

AEROSPACE STANDARD	AS54471™	ISSUE 3
	Issued 1990-03 Revised 2003-06	
Nut, Self Locking, Shank, Flange Restrained, 0.2500-28 UNJF-3B ISO3161. Based on AS44751 with 2g, 5g, 12g and 18g of Additional Mass		

NOTE: The issue status of this document remains unchanged as there have been no changes to the technical content.

SAE INDUSTRY TECHNOLOGIES CONSORTIA AEROSPACE STANDARDS AND PART QUALIFICATION PROGRAM

FOREWORD

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SOCIETY OF BRITISH AEROSPACE COMPANIES STANDARD

**NUT, SELF LOCKING, SHANK, FLANGE RESTRAINED,
0.2500-28UNJF-3B ISO3161. BASED ON AS44751 WITH
2g, 5g, 12g AND 18g OF ADDITIONAL MASS.**

AS54471

SHEET 1 OF 3

3RD ANGLE PROJECTION	SHEET No	1	2	3
	ISSUE	3	3	1
	DATE	JUNE 03	JUNE 03	JUNE 03

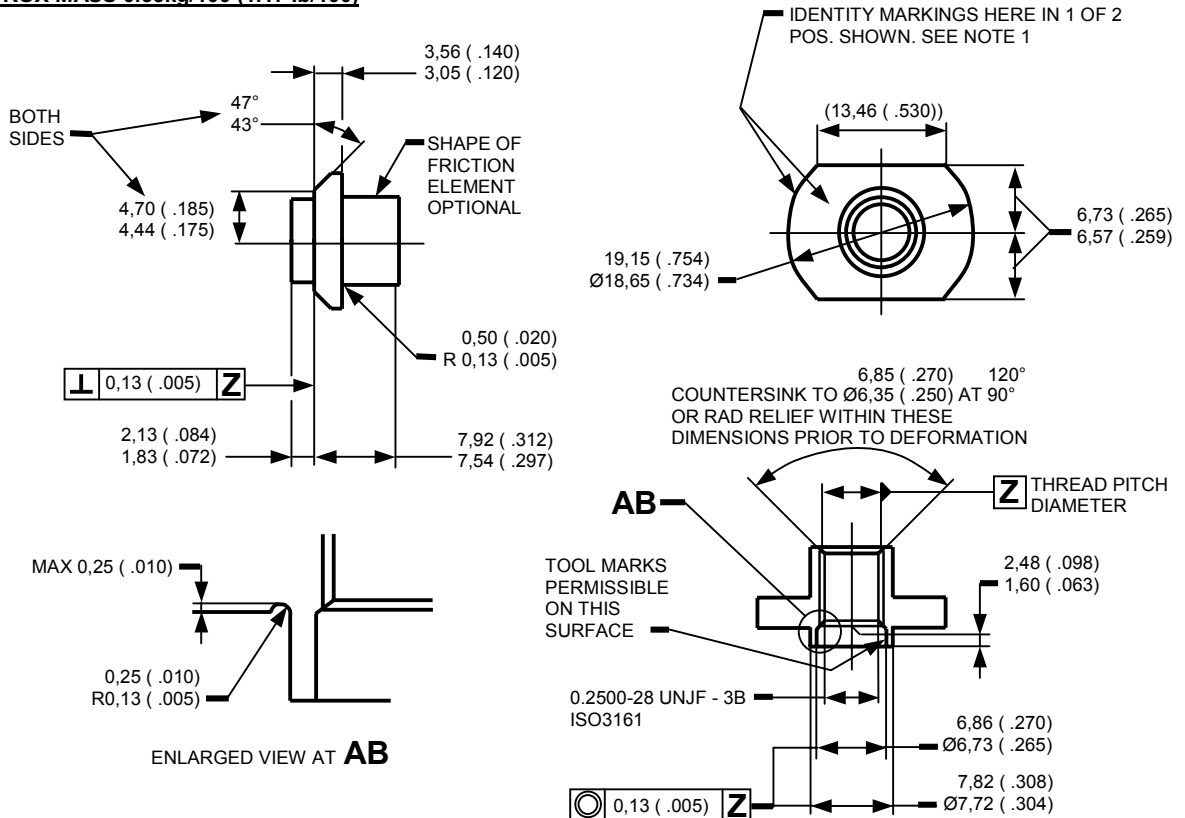
AS54471-2

APPROX MASS 0.53kg/100 (1.17 lb/100)

PRINTED IN ENGLAND

ISSUED IN ACCORDANCE WITH THE TERMS OF THE
FORWARD TO SBAC AEROSPACE INDUSTRY STANDARDS

ORIGINAL PAPER SIZE ISO A4 210 x 297 mm



- MARK PART NO. AS54471-2, -5, -12 OR -18 AS APPROPRIATE AND MANUFACTURER'S IDENTITY CODE AS GIVEN IN TS200 TO SBAC SPEC RS610, METHOD 2 WHERE INDICATED. MANUFACTURER'S IDENTITY CODE TO FOLLOW PART NO.
- PERFORMANCE : TS128
- MATERIAL : CORROSION RESISTANT STEEL BSHR650 OR AMS5737
- FINISH : SILVER COAT TO DTD939 (AMS2411), COATING THICKNESS 0,005 (0.0002) TO 0,015 (0.0006). THE COATING THICKNESS SHALL NOT BE LESS THAN 0,005 (0.0002) MEASURED AT THE PITCH DIAMETER
- DIMENSIONS AND TOLERANCES EXCEPT FOR THREADS ARE IN MILLIMETRES. INCH CONVERSIONS ARE IN PARENTHESES. ALL DIMENSIONS APPLY AFTER COATING.
- BREAK SHARP EDGES 0,08 (.003) TO 0,38 (.015) UNLESS OTHERWISE SPECIFIED.
- SURFACE TEXTURE : BS1134 ALL UNSPECIFIED SURFACES 3,2 MICROMETRES (125 MICROINCHES).
- SCREW THREADS : ISO3161
- CRACK TEST TO DTD929 OR BS M39 BEFORE COATING.
- DRAWING PRACTICE TO TS66
- FOR LIST OF QUALIFIED SUPPLIERS REFER TO TS200
- DO NOT USE UNASSIGNED PART NUMBERS.
- APPLICATION : UPPER THREAD PORTION DEFORMED TO DEVELOP SPECIFIED LOCKING TORQUE WHEN USED ON STANDARD CLASS 3A UNIFIED THREADS.

RS AND TS ARE SBAC PUBLICATIONS
BS ARE BRITISH STANDARDS INSTITUTION PUBLICATIONS
DTD ARE MINISTRY OF DEFENCE (PROCUREMENT EXECUTIVE) PUBLICATIONS
AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS INC, USA PUBLICATIONS
ASTM ARE AMERICAN SOCIETY FOR TESTING MATERIALS PUBLICATIONS.

PREPARED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD TECHNICAL STANDARDS GROUP

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