

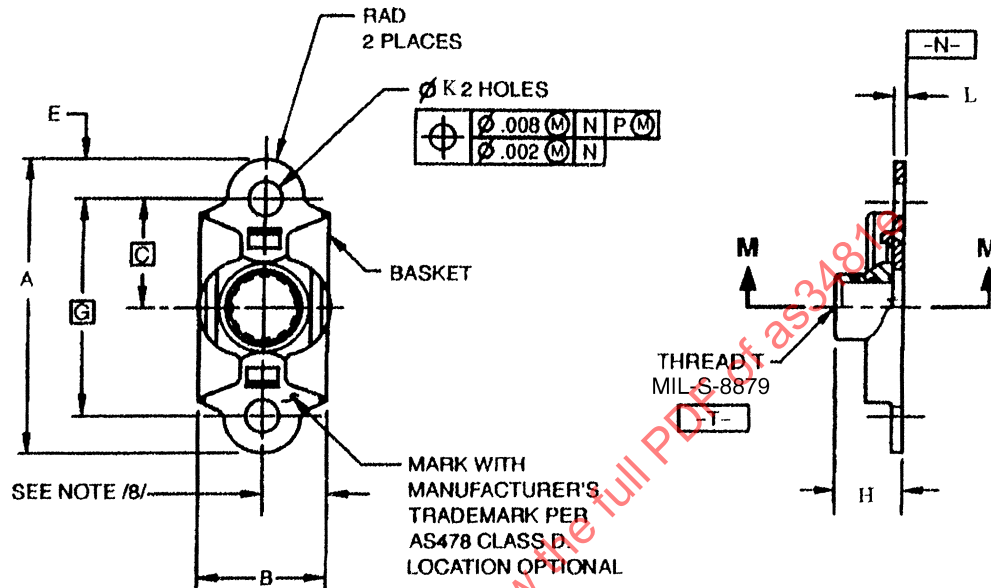
REV.
E

AS3481

FEDERAL SUPPLY CLASS
5310

RATIONALE

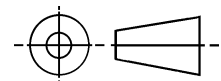
THIS DOCUMENT HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE 5-YEAR REVIEW POLICY.



SECTION M-M

FIGURE 1

THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE E-25, GENERAL STANDARDS FOR AEROSPACE PROPULSION SYSTEMS

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

NUT, SELF-LOCKING, PLATE, TWO LUG, FLOATING,
REDUCED RIVET SPACING, LOW HEIGHT,
UNS S66286, CLASS: 125 KSI/800 °F

AS3481
SHEET 1 OF 3

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ISSUED 1991-02 REVISED 2002-03 REAFFIRMED 2007-06

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TABLE 1A

PART NUMBER AS3481	T THREAD	A MAX	B	C BASIC	ØD CBORE MIN	E MIN	H MAX
-01	.1380-32UNJC-3B	.682	.290-.357	.218	--	.070	.171
-02	.1640-32UNJC-3B	.707	.290-.367	.234	.168	.100	.250
-03	.1900-32UNJF-3B	.739	.290-.416	.250	.194	.100	.250
-04	.2500-28UNJF-3B	.801	.350-.500	.281	.254	.100	.281
-05	.3125-24UNJF-3B	1.010	.412-.581	.359	.317	.117	.328

TABLE 1B

PART NUMBER AS3481	G BASIC	ØK +.005 -.000	ØJ	L	AXIAL STRENGTH LBF MIN	APPROX MASS LB/100
-01	.437	.098	.178-.270	.020-.090	1130	.32
-02	.468	.098	.204-.270	.025-.090	1720	.36
-03	.500	.098	.230-.270	.025-.090	2460	.39
-04	.562	.098	.290-.330	.027-.090	4580	.69
-05	.718	.130	.352-.392	.032-.105	7390	1.10

NOTES:

1. MATERIAL:
 - a. NUT: CORROSION AND HEAT RESISTANT STEEL AMS 5525, AMS 5731, OR AMS 5734.
 - b. BASKET: CORROSION AND HEAT RESISTANT STEEL AMS 5525.
2. HEAT TREATMENT: AFTER FORMING, PLATE NUTS SHALL BE PRECIPITATION HEATED TO A HARDNESS NOT TO EXCEED THAT SPECIFIED IN NOTE 6.
3. FINISH:
 - a. NUT: SILVER PLATE PER AMS 2411; SILVER PLATE ONLY ON THREADS, EXCEPT:
 1. SIZE -01 MAY HAVE OPTIONAL COVERAGE ON COUNTERSINK.
 2. SIZE -02 THROUGH -05 MAY HAVE OPTIONAL COVERAGE IN COUNTERBORE TO .030 MAXIMUM DEPTH.
 DIMENSIONS APPLY AFTER PLATING.
 - b. BASKET: PASSIVATE PER AMS-QQ-P-35, TYPE II OR VIII.
4. PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS FOLLOWS:
 - a. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F ± 15 °F FOR NUTS TESTED AFTER BAKE.
 - b. AXIAL STRENGTH LOAD PER MIL-DTL-25027. SEE SHEET 2, TABLE 1.
- /5/ SIZE -01 MAY BE COUNTERSUNK OR RADIUSSED WITHIN ØJ. SIZE -02 AND LARGER SHALL BE COUNTERBORED TO ØD TO .062 MINIMUM DEPTH..
6. HARDNESS: 44 HRC MAXIMUM.
7. RADIAL FLOAT OF NUT THREADS RELATIVE TO BASKET ØJ, .020 MINIMUM.
- /8/ ØJ TO BE CENTERED ON WIDTH B WITHIN ±.010.
9. REMOVE BURRS AND SHARP EDGES.
10. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 µin Ra.
11. DIMENSIONING AND TOLERANCING: ANSI Y14.5M-1982 (ASME PUBLICATION).
12. DIMENSIONS ARE IN INCHES.
13. DO NOT USE UNASSIGNED PART NUMBERS.