REV.

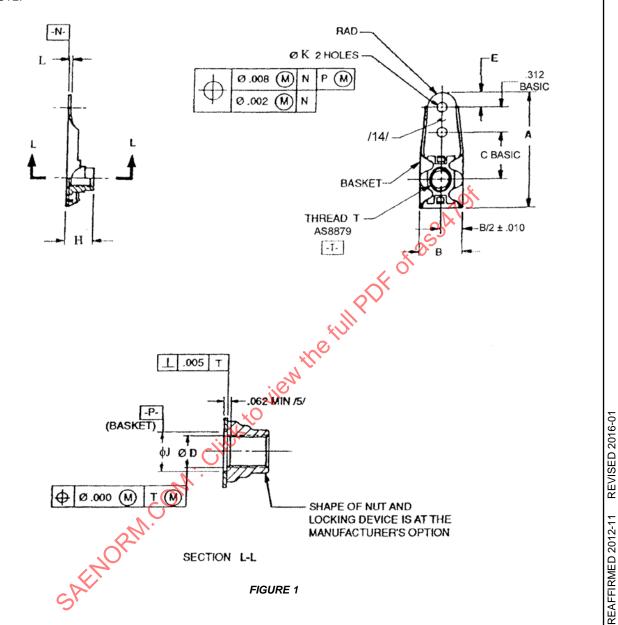
√S3479™

reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions. SAE reviews each technical report at least every five years at which time it may be revised,

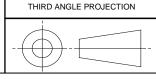
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RATIONALE

UPDATE PASSIVATION REQUIREMENTS PER AMS2700, DELETE REDUNDANT NOTE, AND ADD INVENTORY USE NOTE.



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CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS4393 /4/



AEROSPACE STANDARD

NUT, SELF-LOCKING, PLATE, ONE LUG, FLOATING, LOW HEIGHT, UNS S66286, CLASS: 125 KSI/800 °F **AS3479™** SHEET 1 OF 3 REV. F

1991-02

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TABLE 1

											AXIAL	
								ØK			STRENGTH	APPROX
PART	Т	Α		С	ØD	Е	Н	+.005		L	LBF/MIN	MASS
NUMBER	THREAD	MAX	В	BASIC	MIN	MIN	MAX	000	ØJ	MAX	REF	LB/100
AS3479-01	.1380-32UNJC-3B	1.051	.290422	.344	_	.100	.203	.098	.198270	.032	1130	.53
AS3479-02	.1640-32UNJC-3B	1.051	.290422	.344	.168	.100	.250	.098	.224270	.032	1720	.54
AS3479-03	.1900-32UNJF-3B	1.051	.290422	.344	.194	.100	.250	.098	.250270	.032	2460	.56
AS3479-04	.2500-28UNJF-3B	1.306	.350531	.500	.254	.100	.281	.098	.310330	.045	4580	1.00
AS3479-05	.3125-24UNJF-3B	1.396	.412641	.500	.317	.125	.328	.130	.372392	.045	7390	1.44

NOTES:

- MATERIAL:
 - NUT: CORROSION AND HEAT RESISTANT STEEL AMS5525, AMS5731, OR AMS5734.
 - BASKET: CORROSION AND HEAT RESISTANT STEEL AMS5525.
- HEAT TREATMENT: AFTER FORMING, PLATE NUTS SHALL BE PRECIPITATION HEATED TO A HARDNESS NOT TO EXCEED THAT SPECIFIED IN NOTE 6.
- FINISH:
 - NUT: PASSIVATE PER AMS2700 METHOD 1, TYPE 2 OR TYPE 8 FOLLOWED BY SILVER PLATE PER AMS2411: SILVER PLATE ONLY ON THREADS, EXCEPT: COVERAGE OF THE THREAD CHAMPERS AND COUNTERBORE IS OPTIONAL AND MINIMUM THICKNESS IS NOT A REQUIREMENT. NO SILVER SHALL ENCROACH ON THE SEATING SURFACES.
 - BASKET: PASSIVATE PER AMS2700 METHOD 1, TYPE 2 OR TY
- PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS FOLLOWS:
 - BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F ± 15 °F FOR NUTS TESTED AFTER BAKE.
- SIZE -01 MAY BE COUNTERSUNK OR RADIUSED WITHIN H. SIZE -02 AND LARGER SHALL BE COUNTERBORED TO ØD TO .062 MINIMUM DEPTH.
- HARDNESS: 45 HRC MAXIMUM.
- RADIAL FLOAT OF NUT THREADS RELATIVE TO BASKET ØJ, .030 MINIMUM.
- UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- BASKET REMOVE BURRS AND SHARP EDGES; NUT BREAK SHARP EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
- 10. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
- 11. DIMENSIONING AND TOLERANCING: ANSI Y14.5M-1982 (ASME PUBLICATION).
- 12. DIMENSIONS ARE IN INCHES.
- 13. DO NOT USE UNASSIGNED PART NUMBERS.

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SHEET 2 OF 3

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