



400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD



AS7478

REV.
A

Issued 1991-01
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Submitted for recognition as an American National Standard

(R) BOLTS AND SCREWS, STEEL, UNS S66286

Classification: 130 ksi/1200 °F

1800 °F Solution Heat Treated, Aged After Roll Threaded

Procurement Specification for

FSC 5306

1. SCOPE:

1.1 Type:

This procurement specification covers bolts and screws made from a corrosion and heat resistant age hardenable iron base alloy of the type identified under the Unified Numbering System as UNS S66286.

- 1.1.1 Classification: 130 ksi minimum tensile strength at room temperature
(R) 1200 °F maximum test temperature of parts

1.2 Application:

Primarily for aerospace propulsion system applications where stress-rupture strength and creep resistance are required at elevated temperature.

1.3 Safety - Hazardous Materials:

While the materials, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

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SAE AS7478 Revision A**2. REFERENCES:****2.1 Applicable Documents:**

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other documents shall be the issue in effect on the date of the purchase order.

2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

- AMS 2759/3 Heat Treatment of Precipitation Hardening, Corrosion Resistant and Maraging Steel Parts
- AMS 5731 Steel Bars, Forgings, Tubing, and Rings, Corrosion and Heat Resistant, 15Cr-25.5Ni-1.2Mo-2.1Ti-0.006B-0.30V Consumable Electrode Melted, 1800 °F (982 °C), Solution Heat Treated
- AS1132 Design Parameters for Bolts and Screws, External Wrenching, Unified Thread Inch Series
- AS3062 Bolts, Screws, and Studs, Screw Thread Requirements
- AS3063 Bolts, Screws, and Studs, Geometric Control Requirements

2.1.2 U.S. Government Publications: Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

- QQ-P-35 Passivation Treatments for Corrosion Resistant Steel
- MIL-S-8879 Screw Threads, Controlled Radius Root With Increased Minor Diameter; General Specifications For
- MIL-STD-1312-6 Fastener Test Methods, Method 6, Hardness
- MIL-STD-1312-8 Fastener Test Methods, Method 8, Tensile Strength
- MIL-STD-1312-10 Fastener Test Methods, Method 10, Stress-Rupture
- MIL-STD-1312-12 Fastener Test Methods, Method 12, Thickness of Metallic Coatings
- MIL-STD-1312-13 Fastener Test Methods, Method 13, Double Shear Test

2.1.3 ASTM Publications: Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

- ASTM E 8 Tension Testing of Metallic Materials
- ASTM E 112 Determining Average Grain Size
- ASTM E 139 Conducting Creep, Creep-Rupture, and Stress-Rupture Test of Metallic Materials
- ASTM E 140 Standard Hardness Tables for Metals
- ASTM E 1417 Liquid Penetrant Examination
- ASTM D 3951 Commercial Packaging

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- 2.1.4 ANSI Publication: Available from American National Standards Institute, 11 West 42nd Street, 13th Floor, New York, NY 10036.

ANSI/ASME B46.1 Surface Texture (Surface Roughness, Waviness, and Lay)

2.2 Definitions:

(R)

BURR: A rough edge or ridge left on the metal due to a cutting, grinding, piercing or blanking operation.

TIGHT BURR: A burr closely compacted and binding in the periphery of a part without any loose ends and is within the dimensional limits of the part.

DEFECTIVE: A unit of product which contains one or more defects.

PRODUCTION INSPECTION LOT: Shall be all finished parts of the same part number, made from a single heat of alloy, heat treated at the same time to the same specified condition, produced as one continuous run, and submitted for vendor's inspection at the same time.

2.3 Unit Symbols:

(R)

- ° - degree, angle
- °C - degree Celsius
- °F - degree Fahrenheit
- cm³ - cubic centimeter
- g - gram (mass)
- % - percent (1% = 1/100)
- lbf - pound-force
- ksi - kips (1000 pounds) per square inch
- sp gr - specific gravity
- HRC - hardness, Rockwell C scale

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Shall be AMS 5731 steel heading stock, unless otherwise specified on part drawing.

3.2 Design:

Finished (completely manufactured) parts shall conform to the following requirements:

- 3.2.1 **Dimensions:** The dimensions of finished parts, after all processing including plating, shall conform to the requirements as specified on the part drawing. Dimensions apply after plating but before coating with dry film lubricants.

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- 3.2.2 Surface Texture:** Surface texture of finished parts, prior to plating or coating, shall conform to the requirements as specified on the part drawing, determined in accordance with ANSI/ASME B46.1.
- 3.2.3 Threads:** Screw thread UNJ profile and dimensions shall be in accordance with MIL-S-8879, unless otherwise specified on the part drawing.
- 3.2.3.1 Incomplete Lead and Runout Threads:** Incomplete threads are permissible at the entering end and the juncture of the unthreaded portion of the shank or adjacent to the head as specified in AS3062.
- 3.2.3.2 Chamfer:** The entering end of the thread shall be chamfered as specified on the part drawing.
- 3.2.4 Geometric Tolerances:** Part features shall be within the geometric tolerances specified on the part drawing and, where applicable, controlled in accordance with AS3063.
- 3.3 Fabrication:**
- 3.3.1 Blanks:** Heads shall be formed by hot forging, cold forging, or machining. Heading stock to be hot forged shall be heated to a temperature not higher than 2100 °F. Lightening holes may be produced by any suitable method. Wrenching recesses may be forged or machined. Flash or chip clearance in machined recesses shall not cause dimensions to exceed the specified limits.
- 3.3.2 Heat Treatment:** Shall conform to the technical requirements and other provisions specified in (R) AMS 2759/3 for A-286, 1800 °F solution heat treatment and 1325 °F aging treatment.
- 3.3.2.1 Solution Heat Treatment:** Headed and machined blanks of AMS 5731, unless machined from solution heat treated stock, shall, before finishing the shank and the bearing surface of the head, cold rolling the head-to-shank fillet radius when specified, and rolling the threads, be solution heat treated as in 3.3.2. Blanks of other materials shall be solution heat treated in accordance with the applicable material specification. If blanks are machined from solution heat treated stock, only the aging treatment as in 3.3.2.2 is necessary.
- 3.3.2.2 Aging Treatment:** After cold rolling the fillet radius as in 3.3.4 when specified and rolling the threads as in 3.3.5, parts of AMS 5731 shall be heat treated by aging as in 3.3.2. Parts of other materials shall be heat treated by aging after cold rolling the fillet radius as in 3.3.4 when specified and rolling the threads as in 3.3.5, in accordance with the applicable material specification.
- 3.3.3 Oxide Removal:** Surface oxide and oxide penetration resulting from prior heat treatment shall be removed from the full body diameter and bearing surface of the head of the solution heat treated blanks prior to cold rolling the fillet radius when specified and rolling the threads. The oxide removal process shall produce no intergranular attack or corrosion of the blanks. The metal removed from the bearing surface of the head and the full body diameter of the shank shall be as little as practicable to obtain a clean, smooth surface.

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- 3.3.4 Cold Rolling of Fillet Radius: After removal of oxide as in 3.3.3, the head-to-shank fillet radius of parts having the radius complete throughout the circumference of the part shall, when specified, be cold rolled sufficiently to remove all visual evidence of grinding or tool marks. Distortion due to cold rolling shall conform to Figure 1, unless otherwise specified on the part drawing. No raised metal (excrescence) is permitted on the head bearing surface (face) or depressed metal more than 0.001 inch below the fillet radius contour as shown in Figure 1; the unthreaded shank at the position shown in Figure 1, inclusive of distortion, shall not exceed the unthreaded shank diameter by an amount more than that specified in Figure 1. In configurations having an undercut connected with the fillet radius, the cold rolling will be required only for 90° of fillet arc, starting at the point of tangency of the fillet radius and the bearing surface of the head. For shouldered bolts, having an unthreaded shank diameter larger than the thread major diameter and having an undercut connected with a fillet between the threaded shank and the shoulder of the unthreaded shank, the cold rolling will be required only for 90° of fillet arc, starting at the point of tangency of the fillet radius and the shouldered surface of the unthreaded shank.
- (R)
- 3.3.5 Thread Rolling: Threads shall be formed on the finished blanks by a single cold rolling process after removal of oxide as in 3.3.3.
- (R)
- 3.3.6 Passivation Treatment: Parts, after finishing, shall be degreased and then subjected to the passivation treatment and copper sulfate test in accordance with QQ-P-35.
- (R)
- 3.4 Product Marking:
- Each part shall be identification marked as specified by the part drawing. The markings may be formed by forging or stamping, raised or depressed 0.010 inch max, with rounded root form on depressed characters.
- 3.5 Plating or Coating:
- Where required, surfaces shall be plated as specified by the part drawing. Where coating with dry film lubricants is required, the under-head bearing surface, unthreaded shank, and threads shall be coated as specified on the part drawing; other surfaces are optional to coat, unless otherwise specified.
- 3.6 Mechanical Properties:
- (R)
- Where AS7478 is specified, parts shall conform to the requirements of 3.6.1, 3.6.2, and 3.6.4. Where AS7478-1 is specified, parts shall conform to the requirements of 3.6.1, 3.6.2, and 3.6.3. Threaded members of gripping fixtures for tensile and stress-rupture tests shall be of sufficient size and strength to develop the full strength of the part without stripping the thread. The loaded portion of the shank shall have a minimum of three full thread turns from the thread runout exposed between the loading fixtures during the tensile and stress-rupture tests.

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3.6 (Continued):

AS7478 finished parts shall be tested in accordance with the following test methods:

- a. Hardness: MIL-STD-1312-6
- b. Room Temperature Ultimate Tensile Strength: MIL-STD-1312-8
- c. Stress-Rupture Strength at 1200 °F: MIL-STD-1312-10

AS7478-1 finished parts shall be tested in accordance with the following test methods:

- a. Hardness: MIL-STD-1312-6
- b. Room Temperature Ultimate Tensile Strength: MIL-STD-1312-8
- c. Ultimate Double Shear at Room Temperature: MIL-STD-1312-13

3.6.1 Ultimate Tensile Strength at Room Temperature:

3.6.1.1 Finished Parts: Parts shall have an ultimate tensile load not lower than that specified in Table 2 and shall be tested to failure in order to observe fracture location, first measuring and recording the maximum tensile load achieved. If the size or shape of the part is such that failure would occur outside the threaded section but the part can be tested satisfactorily, such as parts having a shank diameter equal to or less than the thread root diameter or having an undercut, parts shall have an ultimate tensile strength not lower than 130 ksi; for such parts, the diameter of the area on which stress is based shall be the actual measured minimum diameter of the part. Tension fasteners with either standard double hexagon or hexagon-type heads having a minimum metal condition in the head equal to the design parameters specified in AS1132 shall not fracture in the head-to-shank fillet radius except when this radius is connected with an undercut or with a shank diameter less than the minimum pitch diameter of the thread.

3.6.1.2 Machined Test Specimens: If the size or shape of the part is such that a tensile test cannot be made on the part, tensile tests shall be conducted in accordance with ASTM E 8 on specimens as in 4.4.7. Specimens may be required by purchaser to perform confirmatory tests. Such specimens shall meet the following requirements:

- a. Ultimate Tensile Strength, minimum: 130 ksi
- b. Yield Strength at 0.2% Offset, minimum: 85 ksi
- c. Elongation in 2 inches or 4D, minimum: 15 %
- d. Reduction of Area, minimum: 20 %

3.6.1.2.1 When permitted by purchaser, hardness tests on the end of parts may be substituted for tensile tests of machined specimens.

3.6.2 Hardness: Shall be uniform and within the range 24 to 35 HRC (see 8.1), but hardness of the threaded section and of the head-to-shank fillet area when cold rolling of this area is specified, may be higher as a result of the cold rolling operations. Parts shall not be rejected on the basis of hardness if the tensile strength properties of the part, specified in 3.6.1 are met.

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3.6.3 Ultimate Shear Strength: Finished parts having a close toleranced full shank as in AS1132 (R) shall have an ultimate double shear load not lower than that specified in Table 2. The double shear test may be discontinued without a complete shear failure after the ultimate double shear load has been reached, first measuring and recording the maximum double shear load achieved. Shear bolts having special shank diameters shall have the minimum ultimate double shear load based on 85 ksi minimum shear strength. Shear tests are not required for countersunk head fasteners having a grip less than 2.5 times the nominal diameter, or protruding head fasteners having a grip less than 2 times the nominal diameter. Shear test is not required for the following conditions:

- a. Bolts or screws threaded to head.
- b. Protruding head bolts having coarse tolerance full shank.
- c. Protruding head bolts having a PD or relieved shank.

3.6.4 Stress-Rupture Strength at 1200 °F:

3.6.4.1 Finished Parts: Finished parts, maintained at 1200 °F $\pm$ 3 °F while the tensile load specified in Table 2 is applied continuously, shall not rupture in less than 23 hours. If the shank diameter of the part is less than the maximum minor (root) diameter of the thread but the part can be tested satisfactorily, parts shall conform to the requirements of 3.6.4.1.1.

3.6.4.1.1 Parts having a shank diameter less than the maximum minor (root) diameter of the thread shall be tested as in 3.6.4.1 except that the load shall be as specified in 3.6.4.2. The diameter of the area on which stress is based shall be the actual measured minimum diameter of the part.

3.6.4.2 Machined Test Specimens: If the size or shape of the part is such that a stress-rupture test cannot be made on the part, a test specimen prepared as in 4.4.7, maintained at 1200 °F $\pm$ 3 °F while a load sufficient to produce an initial axial stress of 65 ksi is applied continuously, shall not rupture in less than 23 hours. Tests shall be conducted in accordance with ASTM E 139.

3.7 Quality:

(R)

Parts shall be uniform in quality and condition, clean, sound, smooth, and free from burrs (tight burrs may be acceptable if part performance is not affected) and foreign materials, and from imperfections detrimental to the usage of the parts.

3.7.1 Macroscopic Examination: Specimens cut from headed blanks and from finished parts shall be (R) etched in a suitable etchant and examined at a magnification of approximately 20X to determine conformance to the requirements of 3.7.1.1 and 3.7.1.2. The head and shank section shall extend not less than D/2 from the bearing surface of the head and the threaded shank section shall extend not less than D/2 beyond the thread runout where "D" is the nominal diameter of the shank after heading. If the two sections would overlap, the entire length of the part shall be sectioned and examined as a whole.

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3.7.1.1 Flow Lines:

3.7.1.1.1 Head-to-Shank, Headed Blanks: After heading and prior to heat treatment, examination of an etched section taken longitudinally through the blank shall show flow lines in the shank, head-to-shank fillet, and bearing surface which follow the contour of the blank as shown in Figure 2. Flow lines in headed blanks having special heads, such as Dee- or Tee-shaped heads or thinner than AS1132 standard heads, shall be as agreed upon by purchaser and vendor.

3.7.1.1.2 Head-to-Shank, Finished Part: If parts have forged heads, examination of a longitudinal section through the part shall show evidence that the heads were formed by forging. This evidence shall include traces of flow lines as shown in Figure 2B.

3.7.1.1.3 Threads: Examination of a longitudinal section through the threaded portion of the shank shall show evidence that the threads were rolled. This evidence shall include traces of flow lines as shown in Figure 3.

3.7.1.2 Internal Defects: Examination of longitudinal sections of the head and shank shall reveal no cracks, laps, or porosity. Thread imperfections as in 3.7.2.4 shall be examined in accordance with 3.7.2.

3.7.2 Microscopic Examination: Specimens cut from parts shall be polished, etched in Kalling's reagent [100 cm³ of absolute ethyl alcohol, 100 cm³ of hydrochloric acid (sp gr 1.19), and 5 g of cupric chloride], Marble's reagent [20 cm³ of hydrochloric acid (sp gr 1.19), 20 cm³ of water, and 4 g of cupric sulfate pentahydrate], or other suitable etchant, and examined at a magnification not lower than 100X to determine conformance to the requirements of 3.7.2.1, 3.7.2.2, 3.7.2.3, and 3.7.2.4.

3.7.2.1 Microstructure: Parts shall have microstructure of completely recrystallized material except in the area of the threads and the head-to-shank fillet radius.

3.7.2.2 Grain Size: Grain size shall be ASTM No. 5 or finer as determined by comparison method of ASTM E 112. Up to 25% of the areas examined may exhibit a grain size as large as ASTM No. 2. Such areas shall be separated by at least 0.025 inch. Bands of fine or coarse grains are not permitted. In case of dispute, the intercept (Heyn) method shall be used.

3.7.2.3 Surface Hardening: Parts shall have no change in hardness from core to surface except as produced during cold rolling of the head-to-shank fillet radius and during rolling of threads. There shall be no evidence of carburization or nitriding. In case of dispute over results of the microscopic examination, microhardness testing shall be used as a referee method; a Vickers hardness reading of an unrolled surface which exceeds the reading in the core by more than 20 points shall be evidence of nonconformance to this requirement.

3.7.2.4 Threads:

3.7.2.4.1 Root defects such as laps, seams, notches, slivers, folds, roughness, and oxide scale are not permissible (see Figure 4).

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3.7.2.4.2 Multiple laps on the flanks of threads are not permissible regardless of location.

3.7.2.4.3 Single Lap on Thread Profile: Shall conform to the following:
(R)

- a. Rateable Lap: Shall have its length equal to or greater than three times its width. The minimum interpretable lap depth is 0.0005 inch when viewed at 200X magnification.
- b. Thread Flank Above the Pitch Diameter: A slight lap is permissible along the flank of the thread above the pitch diameter on either the pressure or nonpressure flank (one lap at any cross-section through the thread) provided it extends toward the crest and is generally parallel to the flank (see Figure 5). The lap depth shall not exceed the limit specified in Table 1 for the applicable thread pitch. A lap extending toward the root is not permissible (see Figure 6).
- c. Thread Flank Below the Pitch Diameter: A lap along the thread flank below the pitch diameter, regardless of direction it extends, is not permissible (see Figure 7).
- d. Crest craters, crest laps, or a crest lap in combination with a crest crater are permissible, provided that the imperfections do not extend deeper than the limit specified in Table 1 as measured from the thread crest when the thread major diameter is at minimum size (see Figure 8). The major diameter of the thread shall be measured prior to sectioning. As the major diameter of the thread approaches maximum size, values for depth of crest crater and crest lap imperfections listed in Table 1 may be increased by one-half of the difference between the minimum major diameter and the actual major diameter as measured on the part.

3.7.3 Fluorescent Penetrant Inspection: Parts shall be subject to fluorescent penetrant inspection in accordance with ASTM E 1417, Type I, Sensitivity Level 2; any plating or coating shall be removed for this inspection.
(R)

3.7.3.1 The following conditions shall be cause for rejection of parts inspected.

3.7.3.1.1 Discontinuities transverse to grain flow (i.e., at an angle of more than 10° to the axis of the shank), such as grinding checks and quench cracks.

3.7.3.1.2 Longitudinal indications (i.e., at an angle of 10° or less to the axis of the shank) due to imperfections other than seams, forming laps, and nonmetallic inclusions.

3.7.3.2 The following conditions shall be considered acceptable on parts inspected.

3.7.3.2.1 Parts having longitudinal indications (i.e., at an angle of 10° or less to the axis of the shank) of seams and forming laps parallel to the grain flow that are within the limits specified in 3.7.3.2.2 through 3.7.3.2.5 provided the separation between indications is not less than 0.062 inch in all directions.

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- 3.7.3.2.2 Sides of Head: There shall be not more than three indications per head. The length of each indication may be the full height of the surface but no indication shall break over either edge to a depth greater than 0.031 inch or the equivalent of the 2H/3 thread depth (see Table 1), whichever is less.
(R)
- 3.7.3.2.3 Shank or Stem: There shall be not more than five indications. The length of any indication may be the full length of the surface but the total length of all indications shall not exceed twice the length of the surface. No indication shall break into a fillet or over an edge.
- 3.7.3.2.4 Threads: There shall be no indications, except as permitted in 3.7.2.4. Rateable lap indications shall conform to 3.7.2.4.3(a).
(R)
- 3.7.3.2.5 Top of Head and End of Stem: The number of indications is not restricted, but the depth of any individual indication shall not exceed 0.010 inch as shown by sectioning representative samples. No indication, except those of 3.7.3.2.2, shall break over an edge.

4. QUALITY ASSURANCE PROVISIONS:**4.1 Responsibility for Inspection:**

The vendor of parts shall supply all samples and shall be responsible for performing all required tests. Purchaser reserves the right to perform such confirmatory testing as deemed necessary to ensure that the parts conform to the requirements of this specification.

**4.2 Responsibility for Compliance:
(R)**

The manufacturer's system for parts production shall be based on preventing product defects, rather than detecting the defects at final inspection and then requiring corrective action to be invoked. An effective manufacturing in-process control system shall be established, subject to the approval of the purchaser, and used during production of parts.

**4.3 Production Acceptance Tests:
(R)**

The purpose of production acceptance tests is to check, as simply as possible, using a method which is inexpensive and representative of the part usage, with the uncertainty inherent in random sampling, that the parts comprising a production inspection lot satisfy the requirements of this specification.

4.3.1 Tests for all technical requirements are acceptance tests and shall be performed on each production inspection lot. A summary of acceptance tests is specified in Table 3.**4.4 Acceptance Test Sampling:****4.4.1 Material: Sampling for material composition on each heat shall be in accordance with AMS 5731.
(R)**

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- 4.4.2 (R) **Nondestructive Test - Visual and Dimensional:** A random sample of parts shall be taken from each production inspection lot; the size of the sample to be as specified in Table 4. The classification of dimensional characteristics shall be as specified in Table 5. All dimensional characteristics are considered defective when out of tolerance.
- 4.4.3 (R) **Fluorescent Penetrant Inspection:** A random sample shall be selected from each production inspection lot; the size of the sample shall be as specified in Table 4 and classified as in Table 5. The sample units may be selected from those that have been subjected to and passed the visual and dimensional inspection, with additional units selected at random from the production inspection lot as necessary.
- 4.4.4 (R) **Stress-Rupture Test:** A random sample of one part (or one specimen where required) shall be selected from each production inspection lot.
- 4.4.5 (R) **Destructive Tests:** A random sample shall be selected from each production inspection lot; the size of the sample shall be as specified in Table 6. The sample units may be selected from those that have been subjected to and passed the nondestructive tests and the fluorescent penetrant inspection, with additional units selected at random from the production inspection lot as necessary.
- 4.4.6 (R) **Acceptance Quality:** Of random samples tested, acceptance quality shall be based on zero defectives.
- 4.4.7 **Test Specimens:** Specimens for tensile and stress-rupture testing of machined test specimens shall be of standard proportions in accordance with ASTM E 8 with either 0.250 inch diameter at the reduced parallel gage section or smaller specimens proportional to the standard when required. Specimens shall be machined from finished parts or coupons of the same lot of alloy and be processed together with the parts they represent. Specimens shall be machined from the center of parts 0.750 inch and under in nominal diameter, from the center of coupons 0.800 inch and under in nominal diameter or distance between parallel sides, and from mid-radius of larger size parts or coupons.
- 4.5 (R) **Reports:**
The vendor of parts shall furnish with each shipment a report stating that the chemical composition of the parts conforms to the applicable material specification, showing the results of tests to determine conformance to the room temperature ultimate tensile property, hardness, double shear test (if required), and stress-rupture requirements, and stating that the parts conform to the other technical requirements. This report shall include the purchase order number, AS7478, lot number, contractor or other direct supplier of material, part number, nominal size, and quantity.

SAE AS7478 Revision A**4.6 Rejected Lots:****(R)**

If a production inspection lot is rejected, the vendor of parts may perform corrective action to screen out or rework the defective parts, and resubmit for acceptance tests inspection as in Table 3. Resubmitted lots shall be clearly identified as reinspected lots.

5. PREPARATION FOR DELIVERY:**5.1 Packaging and Identification:**

5.1.1 Parts having different part numbers shall be packed in separate containers.

5.1.2 Each container of parts shall be marked to show not less than the following information:

(R)

BOLTS (SCREWS), STEEL, CORROSION AND HEAT RESISTANT

AS7478

PART NUMBER

LOT NUMBER

PURCHASE ORDER NUMBER

QUANTITY

MANUFACTURER'S IDENTIFICATION

5.1.3 Threaded fasteners shall be suitably protected from abrasion and chafing during handling, transportation, and storage.

5.1.4 Packaging shall be in accordance with ASTM D 3951.

(R)**6. ACKNOWLEDGMENT:**

A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.

7. REJECTIONS:

Parts not conforming to this specification, or to modifications authorized by purchaser, will be subject to rejection.

8. NOTES:**8.1 Hardness Conversion Tables:****(R)**

Hardness conversion tables for metals are presented in ASTM E 140.

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8.2 Direct U.S. Military Procurement:

Purchase documents should specify the following:

Title, number, and date of this specification

Part number of parts desired

Quantity of parts desired

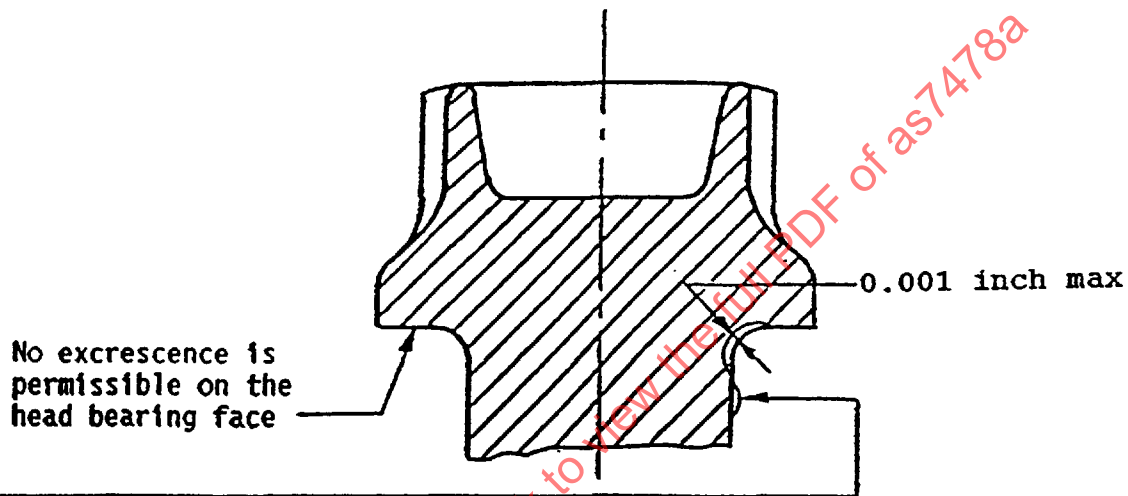
8.3 Key Words:

Bolts, screws, procurement specification

8.4 The (R) 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 specification.

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

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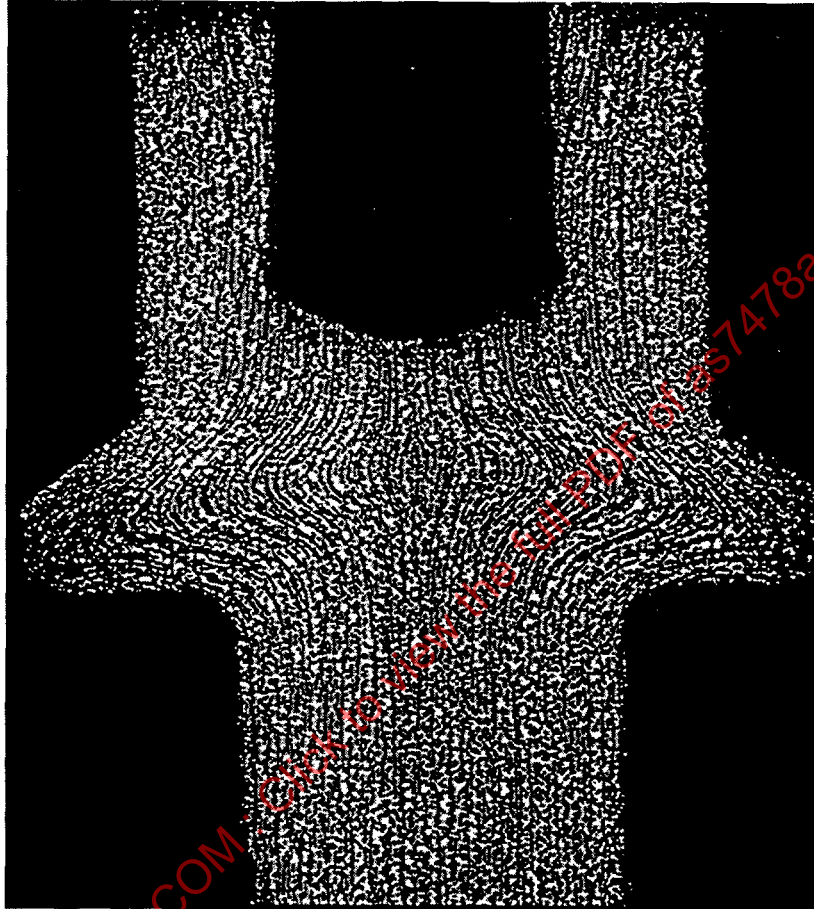


The shank diameter at this position, inclusive of distortion shall:

- On full shank close tolerance bolts, not to exceed the nominal thread diameter.
- On full shank coarse tolerance bolts, not to exceed the actual shank diameter, prior to distortion, by more than 0.0024 inch on diameter.
- On PD shank bolts, not to exceed the actual PD shank diameter, prior to distortion, by more than 0.0024 inch on diameter.

(R) FIGURE 1 - Permissible Distortion from Fillet Working

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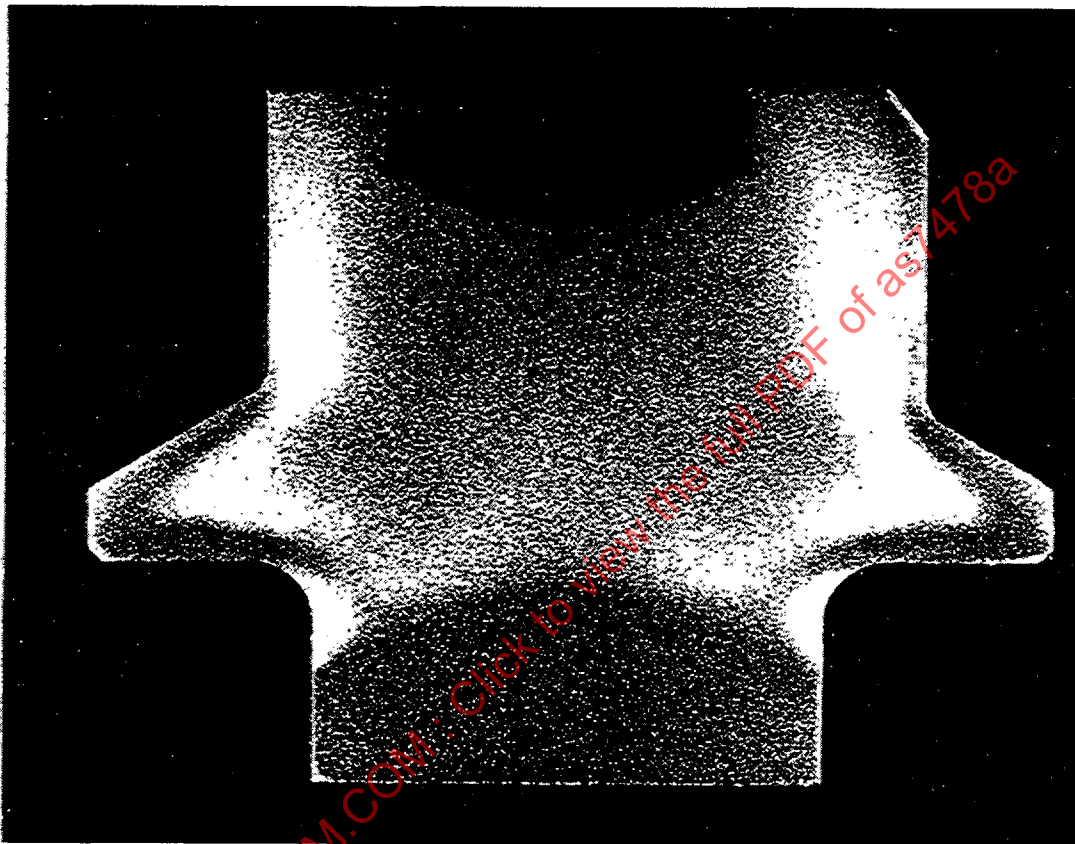


Showing a smooth, well formed grain flow following the contour of the head-to-shank fillet radius.

(R) FIGURE 2A - Satisfactory Grain Flow, Headed Blank, Before Heat Treatment

FIGURE 2

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Shows evidence that head was formed by forging.

(R) FIGURE 2B - Head-to-Shank Section through Finished Part

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FIGURE 3 - Flow Lines, Rolled Thread

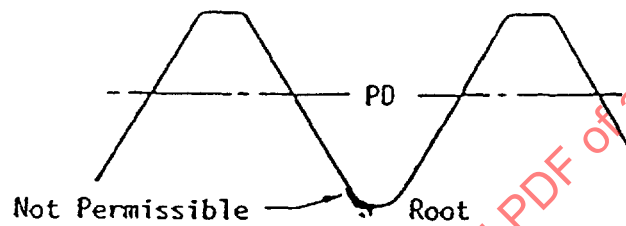
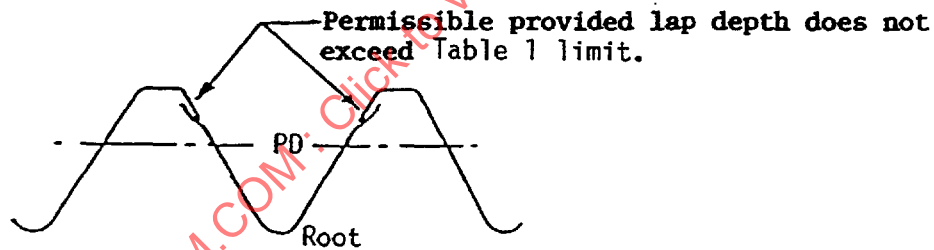
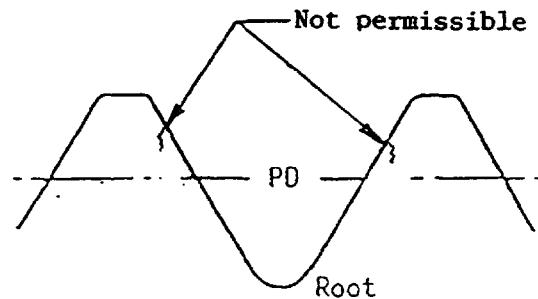


FIGURE 4 - Root Defects, Rolled Thread

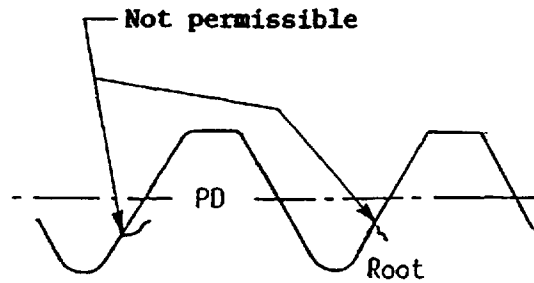


(R) FIGURE 5 - Laps Above Pitch Diameter Extending Towards Crest, Rolled Thread

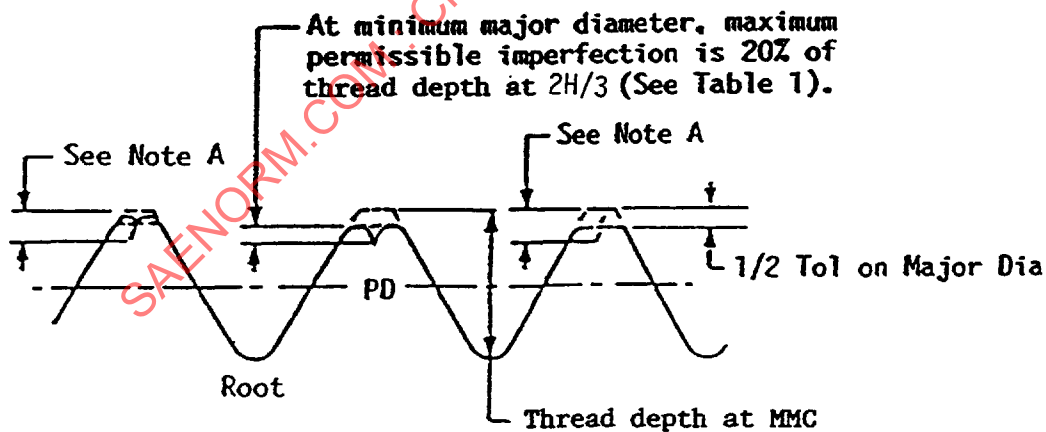


(R) FIGURE 6 - Laps Above PD Extending Toward Root, Rolled Thread

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(R) FIGURE 7 - Laps Below PD Extending in any Direction, Rolled Thread



NOTE A: Maximum depth of imperfection equals 20% of thread depth at $2H/3$ plus $1/2$ the difference of the actual major diameter and minimum major diameter.

(R) FIGURE 8 - Crest Craters and Crest Laps, Rolled Thread

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(R) TABLE 1 - UNJ External Thread Depth at 2H/3 and Allowable Thread Lap Depth

Thread Pitches Per Inch n	UNJ External Thread Depth at 2H/3 inch	Allowable Thread Lap Depth inch
40	0.0144	0.0029
36	0.0160	0.0032
32	0.0180	0.0036
28	0.0206	0.0041
24	0.0241	0.0048
20	0.0289	0.0058
18	0.0321	0.0064
16	0.0361	0.0072
14	0.0412	0.0082
13	0.0444	0.0089
12	0.0481	0.0096
11	0.0525	0.0105
10	0.0577	0.0115
9	0.0642	0.0128
8	0.0722	0.0144

NOTE: Allowable lap depth is based upon 20% of UNJ external thread depth at 2H/3 in accordance with MIL-S-8879, and is calculated as follows:

$$\begin{aligned}\text{Ext thd depth} &= 2H/3 = (2/3)(\cos 30^\circ)/n = 0.57735/n \\ \text{Lap depth} &= 0.2(2H/3) = 0.2(2/3)(\cos 30^\circ)/n = 0.11547/n\end{aligned}$$