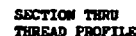


MSGS

5305



Review activities:

USAF - 82, 85

1. SHANK SHALL BE STRAIGHT WITHIN .003 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 WASHER FACE DIAMETER AND DOUBLE HEXAGON OD SHALL BE WITHIN .005 FIR.
4. INCOMPLETE THREADS NOT TO ENTER FILLET.
5. MATERIAL: CORROSION RESISTANT STEEL AMS 5616.
6. MANUFACTURING SPECIFICATION: AMS 7470 EXCEPT HEAD SHALL BE UPSET.
7. HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
8. HARDNESS: ROCKWELL C32-38.
9. SURFACE TEXTURE: USAS B46.1-1962. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES EXCEPT UPSET HEAD.
10. MAGNETIC PARTICLE INSPECTION PER AMS 2640.
11. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$.
13. DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PROPULSION DIVISION.

DD FORM 672-1 (Revised coordination)
ASI use only

*REVIEWED UNDER VANDERBILT'S POLICY ON CONFLICT OF INTEREST

5305 - 7008

APPROVED **21 Apr 69** **REVISED**