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AS9308

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5307

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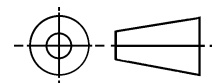
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THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE E-25

PROCUREMENT SPECIFICATION: AMS 7452-73

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

STUD, SHOULDERED, HEXAGON WRENCHING,
DRILLED, STEEL, .190-32 NF-3A X .190-32 NF-3A

AS9308
SHEET 1 OF 4

ISSUED 2000-08 REAFFIRMED 2004-07

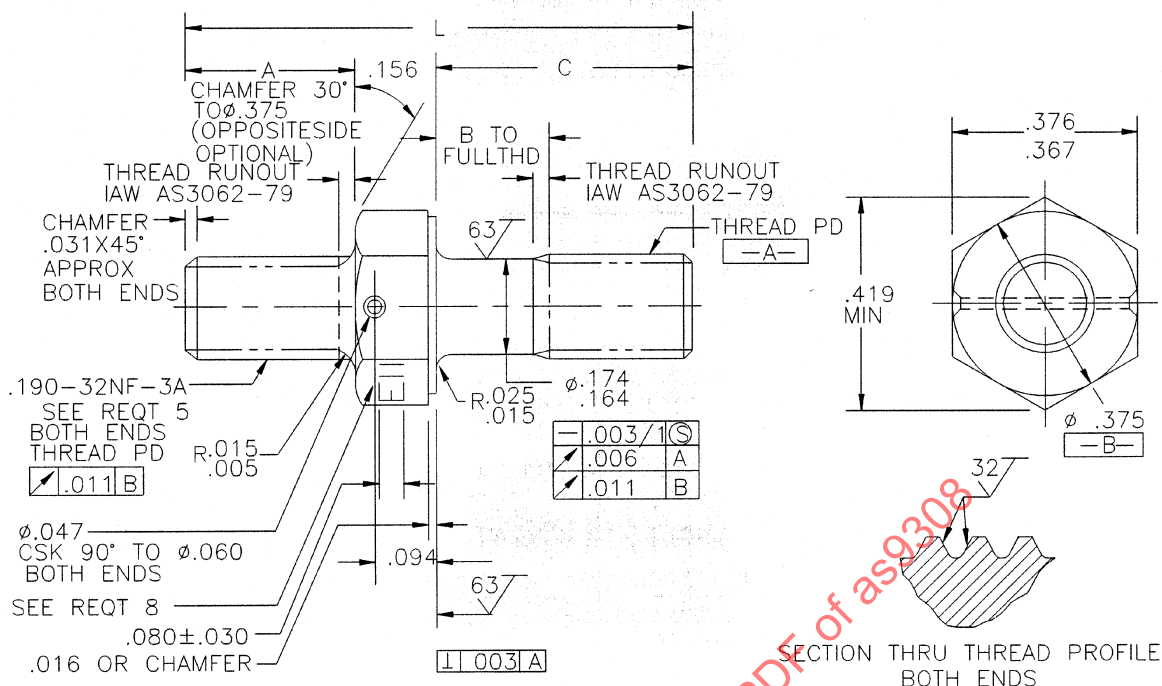


TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100	DASH NO.	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100
-001	.375	1/	.375	.906	.99	-050	.438	1/	.375	.968	1.04
-002	.375	1/	.438	.968	1.04	-051	.438	1/	.438	1.031	1.07
-003	.375	1/	.500	1.031	1.07	-052	.438	1/	.500	1.094	1.13
-004	.375	1/	.562	1.094	1.13	-053	.438	1/	.562	1.156	1.16
-005	.375	1/	.625	1.156	1.16	-054	.438	1/	.625	1.219	1.18
-006	.375	1/	.688	1.219	1.18	-055	.438	1/	.688	1.281	1.27
-007	.375	.125	.750	1.281	1.27	-056	.438	.125	.750	1.344	1.27
-008	.375	.188	.812	1.344	1.27	-057	.438	.188	.812	1.406	1.33
-009	.375	.250	.875	1.406	1.33	-058	.438	.250	.875	1.469	1.38
-010	.375	.312	.938	1.469	1.38	-059	.438	.312	.938	1.531	1.41
-011	.375	.375	1.000	1.531	1.41	-060	.438	.375	1.000	1.594	1.44
-012	.375	.438	1.062	1.594	1.44	-061	.438	.438	1.062	1.656	1.47
-013	.375	.500	1.125	1.656	1.47	-062	.438	.500	1.125	1.719	1.52
-014	.375	.562	1.188	1.719	1.52	-063	.438	.562	1.188	1.781	1.55
-015	.375	.625	1.250	1.781	1.55	-064	.438	.625	1.250	1.844	1.61
-016	.375	.688	1.312	1.844	1.61	-065	.438	.688	1.312	1.906	1.64
-017	.375	.750	1.375	1.906	1.64	-066	.438	.750	1.375	1.969	1.69
-018	.375	.812	1.438	1.969	1.69	-067	.438	.812	1.438	2.031	1.72
-019	.375	.875	1.500	2.031	1.72	-068	.438	.875	1.500	2.093	1.78
-020	.375	.938	1.562	2.093	1.78	-069	.438	.938	1.562	2.156	1.81
-021	.375	1.000	1.625	2.156	1.81	-070	.438	1.000	1.625	2.219	1.83
-022	.375	1.062	1.688	2.219	1.83	-071	.438	1.062	1.688	2.281	1.89
-023	.375	1.125	1.750	2.281	1.89	-072	.438	1.125	1.750	2.344	1.92

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

TABLE I. DASH NUMBERS AND DIMENSIONS - CONTINUED

DASH NO	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100	DASH NO.	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100
-100	.500	1/	.375	1.031	1.07	-150	.562	1/	.375	1.094	1.13
-101	.500	1/	.438	1.094	1.13	-151	.562	1/	.438	1.156	1.16
-102	.500	1/	.500	1.156	1.16	-152	.562	1/	.500	1.219	1.18
-103	.500	1/	.562	1.219	1.18	-153	.562	1/	.562	1.281	1.27
-104	.500	1/	.625	1.281	1.27	-154	.562	1/	.625	1.344	1.27
-105	.500	1/	.688	1.344	1.27	-155	.562	1/	.688	1.406	1.33
-106	.500	.125	.750	1.406	1.33	-156	.562	.125	.750	1.469	1.38
-107	.500	.188	.812	1.469	1.38	-157	.562	.188	.812	1.531	1.41
-108	.500	.250	.875	1.531	1.41	-158	.562	.250	.875	1.594	1.44
-109	.500	.312	.938	1.594	1.44	-159	.562	.312	.938	1.656	1.47
-110	.500	.375	1.000	1.656	1.47	-160	.562	.375	1.000	1.719	1.52
-111	.500	.438	1.062	1.719	1.52	-161	.562	.438	1.062	1.781	1.55
-112	.500	.500	1.125	1.781	1.55	-162	.562	.500	1.125	1.844	1.61
-113	.500	.562	1.188	1.844	1.61	-163	.562	.562	1.188	1.906	1.64
-114	.500	.625	1.250	1.906	1.64	-164	.562	.625	1.250	1.969	1.69
-115	.500	.688	1.312	1.969	1.69	-165	.562	.688	1.312	2.031	1.72
-116	.500	.750	1.375	2.031	1.72	-166	.562	.750	1.375	2.094	1.78
-117	.500	.812	1.438	2.094	1.78	-167	.562	.812	1.438	2.156	1.81
-118	.500	.875	1.500	2.156	1.81	-168	.562	.875	1.500	2.218	1.83
-119	.500	.938	1.562	2.218	1.83	-169	.562	.938	1.562	2.281	1.89
-120	.500	1.000	1.625	2.281	1.89	-170	.562	1.000	1.625	2.344	1.92
-121	.500	1.062	1.688	2.344	1.92	-171	.562	1.062	1.688	2.406	1.98
-122	.500	1.125	1.750	2.406	1.98	-172	.562	1.125	1.750	2.469	2.00

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

REQUIREMENTS:

1. **MATERIAL:** STEEL IN ACCORDANCE WITH AMS 6322-80.
2. **FINISH:** CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80.
3. **HARDNESS:** 26-32 HRC
4. **DIMENSIONING AND TOLERANCING:** DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
5. **THREADS:** THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22.
6. **SURFACE TEXTURE:** SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH AS291-64.
7. **MAGNETIC PARTICLE INSPECTION:** MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640-83.
8. **MARKING:** MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2800-76. DEPRESSED .010 MAX.
9. **TOLERANCES:** UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
10. **EDGES:** BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
11. **MANUFACTURING SPECIFICATION:** AMS 7452-73.