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REV.
B

AS3547™

FEDERAL SUPPLY CLASS
5310

RATIONALE

NOTES 2, 4, AND 6 COMBINED AND EDITED FOR CLARITY, EXCEPTION FOR RECRYSTALLIZED MICROSTRUCTURE ADDED, BASIC BLOCK REMOVED FROM DIM L, EDITORIAL REVISIONS THROUGHOUT.

AS3547B 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.

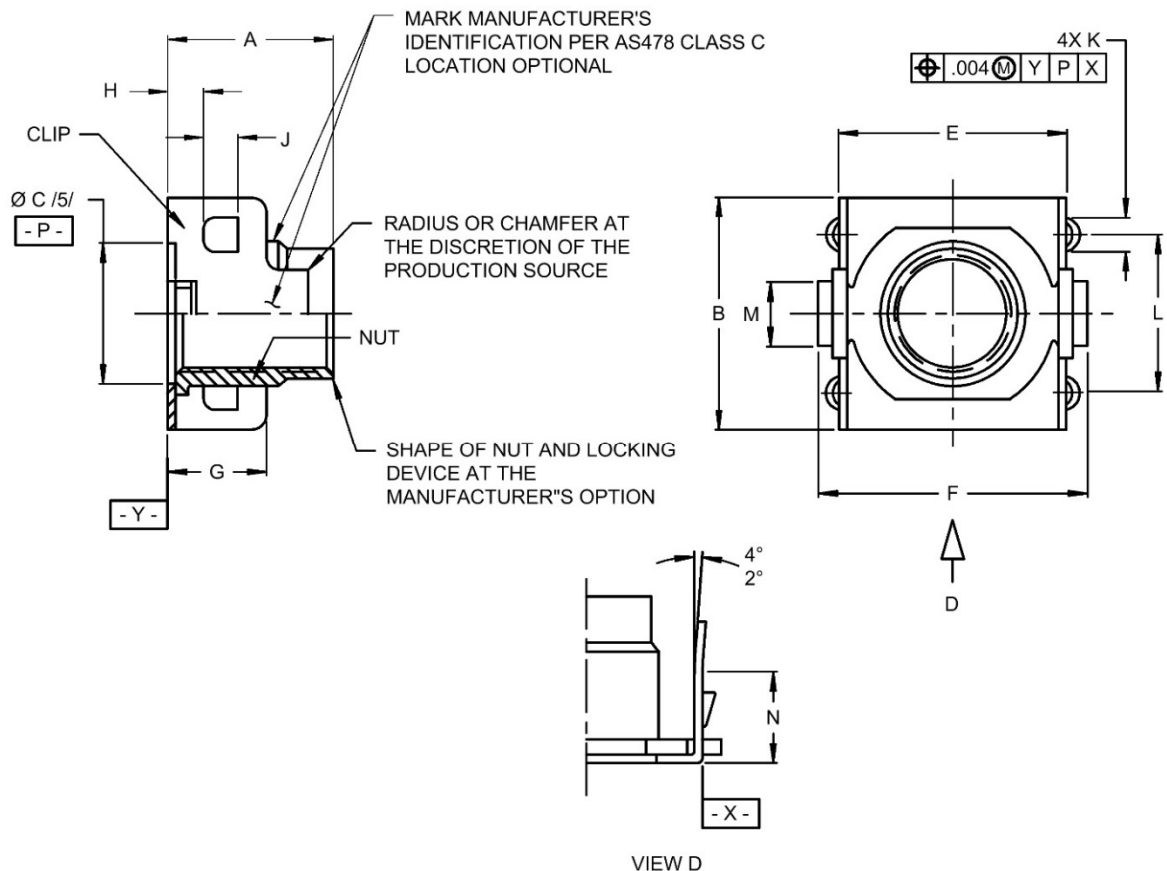
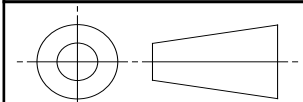


FIGURE 1 - NUT ASSEMBLY

For more information on this standard, visit
<https://www.sae.org/standards/content/AS3547B/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: AS4393 /2/



AEROSPACE STANDARD

ASSEMBLY NUT AND CLIP,
REMOVABLE SELF-LOCKING NUT,
UNS S66286, CLASS 160 KSI/1200 °F

AS3547™
SHEET 1 OF 2

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TABLE 1A - PART NUMBERS, THREAD SIZE AND DIMENSIONS A THRU G

PART NUMBER	THREAD T	A MAX	B ±.002	ØC ±.002	E		F ±.002	G MAX
					+ .008 - .000			
AS3547-01	.1900-32UNJF-3B	.269	.435	.246	.411		.521	.177
AS3547-02	.2500-28UNJF-3B	.350	.490	.297	.480		.590	.208
AS3547-03	.3125-24UNJF-3B	.381	.598	.368	.582		.716	.220
AS3547-04	.3750-24UNJF-3B	.413	.661	.447	.661		.801	.242

TABLE 1B - DIMENSIONS H THRU N AND APPROX MASS

PART NUMBER	H MAX	J MAX	K ±.002	L +.002	M MAX	N MIN	APPROX MASS
							LB/100
AS3547-01	.139	.061	.065	.303	.122	.168	.37
AS3547-02	.165	.072	.073	.334	.137	.195	.63
AS3547-03	.173	.072	.091	.413	.171	.211	.99
AS3547-04	.187	.072	.091	.397	.161	.225	1.23

NOTES:

1. MATERIAL:

- a. NUT: CORROSION AND HEAT RESISTANT ALLOY AMS5525, AMS5731, OR AMS5734 (COMPOSITION SIMILAR TO UNS S66286).
- b. CLIP: CORROSION AND HEAT RESISTANT ALLOY AMS5510 (COMPOSITION SIMILAR TO UNS S32100).

/2/ PROCUREMENT SPECIFICATION: AS4393 EXCEPT AS FOLLOWS:

- a. HEAT TREATMENT: AFTER FORMING, NUTS SHALL BE PRECIPITATION HEAT TREATED TO MEET THE HARDNESS SPECIFIED IN NOTE 2c.
- b. COMPLETELY RECRYSTALLIZED MICROSTRUCTURE IS NOT REQUIRED.
- c. HARDNESS: 37 TO 45 HRC.

3. FINISH:

- a. NUT: SILVER PLATE PER AMS2411. PLATING IS PERMITTED ONLY ON THREAD WITH OPTIONAL COVERAGE ON COUNTERSINKS. DIMENSIONS APPLY AFTER PLATING.
- b. CLIP: PASSIVATE PER AMS2700 METHOD 1, TYPE 2 OR 8, OR AMS2700 METHOD 2.

4. ASSEMBLY AND INSTALLATION: AS3550.

5. RADIAL FLOAT OF NUT THREADS RELATIVE TO CLIP ØC .030 MINIMUM.

6. REMOVE BURRS AND SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

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

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

9. DIMENSIONS ARE IN INCHES.

10. DO NOT USE UNASSIGNED PART NUMBERS.

11. UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

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.

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	ASSEMBLY NUT AND CLIP, REMOVABLE SELF-LOCKING NUT, UNS S66286, CLASS 160 KSI/1200 °F		



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