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RATIONALE

LIMITED SCOPE TO REVISE AND CLARIFY NOTE 2B FOR THE PERMISSIBLE PLATING PRETREATMENT THAT MAY INCLUDE BOTH COPPER AND NICKEL WITH THICKNESS TO .00025 INCH MAX FOR CONSISTENCY WITH AS8879 PERMITTED TOLERANCE FOR PITCH DIAMETER INCREASE OF .0010 INCH

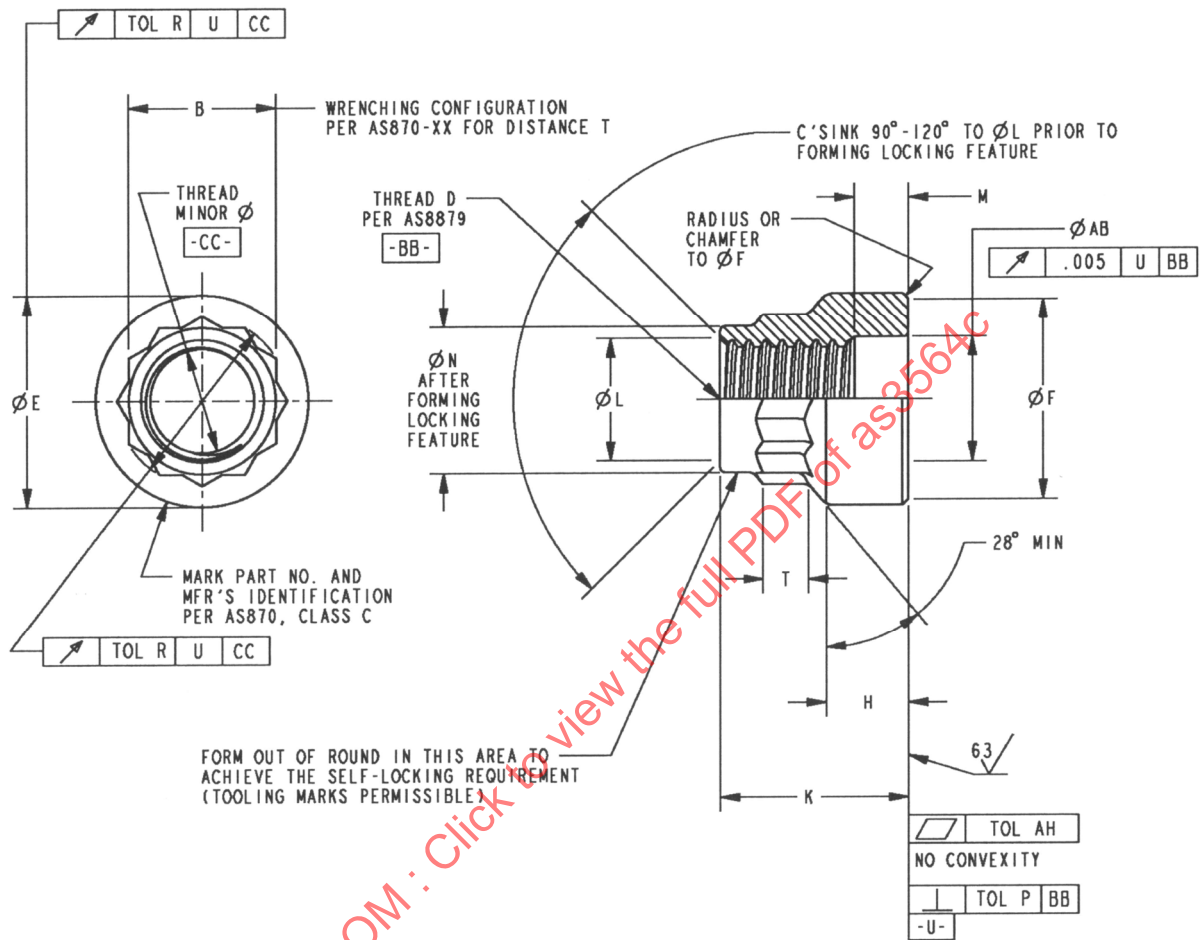
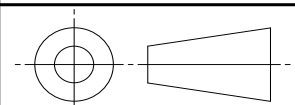


FIGURE 1 – NUT

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THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION:

SAE Aerospace
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AEROSPACE STANDARD

NUT, SELF-LOCKING, DOUBLE HEXAGON, SOLID
FILM LUBRICATED, COUNTERBORED,
160 KSI, 800 °F, UNS S66286

SAE AS3564
SHEET 1 OF 3

REV.
C

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TABLE 1A – DIMENSIONS

PART NUMBER	THREAD D	B NOM	DASH NO.	ØE MAX	ØF MIN	ØAB	H MIN	K MAX
AS3564-09	.1900-32UNJF-3B	.2500	08	.340	.325	.200-.210	.125	.400
AS3564-10	.2500-28UNJF-3B	.3125	10	.450	.410	.260-.270	.170	.510
AS3564-11	.3125-24UNJF-3B	.3750	12	.525	.495	.323-.333	.175	.580
AS3564-12	.3750-24UNJF-3B	.4375	14	.600	.560	.385-.395	.195	.645
AS3564-13	.4375-20UNJF-3B	.5625	18	.690	.650	.448-.458	.220	.745
AS3564-14	.5000-20UNJF-3B	.6250	20	.780	.740	.510-.525	.240	.830
AS3564-15	.5625-18UNJF-3B	.6875	22	.880	.840	.573-.583	.270	.928
AS3564-16	.6250-18UNJF-3B	.7812	25	.970	.925	.635-.645	.290	1.020
AS3564-17	.7500-16UNJF-3B	.9375	30	1.230	1.180	.760-.770	.320	1.222

TABLE 1B – DIMENSIONS

PART NUMBER	ØL	ØM MAX	ØN MAX	T MIN	P	R	AH	APPROX MASS LB/100
AS3564-09	.190-.210	.085-.105	.262	.082	.004	.006	.0014	.44
AS3564-10	.250-.270	.100-.120	.326	.130	.005	.007	.0014	.77
AS3564-11	.312-.332	.115-.135	.392	.170	.005	.008	.0016	1.22
AS3564-12	.375-.395	.115-.135	.458	.210	.005	.009	.0016	1.90
AS3564-13	.438-.458	.140-.160	.588	.230	.005	.010	.0020	3.31
AS3564-14	.500-.520	.140-.160	.654	.260	.006	.012	.0020	4.42
AS3564-15	.562-.582	.160-.180	.720	.320	.006	.014	.0020	7.96
AS3564-16	.625-.645	.160-.180	.817	.370	.007	.015	.0020	10.80
AS3564-17	.750-.770	.180-.200	.980	.500	.007	.016	.0020	19.57

NOTES:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL PER AMS5731 OR AMS5734 (UNS S66286).

HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE HEAT TREATED PER AMS2759/3 TO MEET THE HARDNESS SPECIFIED IN NOTE 3.

2. PROCUREMENT SPECIFICATION: AS4393 EXCEPT AS FOLLOWS:

- a. COATING: SOLID FILM LUBRICANT PER AS1701, TYPE VI, IN LIEU OF SILVER PLATE PER AMS2411.
- b. PRETREATMENT: PRIOR TO APPLYING THE SOLID FILM LUBRICANT, NUTS MAY BE PLATED WITH COPPER (AMS2418) OR NICKEL (AMS2403) OR BOTH TO .00025 MAXIMUM THICKNESS.
- c. DIMENSIONS APPLY AFTER PRETREATMENT PLATING AND BEFORE COATING WITH SOLID FILM LUBRICANT.
- d. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F FOR NUTS TESTED AFTER BAKE.

3. HARDNESS: 32 -42 HRC.

4. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

5. FLUORESCENT PENETRANT INSPECTION PER ASTM E 1417, TYPE 1, SENSITIVITY LEVEL 2, PRIOR TO PRETREATMENT OR COATING. ACCEPTANCE CRITERIA PER AS3071.

6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 µin Ra.

 An SAE International Group	AEROSPACE STANDARD	 AS3564 SHEET 2 OF 3	REV. C
	NUT, SELF-LOCKING, DOUBLE HEXAGON, SOLID FILM LUBRICATED, COUNTERBORED, 160 KSI, 800 °F, UNS S66286		