

SSUED 1999-05	REVISED 2019-11	REAFFIRMED 2026-05
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TABLE 1 - DASH NUMBERS, THREADS, AND DIMENSIONS

DASH NO.	INTERNAL THREAD AS8879 UNJF-3B	EXTERNAL THREAD FED-STD-H28/2 MOD MINOR Ø	EXTERNAL THREAD MINOR Ø MOD	ØC ±.005	D ±.010	(ØE)	(F)	G ±.015	KEY DIM (H)	KEY DIM (J)	KEY DIM (K)	L ±.030
-1	.1900-32	.3750-16UNC-2A	.312- .320	.196	.070	.310	.284	.312	.068	.040	.130	.220
-2	.2500-28	.4375-14UNC-2A	.375- .383	.257	.070	.375	.344	.375	.068	.040	.190	.220
-3	.3125-24	.5000-13UNC-2A	.432- .440	.316	.070	.430	.407	.437	.068	.040	.190	.220
-4	.3750-24	.5625-12UNC-2A	.495- .503	.380	.070	.495	.469	.500	.068	.040	.190	.250
-5	.4375-20	.6250-11UNC-2A	.551- .565	.445	.100	.550	.532	.625	.068	.040	.190	.280
-6	.5000-20	.6875-11NS-2A	.615- .625	.507	.100	.615	.595	.688	.068	.040	.190	.280
-7	.5625-18	.8125-16UN-2A	.744- .752	.580	.100	.745	.720	.812	.068	.040	.190	.320
-8	.6250-18	.8750-14UNF-2A	.807- .815	.640	.100	.805	.782	.875	.068	.040	.190	.330
-9	.7500-16	1.1250-12UNF-2A	1.040-1.050	.763	.100	1.040	.975	1.125	.103	.070	.250	.490
-9L	.7500-16	1.1250-12UNF-2A	1.040-1.050	.763	.100	1.040	.975	1.250	.103	.070	.250	.490
-10	.8750-14	1.2500-12UNF-2A	1.165-1.175	.888	.100	1.165	1.100	1.250	.103	.070	.250	.490
-10L	.8750-14	1.2500-12UNF-2A	1.165-1.175	.888	.100	1.165	1.100	1.375	.103	.070	.250	.490
-11	1.0000-12	1.3750-12UNF-2A	1.290-1.300	1.015	.100	1.290	1.225	1.375	.103	.070	.250	.490
-11L	1.0000-12	1.3750-12UNF-2A	1.290-1.300	1.015	.100	1.290	1.225	1.500	.103	.070	.250	.550

NOTES:

1. MATERIAL:

INSERT: STEEL, CORROSION-RESISTANT, TYPE A286 (UNS S66286) IN ACCORDANCE WITH AMS5731, AMS5734, OR AMS5737.

LOCKING KEYS: STEEL, CORROSION-RESISTANT, TYPE 420 (UNS S42000), CHEMICAL COMPOSITION PER ASTM A580/A580M, HARDNESS 54 HRC MINIMUM.

2. PROCUREMENT SPECIFICATION: AS4892.

3. HEAT TREATMENT: AMS5731, AMS5734 SHALL BE HEAT TREATED TO 140000 PSI FTU MINIMUM.

4. LUBRICATION: INSERTS SHALL BE DRY FILM LUBRICATED IN ACCORDANCE WITH AS1701, CLASS III THROUGH VI (PER MANUFACTURER'S OPTION). THE LOCKING KEYS MAY OR MAY NOT BE LUBRICATED.

5. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.

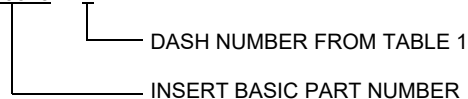
6. DIMENSIONING AND TOLERANCING: ANSI Y14.5M-1982 (ASME PUBLICATION).

7. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.005, ANGULAR DIMENSIONS ±5°.

8. FINISH: PASSIVATE IN ACCORDANCE WITH AMS2700, TYPE 2 OR TYPE 8.

9. EXAMPLE OF PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC AS PART NUMBER PLUS THE DASH NUMBER TAKEN FROM TABLE 1.

EXAMPLE: AS3545 - 2



EXAMPLE: AS3545-2 INDICATES - INSERT, SCREW THREAD, SELF-LOCKING, LOCKED IN, KEY-LOCKED, HEAVY-DUTY, CRES A286, SELF-BROACHING KEYS, .2500-28UNJF-3B INTERNAL THREAD.

/10/ INSERTS WITH INTERNAL THREAD SIZE .1900 SHALL BE SUPPLIED WITH TWO LOCKING KEYS SPACED 180° APART. INSERTS WITH INTERNAL THREAD SIZE .2500 AND GREATER SHALL BE SUPPLIED WITH FOUR LOCKING KEYS SPACED 90° APART.

11. INSERTS SHALL BE FREE OF BURRS AND SLIVERS.

	AEROSPACE STANDARD	AS3545™ SHEET 2 OF 3 	REV. A
	INSERT, SCREW THREAD, SELF-LOCKING, LOCKED IN, KEY LOCKED, HEAVY-DUTY, SELF-BROACHING KEYS, UNS S66286		