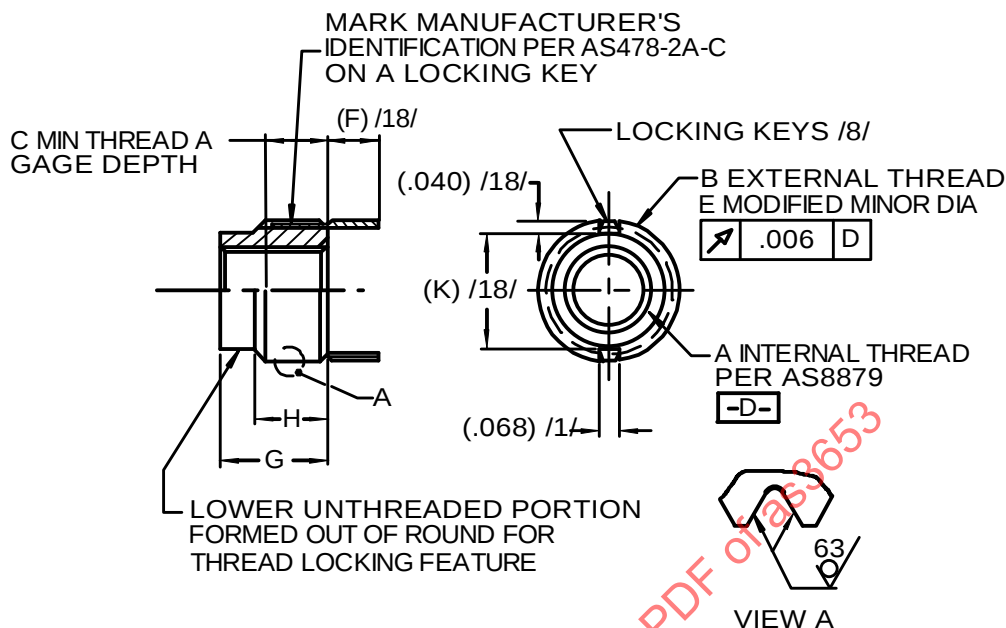


AS3653

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.



/18/ DIMENSION APPLIES TO LOCKING KEYS

FIGURE 1 - INSERT

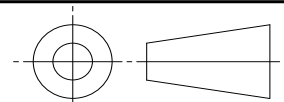
TABLE 1 - DIMENSIONS

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/
AS3653-3	.1900 - .32	.3750-16 UNJC-3A	.312 - .320	.160	.360 - .390	.265 - .285	.284	.226	2
AS3653-4	.2500 - .28	.4375-14 UNJC-3A	.375 - .383	.190	.497 - .527	.360 - .390	.344	.324	2
AS3653-5	.3125 - .24	.5000-13 UNJC-3A	.432 - .440	.190	.695 - .725	.520 - .550	.407	.475	4
AS3653-6	.3750 - .24	.5625-12 UNJC-3A	.495 - .503	.190	.784 - .814	.581 - .611	.469	.536	4
AS3653-7	.4375 - .20	.6250-11 UNJC-3A	.551 - .565	.190	.875 - .905	.650 - .680	.532	.593	4
AS3653-8	.5000 - .20	.6875-12 UNJ-3A	.615 - .625	.190	.983 - 1.013	.723 - .753	.594	.666	4

PART NUMBER	APPROX MASS LB/100
AS3653-3	.69
AS3653-4	1.29
AS3653-5	2.50
AS3653-6	3.30
AS3653-7	4.88
AS3653-8	6.63

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3653>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS5887



AEROSPACE STANDARD

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

AS3653
SHEET 1 OF 2