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REV.
E

AS3486™

FEDERAL SUPPLY CLASS
5310

RATIONALE

FIGURE REDRAWN, NOTES REARRANGED TO ENSURE THERE IS NO CONFLICT BETWEEN PROCUREMENT SPEC AND STANDARD, NOTES UPDATED, USAGE NOTE ADDED.

AS3486E HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

A REAFFIRMED STATUS IS GIVEN TO TECHNICAL REPORTS THAT HAVE BEEN REVIEWED BY THE TECHNICAL COMMITTEE AND DEEMED TO BE CURRENT WITH NO NEED FOR IMMEDIATE REVISION. NO CHANGES HAVE BEEN MADE TO THIS DOCUMENT AS A RESULT OF THIS REVIEW.

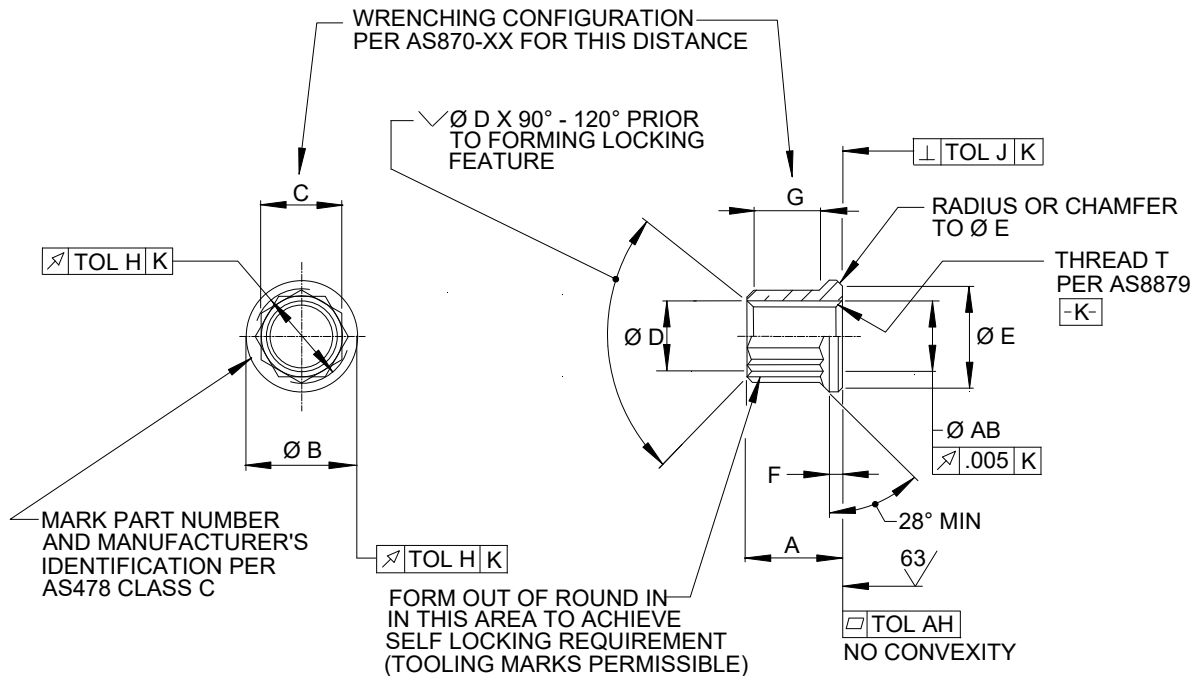
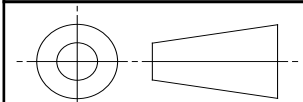


FIGURE 1 - NUT

For more information on this standard, visit
<https://www.sae.org/standards/content/AS3486E/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION:



AEROSPACE STANDARD

(R) NUT, SELF-LOCKING, EXTENDED DOUBLE
HEXAGON, REDUCED FLANGE, DRY FILM LUBE,
UNS S66286, CLASS: 160 KSI/800 °F

AS3486™
SHEET 1 OF 3

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TABLE 1A - DIMENSIONS

PART NUMBER	T THREAD	A +.005/-.010	ØB MAX	C NOM	DASH NO.	ØD MAX
AS3486-09	.1900-32UNJF-3B	.245	.340	.2500	08	.220
AS3486-10	.2500-28UNJF-3B	.317	.430	.3125	10	.280
AS3486-11	.3125-24UNJF-3B	.355	.515	.3750	12	.345
AS3486-12	.3750-24UNJF-3B	.453	.586	.4375	14	.405

TABLE 1B - DIMENSIONS

PART NUMBER	ØE MIN	F	G MIN	H	J	ØAB	AH	APPROX MASS LB/100
AS3486-09	.310	.035-.057	.125	.006	.004	.190-.220	.0014	.20
AS3486-10	.400	.045-.057	.185	.007	.005	.250-.280	.0014	.40
AS3486-11	.485	.055-.068	.195	.008	.005	.312-.342	.0016	.70
AS3486-12	.558	.075-.100	.250	.009	.005	.375-.405	.0016	1.00

NOTES:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL PER AMS5731 OR AMS5734 (UNS S66286).
- /2/ PROCUREMENT SPECIFICATION: AS4393, EXCEPT AS FOLLOWS:
 - a. HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE PRECIPITATION HEAT TREATED PER AMS2759/3 TO MEET THE HARDNESS SPECIFIED IN NOTE 3.
 - b. COATING: SOLID FILM LUBRICANT PER AS1701, TYPE VI, IN LIEU OF SILVER PLATE PER AMS2411.
 - c. PRETREATMENT: PRIOR TO APPLYING THE SOLID FILM LUBRICANT, NUTS MAY BE PLATED WITH COPPER (AMS2418) OR NICKEL (AMS2403) OR BOTH TO .00025 MAXIMUM THICKNESS.
 - d. DIMENSIONS APPLY AFTER PRETREATMENT PLATING AND BEFORE COATING WITH SOLID FILM LUBRICANT.
 - e. BAKE AT 800 °F ± 15 °F IN LIEU OF 1200 °F FOR NUTS TESTED AFTER BAKE.
 - f. COMPLETELY RECRYSTALLIZED MICROSTRUCTURE IS NOT REQUIRED.
3. HARDNESS: 37 TO 45 HRC.
4. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
5. FLUORESCENT PENETRANT INSPECTION PER ASTM E1417/E1417M, TYPE I, SENSITIVITY LEVEL 2 MINIMUM, 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 MICROINCHES Ra.
7. DIMENSIONING AND TOLERANCING: ANSI Y14.5-1982 (ASME PUBLICATION).
8. DIMENSIONS ARE IN INCHES.

	AEROSPACE STANDARD	AS3486™ SHEET 2 OF 3	REV. F
	(R) NUT, SELF-LOCKING, EXTENDED DOUBLE HEXAGON, REDUCED FLANGE, DRY FILM LUBE, UNS S66286, CLASS: 160 KSI/800 °F		

