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REV.
A

AS3121

FEDERAL SUPPLY CLASS
5315

RATIONALE

AS3121A HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

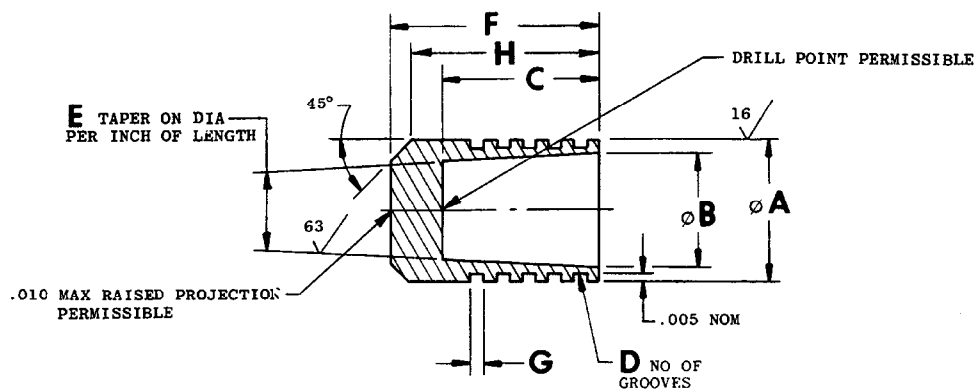


FIGURE 1

TABLE 1A - PART NUMBERS AND DIMENSIONS

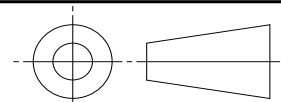
STANDARD DIAMETER			
AEROSPACE STANDARD PART NUMBER /7/	MANUFACTURER'S PART NUMBER /7/	ØA	APPROX MASS LB/100
AS3121-03	PLGA1567010A	.1553-.1562	.025
AS3121-04	PLGA1877010A	.1866-.1875	.036
AS3121-05	PLGA2187010A	.2178-.2187	.050
AS3121-06	PLGA2507010A	.2491-.2500	.080
AS3121-07	PLGA2817010A	.2803-.2812	.085
AS3121-08	PLGA3437010A	.3428-.3437	.182
AS3121-09	PLGA4067010A	.4053-.4062	.257
AS3121-10	PLGA4687010A	.4678-.4687	.346
AS3121-11	PLGA5317010A	.5303-.5312	.449
AS3121-12	PLGA6567010A	.6553-.6562	.720

TABLE 1B - PART NUMBERS AND DIMENSIONS

.010 OVERSIZE DIAMETER			
AEROSPACE STANDARD PART NUMBER /7/	MANUFACTURER'S PART NUMBER /7/	ØA	APPROX MASS LB/100
AS3121-53	PLGA1667010A	.1653-.1662	.031
AS3121-54	PLGA1977010A	.1966-.1975	.042
AS3121-55	PLGA2287010A	.2278-.2287	.060
AS3121-56	PLGA2607010A	.2591-.2600	.092
AS3121-57	PLGA2917010A	.2903-.2912	.103
AS3121-58	PLGA3537010A	.3528-.3537	.205
AS3121-59	PLGA4167010A	.4153-.4162	.287
AS3121-60	PLGA4787010A	.4778-.4787	.387
AS3121-61	PLGA5417010A	.5403-.5412	.504
AS3121-62	PLGA6667010A	.6653-.6662	.793

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS3121A>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

(R) PLUG, EXPANSION, ALUMINUM, 2024-T4 AND
2024-T351, LONG; STD AND .010 OVERSIZE DIAMETERS
(UNS A92024)

AS3121
SHEET 1 OF 3

REV.
A

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ISSUED 1981-02 REVISED 2008-09 REAFFIRMED 2014-04

TABLE 1C - PART NUMBERS AND DIMENSIONS

AEROSPACE STANDARD PART NUMBER /7/	ØB NOM	C NOM	D	ØE NOM	F	G NOM	H
AS3121-03 & 53	.114	.187	8	.0417	.238-.252	.010	.198-.232
AS3121-04 & 54	.146	.205	8	.0417	.253-.267	.010	.227-.243
AS3121-05 & 55	.178	.250	8	.0417	.300-.314	.010	.260-.294
AS3121-06 & 56	.204	.300	8	.0417	.358-.372	.015	.324-.342
AS3121-07 & 57	.240	.312	8	.0313	.363-.377	.013	.323-.357
AS3121-08 & 58	.289	.375	8	.0208	.493-.507	.020	.393-.427
AS3121-09 & 59	.352	.437	9	.0208	.558-.572	.020	.448-.482
AS3121-10 & 60	.414	.500	10	.0208	.613-.627	.020	.513-.547
AS3121-11 & 61	.477	.562	12	.0156	.673-.687	.020	.573-.607
AS3121-12 & 62	.595	.625	14	.0156	.743-.757	.020	.645-.675

NOTES:

- MATERIAL: AMS4120 SIMILAR TO UNS A92024 (AL ALLOY 2024-T4; SIZES 03 THRU 08 AND 53 THRU 58, AND AL ALLOY 2024-T351; SIZES 09 THRU 12 AND 59 THRU 62), OR AMS-QQ-A-225/6 UNS A92024 (AL ALLOY 2024-T4; SIZES 03 THRU 08 AND 53 THRU 58, AND AL ALLOY 2024-T351; SIZES 09 THRU 12 AND 59 THRU 62).
- FINISH: ANODIZE PER MIL-A-8625 TYPE IIB, CLASS 2. STANDARD PLUGS ARE DYED GREEN; .010 OVERSIZE PLUGS ARE DYED RED.
- GROOVE BURRS PERMITTED ON OD OF PLUG TO .001 OVER MAX Ø A.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M, REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.
- BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: ANGULAR DIMENSIONS $\pm 2^\circ$. DIMENSIONS APPLY AFTER FINISH.
- /7/ MARK AS3121-() PART NUMBER AND MANUFACTURER'S PART NUMBER ON PACKAGE IN ACCORDANCE WITH AS478, METHOD 37.
- USE WITH AS3122 PINS. SEE AIR3276 HOLE PREPARATION AND AIR3277 FOR INSTALLATION PROCEDURES.
- DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994.
- DO NOT USE UNASSIGNED PART NUMBERS.
- SEE AS3589 FOR AS3121 PLUG AND AS3122 PIN SET OF PARTS.
- AS, AIR AND AMS ARE SAE INTERNATIONAL PUBLICATIONS. ASME IS AN AMERICAN SOCIETY OF MECHANICAL ENGINEERS PUBLICATION. MIL IS AN US GOVERNMENT PUBLICATION.
- A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN 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 DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

	AEROSPACE STANDARD	AS3121 SHEET 2 OF 3	REV. A
	(R) PLUG, EXPANSION, ALUMINUM, 2024-T4 AND 2024-T351, LONG; STD AND .010 OVERSIZE DIAMETERS (UNS A92024)		