

REV.  
B

SAE AS4660

# RATIONALE

FEDERAL SUPPLY CLASS  
4730

CANCELED MILITARY STANDARD NUMBERS HAVE BEEN REPLACED. PRI-QPL NOTE HAS BEEN UPDATED AND CADMIUM WARNING NOTICE ADDED. OTHER UPDATES.

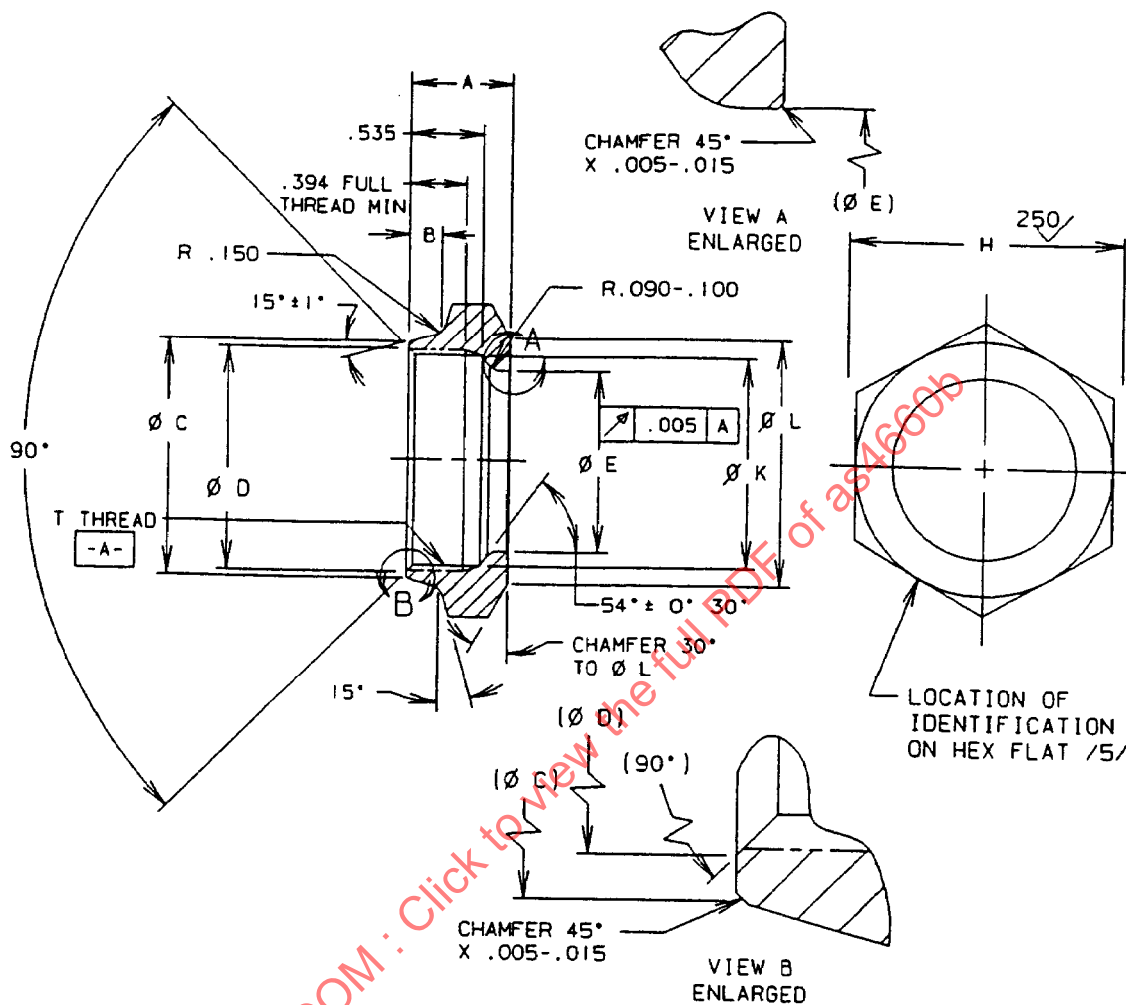
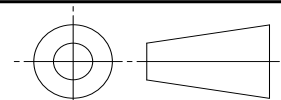


FIGURE 1 - NUT, SHORT FLARELESS

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS4660B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

(R) NUT, SHORT FLARELESS

**SAE AS4660**  
SHEET 1 OF 3

REV.  
B

TABLE 1 - DIMENSIONS AND WEIGHTS

| BASIC NO.<br>AS4660<br>/14/<br>SIZE<br>CODE | (NOMINAL<br>TUBE SIZE) | T THREAD<br>PER AS8879 | A    | B    | C<br>±.005 | D     | E<br>+.005/- .000 | H           | K<br>±.0050 | L     | LB/EA<br>APPROX<br>REF<br>ALUM | LB/EA<br>APPROX<br>REF<br>CRES | LB/EA<br>APPROX<br>REF<br>TI |
|---------------------------------------------|------------------------|------------------------|------|------|------------|-------|-------------------|-------------|-------------|-------|--------------------------------|--------------------------------|------------------------------|
| 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                         |

## NOTES:

## NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE

## /1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY PER AMS4928
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS5659
- c. CODE LETTER W - TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124

## 2. HEAT TREATMENT:

- a. ALUMINUM ALLOY: NONE
- b. CORROSION RESISTANT STEEL: HEAT TREAT TO CONDITION H1075 PER AMS2759/3
- c. TITANIUM: NONE

## /3/ FINISH:

- a. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486. APPLY DRY FILM LUBRICANT PER MIL-PRF-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 AMS2700 TYPE 2 OR 8. APPLY DRY FILM LUBRICANT PER MIL-PRF-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 AMS-QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 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-PRF-46010, TYPE I TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.

/4/ PROCUREMENT SPECIFICATION: PROCUREMENT SPECIFICATION: AS18280 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS18280 FOR THIS STANDARD. SEE <http://www.eAuditNet.com> FOR CURRENT QPL ONLINE.

/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.

|                                                                                                                   |                          |  |                            |           |
|-------------------------------------------------------------------------------------------------------------------|--------------------------|--|----------------------------|-----------|
| <br>An SAE International Group | AEROSPACE STANDARD       |  | SAE AS4660<br>SHEET 2 OF 3 | REV.<br>B |
|                                                                                                                   | (R) NUT, SHORT FLARELESS |  |                            |           |