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REV.
C

AS3504™

FEDERAL SUPPLY CLASS
5340

RATIONALE

GENERAL EDITORIAL REVISION, FIGURE 1 RE-DRAWN, TABLE 1 RE-FORMATTED, ADD ANSI Y14.5M (ASME PUBLICATION), CLARIFY THREAD B DESIGNATION, ADD NEW NOTE FOR DISPOSITION OF EXISTING INVENTORY, UPDATE MARKING NOTE.

AS3504C HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

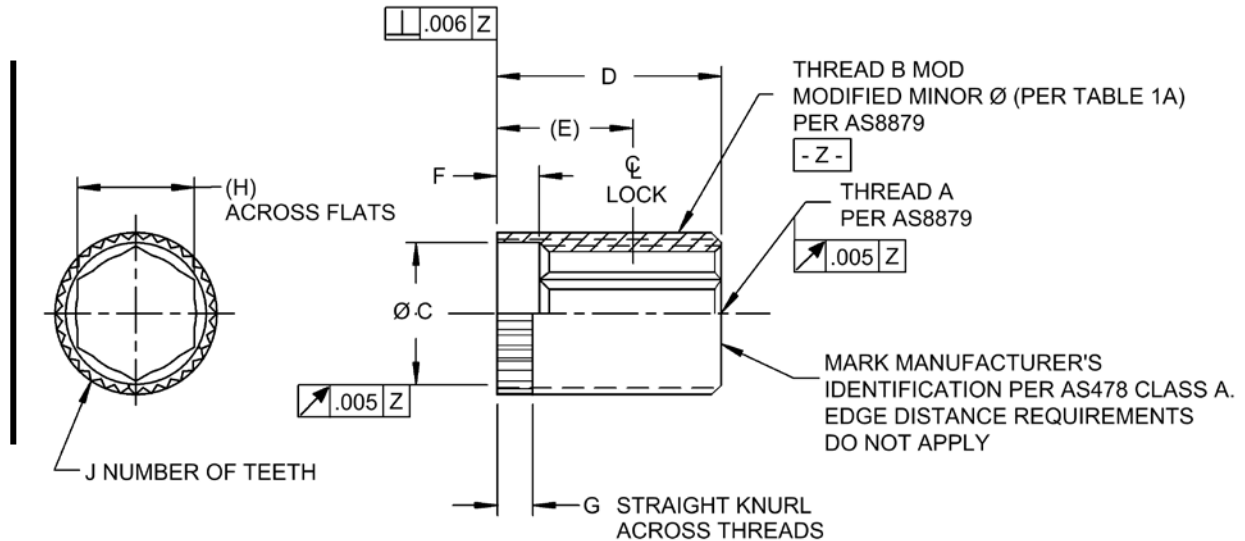


FIGURE 1

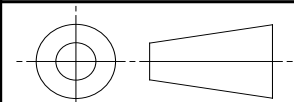
TABLE 1A - PART NUMBERS, THREAD A, THREAD B & MODIFIED MINOR Ø, AND DIMENSIONS ØC AND D

PART NUMBER	THREAD A	THREAD B MODIFIED MINOR Ø	THREAD B MINOR Ø MAX	ØC	D
AS3504-01	.1900-32 UNJF-3B	.2500-28 UNJF-3A	.2170	.193-.199	.280-.300
AS3504-02	.2500-28 UNJF-3B	.3125-24 UNJF-3A	.2785	.253-.259	.370-.390
AS3504-03	.3125-24 UNJF-3B	.3750-24 UNJF-3A	.3405	.315-.321	.460-.480
AS3504-04	.3750-24 UNJF-3B	.4375-20 UNJF-3A	.4010	.379-.385	.550-.570
/a/ AS3504-05	.4375-20 UNJF-3B	.5000-20 UNJF-3A	.4630	.441-.447	.650-.670
/a/ AS3504-06	.5000-20 UNJF-3B	.5625-24UNJEF-3A	.5290	.503-.510	.740-.760

/a/ AS3504-05 AND AS3504-06 ARE NOT TO BE USED FOR NEW DESIGNS.

For more information on this standard, visit
<https://www.sae.org/standards/content/AS3504C/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS3506



AEROSPACE STANDARD

INSERT - THIN WALL, SHORT, SELF-LOCKING,
1025 °F, SILVER PLATED ON INTERNAL SURFACES
ONLY, UNS N07718, UNJ THREAD

AS3504™
SHEET 1 OF 2

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Documents

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TABLE 1B - PART NUMBERS AND DIMENSIONS E, F, G, H, J, AND APPROX. MASS

PART NUMBER	(E)	F	G	(H)	J	APPROX MASS LB/1000
AS3504-01	.19	.085-.095	.070-.080	.157	20	1.264
AS3504-02	.24	.085-.095	.070-.080	.210	24	2.285
AS3504-03	.30	.085-.095	.070-.080	.266	29	3.570
AS3504-04	.35	.115-.125	.100-.110	.322	34	5.024
/a/ AS3504-05	.40	.115-.125	.100-.110	.377	39	7.351
/a/ AS3504-06	.45	.115-.125	.100-.110	.439	44	9.816

/a/ AS3504-05 AND AS3504-06 ARE NOT TO BE USED FOR NEW DESIGNS.

NOTES:

- MATERIAL: NICKEL ALLOY, CORROSION AND HEAT RESISTANT, AMS5662 (UNS N07718).
- HARDNESS: 45 HRC MAX.
- FINISH:
 - SILVER PLATE INSIDE DIAMETER C AND THREAD A, AND AT THE MANUFACTURER'S OPTION THE END SURFACES, TO AMS2411. ON INSERTS WITH THREAD A OF .2500 OR LARGER THE COATING THICKNESS SHALL BE .0002 TO .0006. INSERTS WITH THREAD A OF .1900 SHALL SHOW COMPLETE COATING COVERAGE ON THE THREAD. DIMENSIONS APPLY AFTER PLATING.
 - PASSIVATE PER AS2700 PRIOR TO PLATING.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra, EXCEPT THREADS TO BE 63 MICROINCHES Ra AND KNURL TO BE 250 MICROINCHES Ra.
- BREAK SHARP EDGES .015 MAXIMUM, UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS ARE IN INCHES.
- DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982 (ASME PUBLICATION).
- UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- PARTS TO BE INSTALLED PER AS3507 INTO MACHINED HOLES PER AS3508.
- DO NOT USE UNASSIGNED PART NUMBERS.
- 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.
 ASTM IS AN ASTM INTERNATIONAL PUBLICATION.

	AEROSPACE STANDARD	AS3504™ SHEET 2 OF 2	REV. 6
	INSERT - THIN WALL, SHORT, SELF-LOCKING, 1025 °F, SILVER PLATED ON INTERNAL SURFACES ONLY, UNS N07718, UNJ THREAD		



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