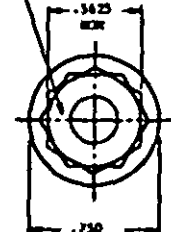


MARK PART NUMBER
AND MANUFACTURER'S IDENT
PER AS 470 CLASS A

WEIGHING CONFIGURATION
PER AS 870 FOR
STES. 220-100



CHAPTER
23⁰- 37⁰
TD .362 GLA

39° NIN TO ROOT
OF DOUBLE EXPOSURE

SECTION 2
UNCLASSIFIED
THERADS
(SEE NOTE 4)

047 - 43

SECTION THRU
THREAD PROFILE

PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100	PART NO.	L	K	APPROX. WEIGHT LB/100
K27890-04	.812	.103-.125	7.99	K27890-22	1.938	.428-.668	13.53	K27890-40	4.125	2.815-2.875	26.27
K27890-05	.873	.103-.125	8.25	K27890-23	2.000	.690-.750	13.84	K27890-41	4.250	2.940-3.000	28.88
K27890-06	.933	.103-.125	8.59	K27890-24	2.125	.815-.875	14.45	K27890-42	4.375	3.065-3.125	25.49
K27890-07	1.000	.103-.125	8.90	K27890-25	2.250	.940-1.000	13.06	K27890-43	4.500	3.190-3.250	28.10
K27890-08	1.062	.103-.125	9.22	K27890-26	2.375	1.065-1.125	13.48	K27890-44	4.625	3.315-3.375	28.71
K27890-09	1.125	.103-.125	9.54	K27890-27	2.500	1.190-1.250	16.20	K27890-45	4.750	3.440-3.500	27.32
K27890-10	1.188	.103-.125	9.86	K27890-28	2.625	1.315-1.375	16.91	K27890-46	4.875	3.565-3.625	27.96
K27890-11	1.250	.103-.125	10.18	K27890-29	2.750	1.440-1.500	17.32	K27890-47	5.000	3.690-3.750	28.59
K27890-12	1.312	.103-.125	10.48	K27890-30	2.875	1.565-1.625	18.13	K27890-48	5.125	3.815-3.875	29.20
K27890-13	1.375	.103-.125	10.78	K27890-31	3.000	3.690-3.750	18.74	K27890-49	5.250	3.940-4.000	29.81
K27890-14	1.438	.125-.148	11.09	K27890-32	3.125	1.815-1.875	19.35	K27890-50	5.375	4.065-4.125	30.42
K27890-15	1.500	.190-.250	11.40	K27890-33	3.250	1.940-2.000	19.96	K27890-51	5.500	4.190-4.250	31.03
K27890-16	1.562	.253-.312	11.71	K27890-34	3.375	2.065-2.125	20.58	K27890-52	5.625	4.315-4.375	31.64
K27890-17	1.625	.315-.375	12.02	K27890-35	3.500	2.190-2.250	21.20	K27890-53	5.750	4.440-4.500	32.25
K27890-18	1.688	.378-.438	12.33	K27890-36	3.625	2.315-2.375	21.81	K27890-54	5.875	4.565-4.625	32.86
K27890-19	1.750	.440-.500	12.64	K27890-37	3.750	2.440-2.500	22.42	K27890-55	6.000	4.690-4.750	33.47
K27890-20	1.812	.502-.562	12.95	K27890-38	3.875	2.565-2.625	23.04				
K27890-21	1.875	.565-.625	13.26	K27890-39	4.000	2.690-2.750	23.66				

1. CHAIR SHALL BE STRAIGHT WITHIN .002 PER INCH OF BOLT LENGTH.
2. THE CONCENTRICITY OF TREAD PD IS RELATION TO THE CHAIR SHALL BE WITHIN .006 DIA.
3. THE CONCENTRICITY OF THE CHAIR IS RELATION TO THE WALKER FACE DIAMETER AND DOUBLE HEADS OF SHALL BE WITHIN .012 DIA.
4. UNCOMPLETE TREADS GO TO OTHER FILLET.
5. MATERIAL: CORROSION RESISTANT STEEL A516.
6. MANUFACTURING SPECIFICATIONS: A516 EXCEPT HEAD SHALL BE UPSET.
7. HEAD TO CHAIR FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
8. FINISHING: ROCKWELL C12-14.
9. SURFACE FINISH: PER A44.1-1941. UNLESS OTHERWISE SPECIFIED, SURFACE TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
10. MAGNETIC PARTICLE INSPECTION PER A54.1940.
11. BREAK CHAIR EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN DOWNS. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS: $\pm .010$, ANGULAR DIMENSIONS: $\pm 3^\circ$.
13. DO NOT USE UNFINISHED PARTS OTHERS.

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THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AIRSPACE PART STANDARDS DIVISION.

P.A. MAP - 11	TITLE	MILITARY STANDARD
Other Code	SOIL, MACHINE - DOUBLE HELIXON EXTENDED WARRIOR HEAD, AND 5416, .500-20 CSRP-3A	MS 9890 (ASG)
Draw - A3		
PROCUREMENT SPECIFICATION	SUPPLEMENT	SHEET 1 OF 1

Very - R. M. M.

This military standard is approved by the Department of the Air Force and is necessary for use by these military activities are required to employ this standard where suitable.

QTTIAN **69 JIN (GAOHONG)**