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NOTE: This drawing was approved by joint action of the Air Force and Navy Departments as the Air Force-Navy standard for this product. This drawing supersedes all antecedent standard drawings for the same product and shall be used for the procurement of commercial supplies, or for use in new design, not later than 6 months after the latest date of approval shown.

FSC 5340

(3) L.H. THREAD 1/2-20UNF-3A IN ACCORDANCE WITH H-28

MAXIMUM TWO IMPERFECT THREADS EACH END

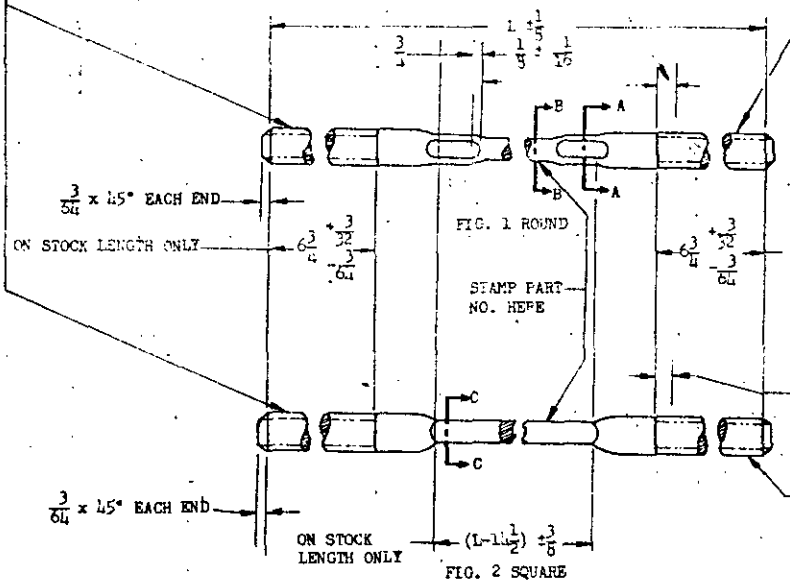
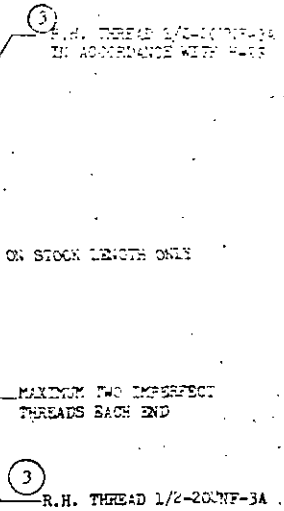



FIG. 2 SQUARE




STANDARD DESIGN

| DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L | DASH NO. | L |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 24 | 24 | 60 | 60 | 96 | 96 | 132 | 132 | 168 | 168 | 204 | 204 | 240 | 240 | 276 | 276 | 312 | 312 | 348 | 348 | 384 | 384 |
| 33 | 33 | 69 | 69 | 105 | 105 | 141 | 141 | 177 | 177 | 213 | 213 | 249 | 249 | 285 | 285 | 321 | 321 | 357 | 357 | 393 | 393 |
| 42 | 42 | 78 | 78 | 114 | 114 | 150 | 150 | 186 | 186 | 222 | 222 | 258 | 258 | 294 | 294 | 330 | 330 | 366 | 366 | 402 | 402 |
| 51 | 51 | 87 | 87 | 123 | 123 | 159 | 159 | 195 | 195 | 231 | 231 | 267 | 267 | 303 | 303 | 339 | 339 | 375 | 375 | | |

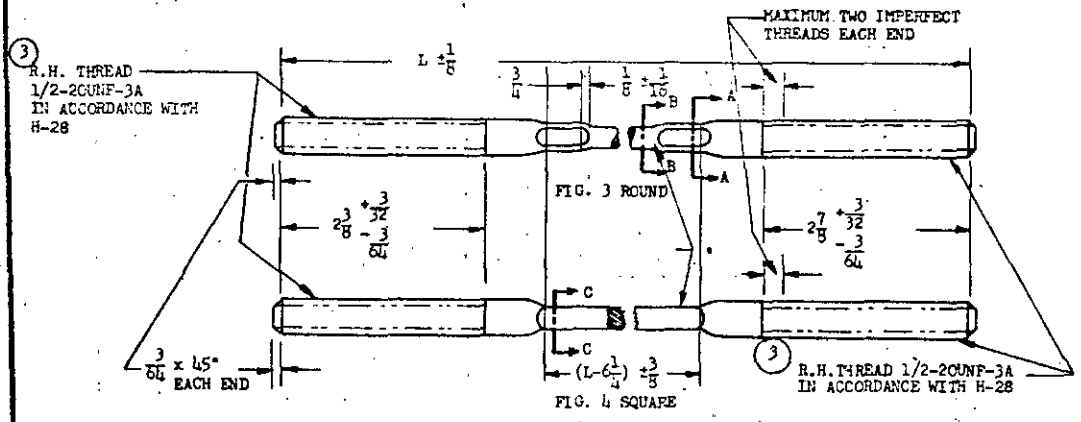



FIG. 4 SQUARE

ALTERATION DESIGN

MATERIAL: CARBON STEEL. CORROSION RESISTING STEEL. SEE PROCUREMENT SPECIFICATION.

(3) FINISH: CADMIUM PLATE, QQ-P-416, TYPE II, CLASS 3.

THREAD: MINIMUM THREAD FOR RIGID TERMINAL AND LOCK NUT 2-3/8. AIRPLANE MANUFACTURERS ARE PERMITTED TO INSTALL RODS WITH MINIMUM LENGTH OF THREADS AS INDICATED IN ALTERNATE DESIGN, ON AIRPLANES SUPPLIED ON GOVERNMENT ORDERS.

LENGTH "L" SHALL BE THE NEAREST 25/100, AS 1825, 1850, 1875, 19, 1925 TO FIT, FIGURING 50% TAKE UP AND 50% LET OUT. TO FIND ROD LENGTH SUBTRACT 2-7/8 FROM LENGTH BETWEEN PIN CENTERS OF ASSEMBLY.

CUT OFF EQUAL AMOUNT FROM EACH END OF STANDARD DESIGN STOCK SIZES FOR INTERMEDIATE LENGTHS.

PART NO. SHALL INDICATE THE EXACT LENGTH OF ROD WITH LETTER "A" AFTER BASIC NO. FOR THE ALTERNATE DESIGN.

RODS OF THE STANDARD DESIGN, WHICH WILL BE USED FOR REPLACEMENT PURPOSES, WILL BEAR THE SAME NO. AS THOSE OF THE ALTERNATE DESIGN, WITHOUT THE LETTER "A".

FOR CORROSION RESISTING STEEL RODS INSERT "C" BEFORE DASH NO.

EXAMPLE OF PART NOS.: AN708A3050 = 1/2-20 ROD, 30-1/2 INCH LONG, ALTERNATE DESIGN, CARBON STEEL.
AN708-3050 = 1/2-20 ROD, 30-1/2 INCH LONG, STANDARD DESIGN, CARBON STEEL.
AN708C3050 = 1/2-20 ROD, 30-1/2 INCH LONG, STANDARD DESIGN, CORROSION RESISTING STEEL.

REMOVE ALL BURRS AND SHARP EDGES.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ON FRACTIONS ±1/64, DECIMALS ±.010, ANGLES ±1/2°.

APPROVED 3 Sep 42 REVISED (1) 24 Jun 43 (2) 8 May 51 (3) 15 JUN 66 (4) 6 AUG 82

CANCELED AFTER 6 AUG 82, NO SUPERSEDING STANDARD,

| PROCUREMENT SPECIFICATION | AIR FORCE-NAVY AERONAUTICAL STANDARD | AN708 |
|---|---|---|
| MIL-T-5684 | TIE ROD—INTERNAL 15,500 LB (1/2-20) | |

SUPERSEDES FORMER ARMY AND NAVY STANDARD ISSUES OF AN708