SAE ITC
An SAE International Affiliate

AEROSPACE STANDARD

AS27830™ - AS27832™	ISSUE 2
Issued 1971-11 Revised 1988-11	

Nut, Self-Locking, Six-Point, Captive Washer. Source Control Drawing

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

On the 1st January 2015 the SAE Industry Technologies Consortia (SAE ITC) acquired the ADS Aerospace Standards, previously known as the Society of British Aerospace Companies (SBAC) Aerospace Standards. The SAE ITC established in 2003 operates as a trade association as part of the SAE International Enterprise providing a unique framework serving the automotive, aerospace, and commercial vehicle sectors. Clients include private companies, government agencies, individuals, and trade associations. Building consensus and breakthrough barriers to achieve solutions, and the ways by which those solutions take shape, are tailored to each client's individual needs.

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These Standards are produced by the SAE ITC with the assistance of, and for the benefit of the Aerospace Industry, as part of a continuous programme of Standardisation for Aerospace application under the control of the Technical Standards Committee (TSC) of the SAE ITC.

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It is recommended that Technical Specification TS260, Metallic Materials List of Alternative Material Standards, be consulted prior to manufacture of SAE ITC products.

Each Standard is a facsimile or electronic reproduction of a master drawing and, therefore, any outline view scales stated are not necessarily reproduced accurately. A Master Index of all SAE ITC Aerospace Standards is published separately on the SAE ITC website.

All references to Standards include reference to RS and TS publications.

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Documents
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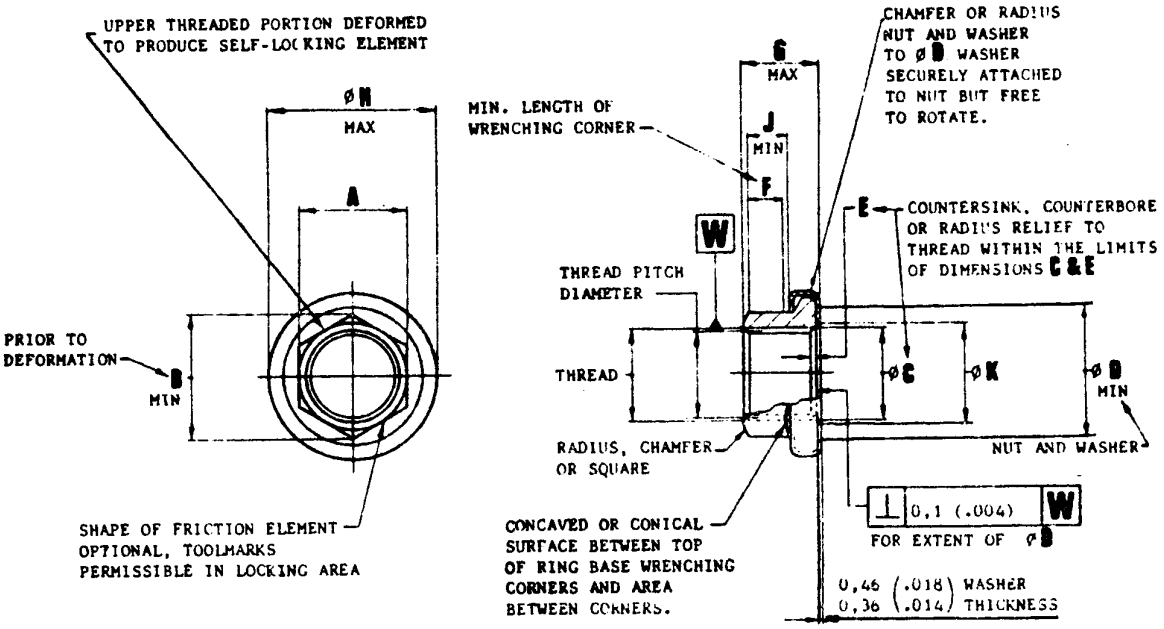
Full document details: SAE AS27830-2

NUT, SELF-LOCKING, SIX-POINT, CAPTIVE WASHER.

SOURCE CONTROL DRAWING

AS 27830-32

3RD ANGLE PROJECTION



1. PERFORMANCE:- USA MANUFACTURED PARTS MIL-N-25027 EXCEPT AS NOTED BELOW IN 13.2, 13.3 AND 13.4.
   UK MANUFACTURED PARTS TS3 EXCEPT AS NOTED BELOW IN 13.2, 13.3 AND 13.4.
2. MATERIAL:- NUT - CORROSION RESISTANT STEEL A286 (AMS 5525, 5735, 5737).
   WASHER - CORROSION RESISTANT STEEL 18-8 (AMS 5510).
3. FINISH:- NUT - SILVER COATED TO DTD 939 OR AMS 2410.
   WASHER - PASSIVATED.
4. HARDNESS:- NUT 49HRC MAX.
5. DIMENSIONS AND TOLERANCES, EXCEPT FOR THREADS, ARE IN MILLIMETRES. INCH CONVERSIONS ARE IN PARENTHESES. ALL DIMENSIONS APPLY AFTER COATING.
6. BREAK SHARP EDGES 0,08 (.003) TO 0,38 (.015) UNLESS OTHERWISE SPECIFIED.
7. SURFACE TEXTURE:- BS 1134 ALL SURFACES 3,2 MICROMETRES (125 MICROINCHES).
8. SCREW THREADS BS 4084 (MIL-S-8879).
9. CRACK TEST NUT TO DTD 929 BEFORE COATING.
10. QUALIFIED MANUFACTURERS TO TS200.
11. DRAWING PRACTICE TO SBAC TS 66.
12. PART NUMBER, MANUFACTURERS IDENTITY ALL OTHER MARKINGS TO RS 610 METHOD 5.
13. APPLICATION:-
    - 13.1. UPPER THREADED PORTION DEFORMED TO DEVELOP SPECIFIED LOCKING TORQUE WHEN USED ON FULL P.D. THREADS TO BS 1580 CLASS 3A OR BS 4084.
    - 13.2. THESE NUTS ARE DESIGNED TO DEVELOP THE TENSILE STRENGTHS QUOTED WHEN USED WITH 1100MN/m² (159,000 lbf/in²) BOLTS AT ROOM TEMPERATURE.
    - 13.3. MAXIMUM RATED TEMPERATURE 480°C.
    - 13.4. WRENCH TORQUE APPLICABLE ONLY WHEN APPLIED WITH A STANDARD SOCKET WRENCH.
14. DO NOT USE UNASSIGNED PART NUMBERS.

RS AND TS ARE SBAC PUBLICATIONS
BS ARE BRITISH STANDARDS INSTITUTION PUBLICATIONS
DTD ARE MINISTRY OF AVIATION SUPPLY/DEPARTMENT OF TRADE AND INDUSTRY PUBLICATIONS
AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS INC., U.S.A. PUBLICATIONS
MIL SPECIFICATIONS ARE DEPARTMENT OF DEFENCE U.S.A. PUBLICATIONS

PRINTED IN ENGLAND
ORIGINAL SIZE ISO A3 297 X 420 mm
ISSUE 1. DATE 4 NOV 1971 REVISION Issue 2 Nov'86
PREPARED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD. ENGINE STANDARDS PANEL
THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD. 29, KING STREET, ST JAMES, LONDON, S.W.1.
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Full document details: SAE AS27830-2