

AS14227 REV. E IS A FIVE-YEAR REVIEW.



REV.
E

Full document details: [SAE AS14227E](#)

REQUIREMENTS:

1. MATERIAL: STEEL CASTING - 17-4PH IN ACCORDANCE WITH AMS5343.
2. HEAT TREATMENT: CASTING - IN ACCORDANCE WITH AMS5343, 38 TO 45 HRC.
3. INSPECTION: 17-4PH (CASTING) PENETRANT INSPECT IN ACCORDANCE WITH ASTM E1417, TYPE I, METHOD OPTIONAL, SENSITIVITY LEVEL 2 OR HIGHER. AQL SHALL BE .65 IN ACCORDANCE WITH ANSI/ASQ Z1.4, INSPECTION LEVEL II. ACCEPTANCE CRITERIA PER MIL-STD-1907, GRADE D.
4. FINISH: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 OR ZINC NICKEL PLATE PER AMS2417, TYPE 2, GRADE B. PARTS SHALL BE PLATED WITH CADMIUM UNLESS OTHERWISE SPECIFIED. IF ZINC NICKEL IS REQUIRED, ADD SUFFIX "E" TO THE AS PART NUMBER.
5. SURFACE TEXTURE: ALL SURFACES SHALL BE 125 MICROINCHES Ra MAXIMUM IN ACCORDANCE WITH ASME B46.1, UNLESS OTHERWISE SPECIFIED.
6. FLATNESS: WASHER FACES SHALL BE FLAT TO WITHIN .005 INCHES.

TABLE 1 - ROD END LOCK DIMENSIONS

DASH NO.	TERMINAL THREAD SIZE (REF)	ØA	ØB +.02 -.00	C	D ±.016	E ±.016	F ±.031
4	.2500-28 UNJF-3A	.272 ± .005	.44	.214 ± .005	.406	.500	.125
5	.3125-24 UNJF-3A	.334 ± .005	.50	.273 ± .005	.484	.578	.125
6	.3750-24 UNJF-3A	.396 ± .008	.56	.327 ± .008	.562	.656	.125
7	.4375-20 UNJF-3A	.459 ± .008	.63	.386 ± .008	.625	.719	.125
8	.5000-20 UNJF-3A	.520 ± .008	.75	.450 ± .008	.719	.813	.156
9	.5625-18 UNJF-3A	.583 ± .008	.88	.496 ± .010	.812	.906	.188
10	.6250-18 UNJF-3A	.647 ± .010	1.00	.559 ± .010	.937	1.031	.188
12	.7500-16 UNJF-3A	.772 ± .010	1.12	.681 ± .010	1.062	1.156	.188
14	.8750-14 UNJF-3A	.897 ± .010	1.31	.795 ± .010	1.250	1.344	.188
16	1.0000-12 UNJF-3A	1.022 ± .010	1.50	.918 ± .010	1.422	1.516	.188
18	1.1250-12 UNJF-3A	1.147 ± .010	1.62	1.028 ± .010	1.547	1.656	.219

TABLE 1 - ROD END LOCK DIMENSIONS (CONTINUED)

DASH NO.	G RAD	H RAD	J ±.005	K	L +.000 -.015	M ±.005	N RAD +.010 -.000	ØP ±.005	T ±.005
4	.094	.094	.052	.026±.005	.280	.046	.005	.062	.050
5	.094	.094	.052	.026±.005	.342	.046	.005	.062	.050
6	.094	.094	.082	.041±.005	.404	.046	.015	.062	.050
7	.094	.094	.082	.041±.005	.467	.059	.015	.062	.063
8	.094	.156	.082	.041±.005	.528	.059	.015	.062	.063
9	.094	.156	.114	.057±.005	.591	.067	.015	.071	.071
10	.094	.188	.114	.057±.005	.655	.067	.015	.071	.071
12	.094	.188	.114	.057±.005	.780	.067	.015	.071	.071
14	.094	.250	.142	.071±.007	.905	.076	.015	.080	.080
16	.094	.250	.142	.071±.007	1.030	.084	.015	.090	.090
18	.109	.313	.174	.087±.007	1.155	.084	.015	.090	.090

- /1/ THE FLAT SURFACE OF THE LOCKING ELEMENT SHALL EXTEND TO DIAMETER B.
/2/ DIMENSIONS TO BE MET AFTER PLATING.

	AEROSPACE STANDARD		AS14227™ SHEET 2 OF 4	REV. E
	LOCK, ROD END, IMPROVED STRENGTH, NAS LUG			





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