

PART IS TOO SMALL TO FIT PART NUMBER.

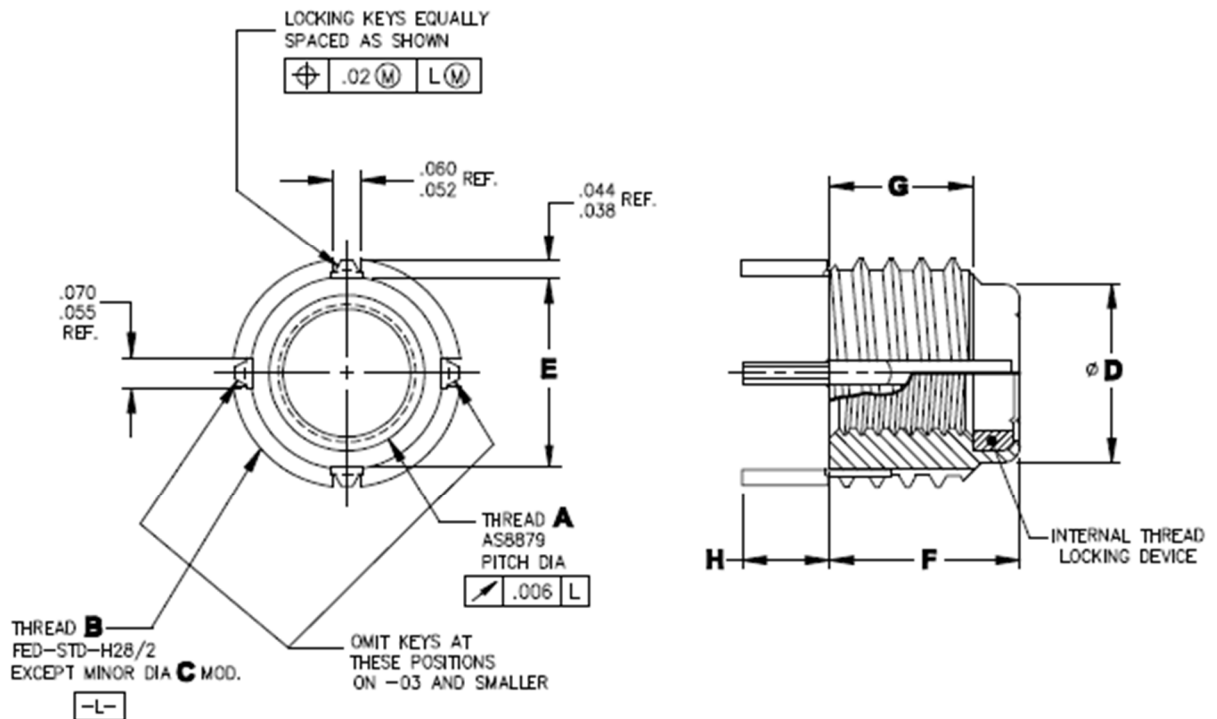


FIGURE 1

TABLE 1

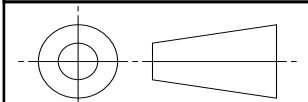
PART NUMBER	A THREAD	B THREAD		Ø D MAX	E
		SIZE	ØC		
AS3503-01	.1640-36 UNJF-3B	.3750-16 UNC-2A	.312-.320	.292	.280-.288
AS3503-02	.1900-32 UNJF-3B	.4375-14 UNC-2A	.375-.383	.355	.341-.348
AS3503-03	.2500-28 UNJF-3B	.5000-13 UNC-2A	.432-.440	.412	.403-.411
AS3503-04	.3125-24 UNJF-3B	.5625-12 UNC-2A	.495-.503	.475	.465-.473
AS3503-05	.3750-24 UNJF-3B	.6250-11 UNC-2A	.551-.565	.531	.528-.536
AS3503-06	.4375-20 UNJF-3B	.6875-11 UNS-2A	.615-.625	.595	.591-.597
AS3503-07	.5000-20 UNJF-3B	.8125-16 UN-2A	.744-.752	.724	.716-.724

TABLE 1 (CONTINUED)

PART NUMBER	F	G	H
AS3503-01	±.015	±.015	±.015
AS3503-02	.260	.180	.135
AS3503-03	.350	.265	.190
AS3503-04	.400	.275	.190
AS3503-05	.480	.330	.190
AS3503-06	.580	.390	.190
AS3503-07	.670	.450	.190
AS3503-08	.770	.520	.190

For more information on this standard, visit
<https://www.sae.org/standards/content/AS3503A/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS4723



AEROSPACE STANDARD

INSERT, SCREW THREAD, SELF LOCKING
PLASTIC LOCKING DEVICE, SOLID FILM LUBRICATED,
SELF-BROACHING KEYS, OVERSIZE UNS S66286

AS3503™
SHEET 1 OF 2

REV.
A

Documents

NOTES:

- 1. MATERIAL:
 - a. INSERT: STEEL, CORROSION-RESISTANT, TYPE A286 (UNS S66286) IN ACCORDANCE WITH AMS5731, AMS5734, OR AMS5737.
 - b. LOCKING KEYS: STEEL, CORROSION-RESISTANT, TYPE 420 (UNS S42000), CHEMICAL COMPOSITION PER ASTM A580/A580M.
 - c. PLASTIC LOCKING DEVICE: POLYIMIDE RESIN, AMS3644 CLASS 1 OR CLASS 2.
- 2. HEAT TREATMENT:
 - a. INSERT: AMS5731 AND AMS5734 SHALL BE HEAT TREATED TO 140000 PSI FTU MIN.
 - b. LOCKING KEYS: HARDNESS TO BE HRC 54 MIN.
- 3. FINISH:
 - a. PASSIVATE IN ACCORDANCE WITH AMS2700 TYPE 2 OR TYPE 8.
 - b. INSERT TO BE SOLID FILM LUBRICANT COATED IN ACCORDANCE WITH AS1701, CLASS III THROUGH VI PER MANUFACTURER'S OPTIONS.
 - c. LOCKING KEYS MAY OR MAY NOT BE LUBRICANT COATED.
- 4. MARK MANUFACTURER'S IDENTIFICATION PER AS478 METHOD 2.
- 5. ALL DIMENSIONS ARE AFTER SURFACE TREATMENT AND PRIOR TO THE ADDITION OF THE LUBRICANT.
- 6. INSTALLATION OF INSERT SHALL BE IN ACCORDANCE WITH AS4724.
- 7. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.
- 8. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
- 9. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.
- 10. ALL DIMENSIONS ARE IN INCHES, UNLESS OTHERWISE SPECIFIED.
- 11. DO NOT USE UNASSIGNED PART NUMBERS.
- 12. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

AS AND AMS ARE SAE INTERNATIONAL PUBLICATIONS.
ASME IS AN AMERICAN SOCIETY OF MECHANICAL ENGINEERS PUBLICATION.

	AEROSPACE STANDARD	AS3503™ SHEET 2 OF 2	REV. A
	INSERT, SCREW THREAD, SELF LOCKING PLASTIC LOCKING DEVICE, SOLID FILM LUBRICATED, SELF-BROACHING KEYS, OVERSIZE UNS S66286		