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AS9311

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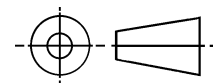
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THIRD ANGLE PROJECTION



ISSUED 1998-08 REAFFIRMED 2003-10

PREPARED BY COMMITTEE E-25

PROCUREMENT SPECIFICATION: AMS 7452-73

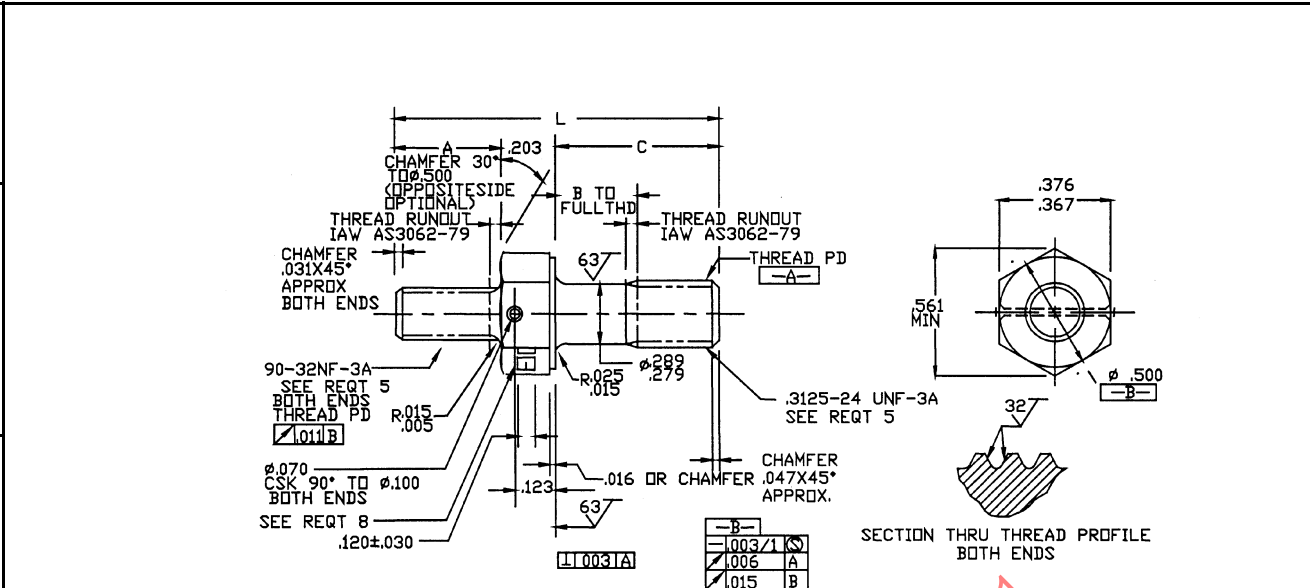
SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

STUD, SHOULDERED AND STEPPED, HEXAGON
WRENCHING, DRILLED, STEEL,
.250-28 UNF-3A X .3125-24 UNF-3A

AS9311
SHEET 1 OF 4

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TABLE 1. DASH NUMBER AND DIMENSIONS

DASH NO	A	B +.000 -.060	C	L REF	APPROX. WEIGHT LBS/100
-001	.438	1/	.500	1.141	2.57
-002	.438	1/	.562	1.203	2.68
-003	.438	1/	.625	1.266	2.80
-004	.438	1/	.688	1.328	2.91
-005	.438	1/	.750	1.391	3.02
-006	.438	1/	.812	1.453	3.14
-007	.438	1/	.875	1.516	3.25
-008	.438	1/	.938	1.578	3.36
-009	.438	.125	1.000	1.641	3.48
-010	.438	.188	1.062	1.703	3.59
-011	.438	.250	1.125	1.766	3.70
-012	.438	.312	1.188	1.828	3.84
-013	.438	.375	1.250	1.891	3.93
-014	.438	.438	1.312	1.953	4.04
-015	.438	.500	1.375	2.016	4.16
-016	.438	.562	1.438	2.078	4.27
-017	.438	.625	1.500	2.141	4.38
-018	.438	.688	1.562	2.203	4.49
-019	.438	.750	1.625	2.266	4.60
-020	.438	.812	1.688	2.328	4.72
-021	.438	.875	1.750	2.391	4.82
-022	.438	.938	1.812	2.453	4.88
-023	.438	1.000	1.875	2.516	4.95
-024	.438	1.062	1.938	2.578	5.06
-025	.438	1.125	2.000	2.641	5.17
-026	.500	1.188	2.062	2.703	5.29
-027	.500	1.250	2.125	2.766	5.36
-028	.500	1.312	2.188	2.828	5.48
-029	.500	1.375	2.250	2.891	5.59
-030	.500	1.438	2.312	2.953	5.70
-031	.500	1.500	2.375	3.016	5.84
-032	.500	1.562	2.438	3.078	5.93
-033	.500	1.625	2.500	3.141	6.04
-034	.500	1.688	2.562	3.203	6.16
-035	.500	1.750	2.625	3.266	6.27
-036	.500	1.812	2.688	3.328	6.38
-037	.500	1.875	2.750	3.391	6.48
-038	.500	1.938	2.812	3.453	6.59
-039	.500	2.000	2.875	3.516	6.70
-040	.500	2.062	2.938	3.578	6.84
-041	.500	2.125	3.000	3.641	6.93
-042	.500	2.188	3.062	3.703	7.04
-043	.500	2.250	3.125	3.766	7.16
-044	.500	2.312	3.188	3.828	7.27
-045	.500	2.375	3.250	3.891	7.38
-046	.500	2.438	3.312	3.953	7.48
-047	.500	2.500	3.375	4.016	7.59
-048	.500	2.562	3.438	4.078	7.70
-049	.500	2.625	3.500	4.141	7.84
-050	.500	2.688	3.562	4.203	7.93
-051	.500	2.750	3.625	4.266	8.04
-052	.500	2.812	3.688	4.328	8.16
-053	.500	2.875	3.750	4.391	8.27
-054	.500	2.938	3.812	4.453	8.38
-055	.500	3.000	3.875	4.516	8.48
-056	.500	3.062	3.938	4.578	8.59
-057	.500	3.125	4.000	4.641	8.70
-058	.500	3.188	4.062	4.703	8.84
-059	.500	3.250	4.125	4.766	8.93
-060	.500	3.312	4.188	4.828	9.04
-061	.500	3.375	4.250	4.891	9.16
-062	.500	3.438	4.312	4.953	9.27
-063	.500	3.500	4.375	5.016	9.38
-064	.500	3.562	4.438	5.078	9.48
-065	.500	3.625	4.500	5.141	9.59
-066	.500	3.688	4.562	5.203	9.70
-067	.500	3.750	4.625	5.266	9.84
-068	.500	3.812	4.688	5.328	9.93

1/ THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

TABLE 1. DASH NUMBER 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	.562	1/	.500	1.266	2.80	-150	.625	1/	.500	1.328	2.91
.101	.562	1/	.562	1.328	2.91	-151	.625	1/	.562	1.391	3.02
.102	.562	1/	.625	1.391	3.02	-152	.625	1/	.625	1.453	3.14
.103	.562	1/	.688	1.453	3.14	-153	.625	1/	.688	1.516	3.25
.104	.562	1/	.750	1.516	3.25	-154	.625	1/	.750	1.578	3.36
.105	.562	1/	.812	1.578	3.36	-155	.625	1/	.812	1.641	3.48
.106	.562	1/	.875	1.641	3.48	-156	.625	1/	.875	1.703	3.59
.107	.562	1/	.938	1.703	3.59	-157	.625	1/	.938	1.766	3.70
.108	.562	.125	1.000	1.766	3.70	-158	.625	.125	1.000	1.828	3.84
.109	.562	.188	1.062	1.828	3.84	-159	.625	.188	1.062	1.891	3.93
.110	.562	.250	1.125	1.891	3.93	-160	.625	.250	1.125	1.953	4.04
.111	.562	.312	1.188	1.953	4.04	-161	.625	.312	1.188	2.016	4.16
.112	.562	.375	1.250	2.016	4.16	-162	.625	.375	1.250	2.078	4.27
.113	.562	.438	1.312	2.078	4.27	-163	.625	.438	1.312	2.141	4.38
.114	.562	.500	1.375	2.141	4.38	-164	.625	.500	1.375	2.203	4.49
.115	.562	.562	1.438	2.203	4.49	-165	.625	.562	1.438	2.266	4.60
.116	.562	.625	1.500	2.266	4.60	-166	.625	.625	1.500	2.328	4.72
.117	.562	.688	1.562	2.328	4.72	-167	.625	.688	1.562	2.391	4.83
.118	.562	.750	1.625	2.391	4.83	-168	.625	.750	1.625	2.453	4.95
.119	.562	.812	1.688	2.453	4.95	-169	.625	.812	1.688	2.516	5.06
.120	.562	.875	1.750	2.516	5.06	-170	.625	.875	1.750	2.578	5.17
.121	.562	.938	1.812	2.578	5.17	-171	.625	.938	1.812	2.641	5.29
.122	.562	1.000	1.875	2.641	5.29	-172	.625	1.000	1.875	2.703	5.35
.123	.562	1.062	1.938	2.703	5.35	-173	.625	1.062	1.938	2.766	5.40
.124	.562	1.125	2.000	2.766	5.40	-174	.625	1.125	2.000	2.828	5.49

1/ THREAD TO HEAD. MAXIMUM TWO INCOMPLETE THREADS

REQUIREMENTS:

- MATERIAL : STEEL IN ACCORDANCE WITH AMS 6322-80.
- FINISH : CADMIUM PLATE IN ACCORDANCE WITH AMS 2400-80.
- HARDNESS : 26-32 HRC
- DIMENSIONING AND TOLERANCING : DIMENSIONING AND TOLERANCING SHALL BE IN ACCORDANCE WITH ANSI Y14.5M.
- 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.
- SURFACE TEXTURE : SURFACE TEXTURES SHALL BE IN ACCORDANCE WITH A8291-64.
- MAGNETIC PARTICLE INSPECTION : MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH AMS 2640-83.
- MARKING : MATERIAL IDENTIFICATION AND MARKING IN ACCORDANCE WITH AMS 2800-76. DEPRESSED .010 MAX.
- TOLERANCES : UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
- MANUFACTURING SPECIFICATION : AMS 7452