

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

AS3654

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.

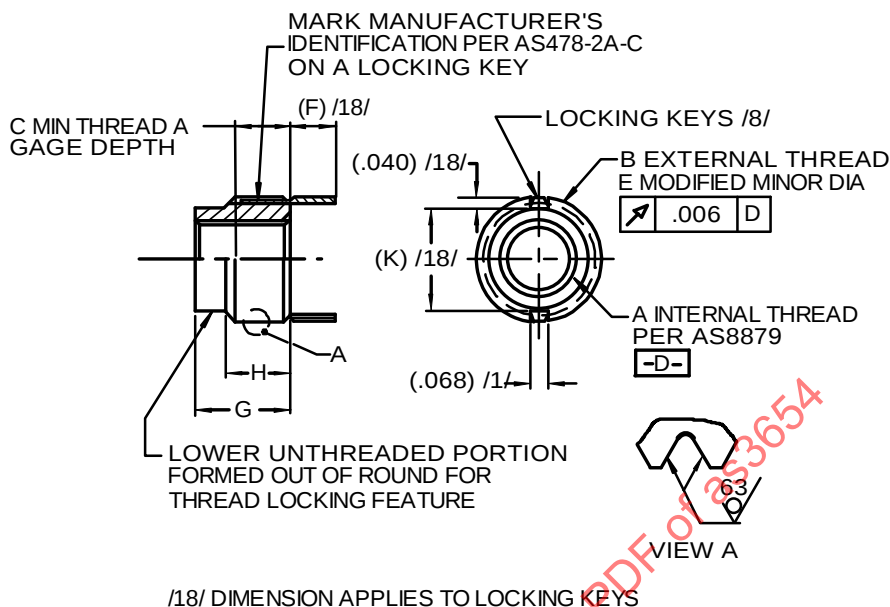


FIGURE 1 - INSERT

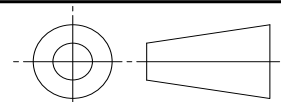
TABLE 1 - DIMENSIONS

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/
AS3654-3	.1900 - 32	.4375-14 UNJC-3A	.375 - .383	.160	.360 - .390	.256 - .285	.344	.226	2
AS3654-4	.2500 - 28	.5000-13 UNJC-3A	.432 - .440	.190	.497 - .527	.360 - .390	.407	.324	2
AS3654-5	.3125 - 24	.5625-12 UNJC-3A	.495 - .503	.190	.695 - .725	.520 - .550	.469	.475	4
AS3654-6	.3750 - 24	.6250-11 UNJC-3A	.551 - .565	.190	.784 - .814	.581 - .611	.532	.536	4
AS3654-7	.4375 - 20	.6875-12 UNJ-3A	.615 - .625	.190	.875 - .905	.620 - .680	.594	.593	4
AS3654-8	.5000 - 20	.8125-16 UNJ-3A	.744 - .752	.190	.983 - 1.093	.723 - .753	.720	.666	4

PART NUMBER	APPROX MASS LB/100
AS3654-3	.72
AS3654-4	1.12
AS3654-5	1.78
AS3654-6	2.07
AS3654-7	2.64
AS3654-8	5.28

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS3654>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS5887



AEROSPACE STANDARD

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

AS3654
SHEET 1 OF 2

Copyright 2014 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Fax: 724-776-0790

Tel: +1 724-776-4970 (outside USA)
Email: CustomerService@sae.org

SAE WEB ADDRESS: <http://www.sae.org>

ISSUED 2014-01