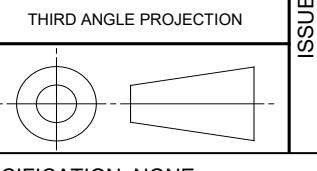


REV. A AS3616™	<p style="text-align: center;">RATIONALE</p> <p>THIS DOCUMENT HAS BEEN DETERMINED TO CONTAIN BASIC AND STABLE TECHNOLOGY WHICH IS NOT DYNAMIC IN NATURE.</p> <p style="text-align: center;">STABILIZED NOTICE</p> <p>THIS DOCUMENT HAS BEEN DECLARED "STABILIZED" BY SAE E-25 GENERAL STANDARDS FOR AEROSPACE AND PROPULSION SYSTEMS COMMITTEE AND WILL NO LONGER BE SUBJECT TO PERIODIC REVIEWS FOR CURRENCY. USERS ARE RESPONSIBLE FOR VERIFYING REFERENCES AND CONTINUED SUITABILITY OF TECHNICAL REQUIREMENTS. NEWER TECHNOLOGY MAY EXIST.</p>	<p style="text-align: center;">FEDERAL SUPPLY CLASS 5310</p>
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	<p>CUSTODIAN: E-25</p>	<p>PROCUREMENT SPECIFICATION: NONE</p>
	<p style="text-align: center;">AEROSPACE STANDARD</p> <p style="text-align: center;">NUT, SELF-LOCKING, DOUBLE HEXAGON REDUCED FLANGE, SOLID FILM LUBE COUNTERBORED 180 KSI, 1400 °F, UNS N07001</p>	<p style="text-align: center;">THIRD ANGLE PROJECTION</p>  <p>AS3616™</p> <p>REV. A</p>

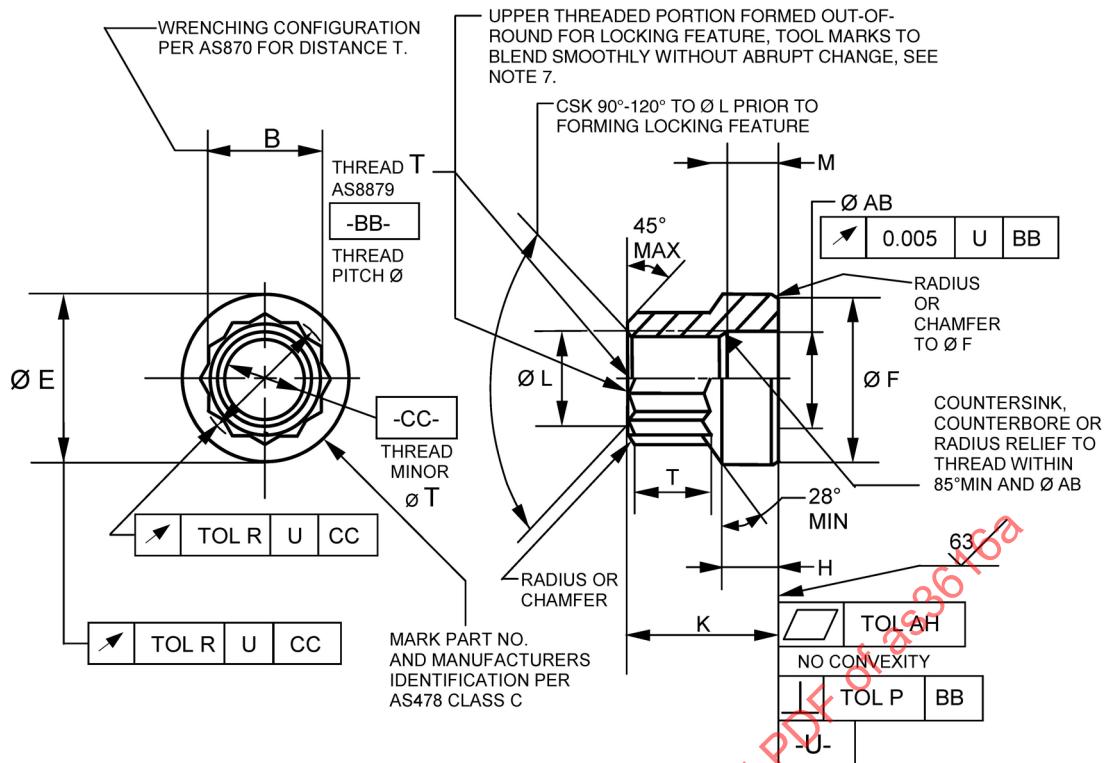


FIGURE 1

TABLE 1

PART /11/ NUMBER	T THREAD SIZE PER AS8879	B		ØE MAX	ØF MIN	H MIN	K MAX
		AS870 DASH NO.	NOMINAL SIZE				
AS3616-03	.1900-32 UNJF-3B	08	.2500	.340	.325	.125	.350
AS3616-04	.2500-28 UNJF-3B	10	.3125	.450	.410	.170	.437
AS3616-05	.3125-24 UNJF-3B	12	.3750	.525	.495	.175	.490
AS3616-06	.3750-24 UNJF-3B	14	.4375	.600	.560	.195	.588
AS3616-07	.4375-20 UNJF-3B	18	.5625	.690	.650	.220	.590
AS3616-08	.5000-20 UNJF-3B	20	.6250	.780	.740	.240	.785
AS3616-09	.5625-18 UNJF-3B	22	.6875	.880	.840	.270	.855
AS3616-10	.6250-18 UNJF-3B	25	.7812	.970	.925	.290	.965
AS3616-12	.7500-16 UNJF-3B	30	.9375	1.230	1.180	.320	1.110

TABLE 1 (CONTINUED)

PART /11/ NUMBER	ØL	M	T MIN	R TOL.	P TOL.	ØAB MAX	AH TOL.	APPROX. MASS LB/100
AS3616-03	.190 - .210	.085 - .105	.082	.006	.004	.200 - .210	.0014	.44
AS3616-04	.250 - .270	.100 - .120	.130	.007	.005	.260 - .270	.0014	.77
AS3616-05	.312 - .332	.115 - .135	.170	.008	.005	.323 - .333	.0016	1.22
AS3616-06	.375 - .395	.115 - .135	.210	.009	.005	.385 - .395	.0016	1.9
AS3616-07	.438 - .458	.140 - .160	.230	.010	.005	.448 - .458	.0020	3.31
AS3616-08	.500 - .520	.140 - .160	.260	.012	.006	.510 - .525	.0020	4.42
AS3616-09	.562 - .582	.160 - .180	.320	.014	.006	.573 - .583	.0020	7.96
AS3616-10	.625 - .645	.160 - .180	.370	.015	.007	.635 - .645	.0020	10.80
AS6316-12	.750 - .770	.180 - .200	.500	.016	.007	.760 - .770	.0020	12.57

NOTES:

1. MATERIAL: AMS 5708 OR AMS 5709; HEAT RESISTING NICKEL ALLOY.
2. HARDNESS: 32-44 HRC.
3. PROCUREMENT SPECIFICATION: AS5878.
 - a. COATING: SOLID FILM LUBRICATION PER AS1701, CLASS IV.
 - b. DIMENSIONS APPLY BEFORE COATING WITH SOLID FILM LUBRICANT.
4. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
5. FLUORESCENT PENETRANT INSPECTION PER AS5878, PRIOR TO COATING.
6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1 SURFACE TO BE 125 μ in Ra, UNLESS OTHERWISE SPECIFIED.
7. DIMENSION B APPLIES PRIOR TO FORMING THE SELF-LOCKING FEATURE AFTER FORMING NUTS SHALL ALLOW THE FITMENT OF STANDARD TOOLS SELECTED FROM AS954.
8. DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994.
9. DIMENSIONS ARE IN INCHES.
10. DO NOT USE UNASSIGNED PART NUMBERS.



AEROSPACE STANDARD

NUT, SELF-LOCKING, DOUBLE HEXAGON
REDUCED FLANGE, SOLID FILM LUBE
COUNTERBORED 180 KSI, 1400 °F, UNS N07001

AS3616™
SHEET 2 OF 3

REV.
A