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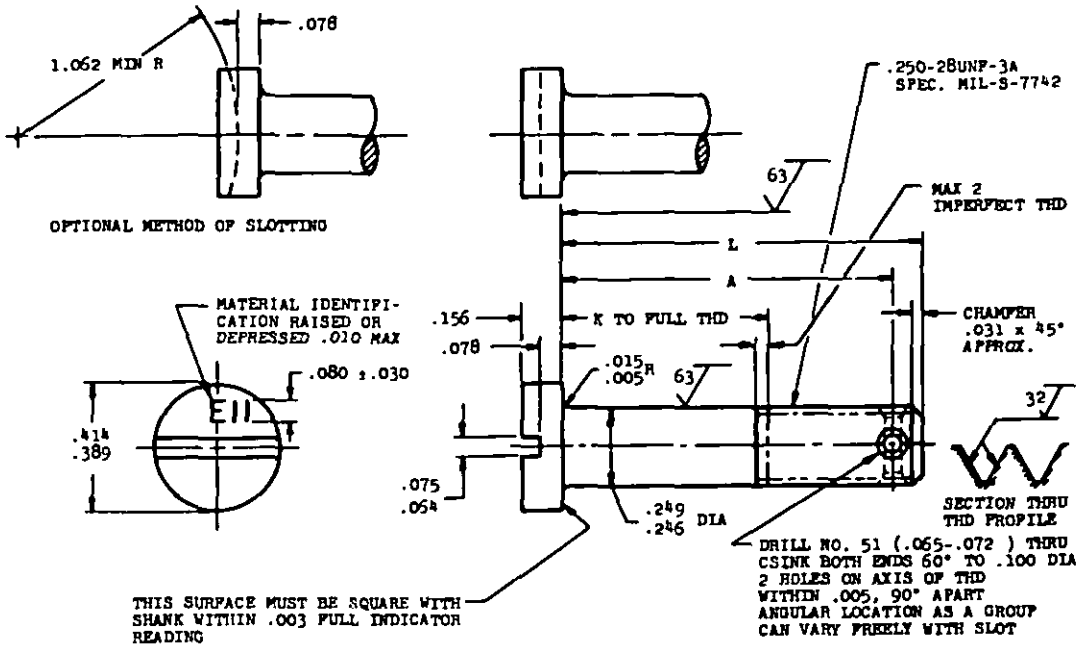

L	A	K +.000 -.050	PART NO.	L	A	K +.000 -.050	PART NO.	L	A	K +.000 -.060	PART NO.
.562	.452	(a)	AN115655	1.312	1.202	.688	AN115667	2.375	2.265	1.750	AN115679
.625	.515	(a)	AN115656	1.375	1.255	.750	AN115668	2.500	2.390	1.875	AN115680
.688	.578	(a)	AN115657	1.438	1.328	.812	AN115669	2.625	2.515	2.000	AN115681
.750	.640	.125	AN115658	1.500	1.390	.875	AN115670	2.750	2.640	2.125	AN115682
.812	.702	.188	AN115659	1.562	1.452	.938	AN115671	2.875	2.765	2.250	AN115683
.875	.765	.250	AN115660	1.625	1.515	1.000	AN115672	3.000	2.890	2.375	AN115684
.938	.828	.312	AN115661	1.688	1.578	1.062	AN115673				
1.000	.890	.375	AN115662	1.750	1.640	1.125	AN115674				
1.062	.952	.438	AN115663	1.875	1.765	1.250	AN115675				
1.125	1.015	.500	AN115664	2.000	1.890	1.375	AN115676				
1.188	1.078	.562	AN115665	2.125	2.015	1.500	AN115677				
1.250	1.140	.625	AN115666	2.250	2.140	1.625	AN115678				

(a) THREAD TO HEAD. MAXIMUM TWO IMPERFECT THREADS.

NOTE: (1) THE RUNOUT FOR STRAIGHTNESS OF SHANK SHALL NOT EXCEED .003 FIR PER INCH OF SCREW LENGTH.
(2) THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 FIR.
(3) THE CONCENTRICITY OF THE SHANK IN RELATION TO THE HEAD SHALL BE WITHIN .010 FIR.

MATERIAL: STEEL AMS 6322

HARDNESS: ROCKWELL C26-32

FINISH: CADMIUM PLATE AMS 2400

SURFACE ROUGHNESS: AS 107

MANUFACTURING SPECIFICATION: AMS 7452

(3) INSPECTION: ALL PARTS SHALL UNDERGO MAGNETIC INSPECTION IN ACCORDANCE WITH AMS2640.

BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED: TOLERANCES; LINEAR DIMENSIONS ±.010.

DO NOT USE UNASSIGNED PART NUMBERS.

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER STANDARD PARTS COMMITTEE OF THE SAE.

APPROVED 8 Jun 49 REVISED (1) 4 Oct 54 (2) 1 Aug 55 (3) 30 June 1986

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P.A.
USAF - 11
Other Cust
Navy - AS
Army - AV

AIR FORCE-NAVY AERONAUTICAL STANDARD

SCREW - FLAT FILLISTER HEAD, DRILLED SHANK, .250-28

AN115651 THRU AN115700

Project No. 5305-1640