

REV.
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AS4660

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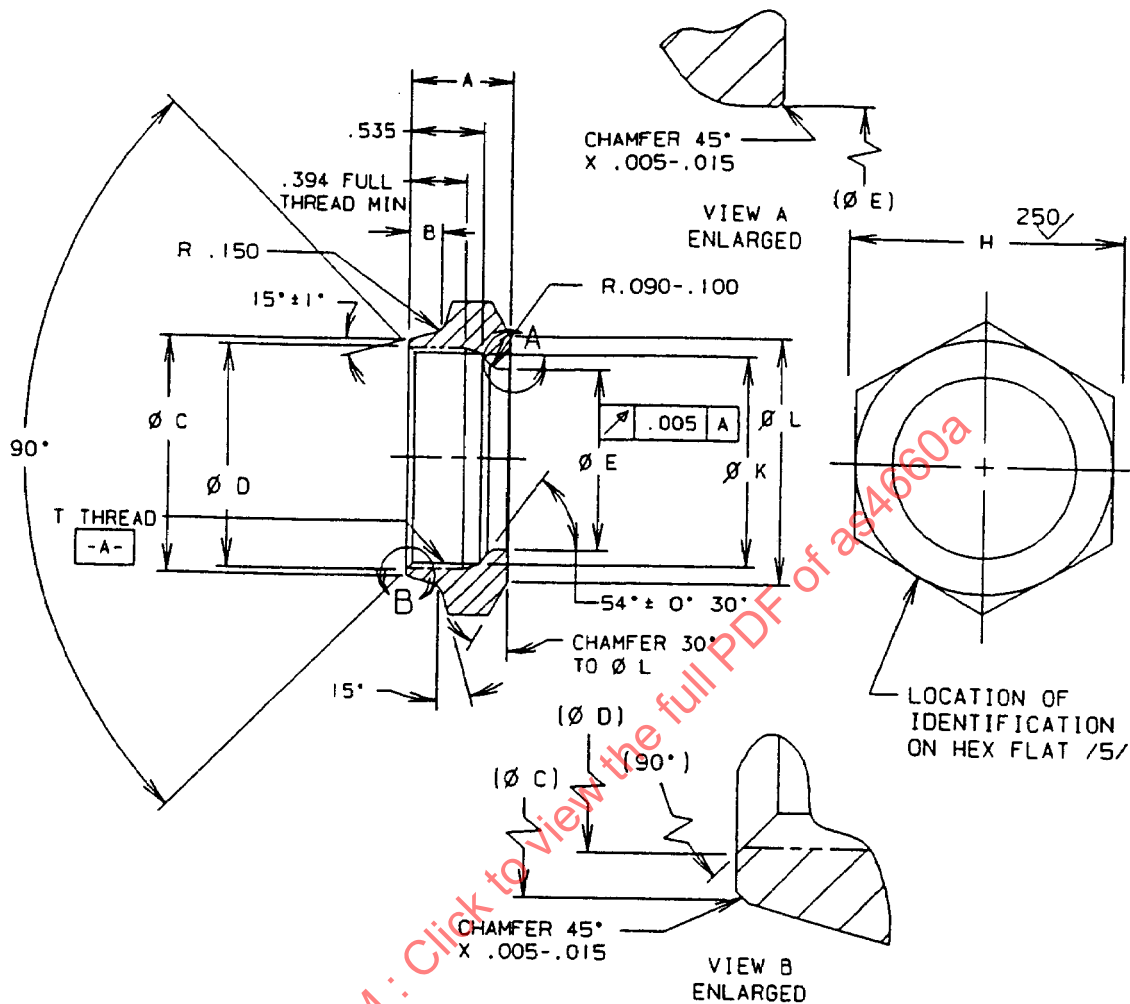
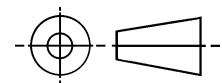


FIGURE 1 - NUT, SHORT FLARELESS

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO	AS4650	(NOMINAL	T												
/14/	TUBE	SIZE)	THREAD PER	A	B	C	D	E	H	K	L	LB/EA	LB/EA	LB/EA	
SIZE CODE			MIL-S-8879			±.005		+005/ -.000		±.0050		MAX	MAX	MAX	
20	1.250	1.5625-12 UNJ-3B	.759	.250	1.678	1.572	1.330	1.802-1.817	1.4864	1.792	.084	.231	.132		
24	1.500	1.8125-12 UNJ-3B	.760	.234	1.928	1.822	1.580	2.052-2.072	1.7364	2.042	.097	.266	.155		
28	1.750	2.1250-12 UNJ-3B	.784	.237	2.240	2.135	1.822	2.365-2.385	2.0489	2.355	.171	.471	.271		

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

SAE Aerospace
An SAE International Group**AEROSPACE STANDARD**

NUT, SHORT FLARELESS

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NOTES:

/1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY PER AMS 4928
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS 5659
- c. CODE LETTER W - TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124

2. HEAT TREATMENT:

- a. ALUMINUM ALLOY: NONE
- b. CORROSION RESISTANT STEEL: HEAT TREAT TO CONDITION H1075 PER AMS 2759/3
- c. TITANIUM: NONE

/3/ FINISH:

- a. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486. APPLY DRY FILM LUBRICANT PER MIL-L-46010, TYPE I TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.
- b. MATERIAL CODE LETTER V:
 - (1) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER QQ-P-35, TYPE II OR VIII. APPLY DRY FILM LUBRICANT PER MIL-L-46010, TYPE I TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.
 - (2) V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595. APPLY DRY FILM LUBRICANT PER MIL-L-46010, TYPE I TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.

/4/ PROCUREMENT SPECIFICATION: MIL-F-18280 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

6. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 psi
- b. SIZE -28 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND SIZES -20, -24, AND -28 ALUMINUM ALLOY AT 600 psi

7. THE (R) IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS SPECIFICATION. IF THE SYMBOL IS NEXT TO THE SPECIFICATION TITLE, IT INDICATES A COMPLETE REVISION OF THE REPORT.

8. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

9. INTERPRETATION OF DRAWING PER ARP4296.

10. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra.

11. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.