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REV.
C

AS4660™

FEDERAL SUPPLY CLASS
4730

RATIONALE

GRAPHICS REDRAWN FOR IMPROVED CLARITY. OPTION FOR SAFETY WIRE HOLES /15/ ADDED. ADDED $\pm 5^\circ$ TOLERANCE TO HEX CHAMFERS. UPDATED DRY FILM SPECIFICATION TO CURRENTLY USED AS5272. UPDATED PROCUREMENT SPECIFICATION NOTE. REVISED GENERAL TOLERANCE FOR ANGLES TO $\pm 0^\circ 30'$. UPDATED OUTDATED SPECIFICATIONS. NOTE /15/ ADDED.

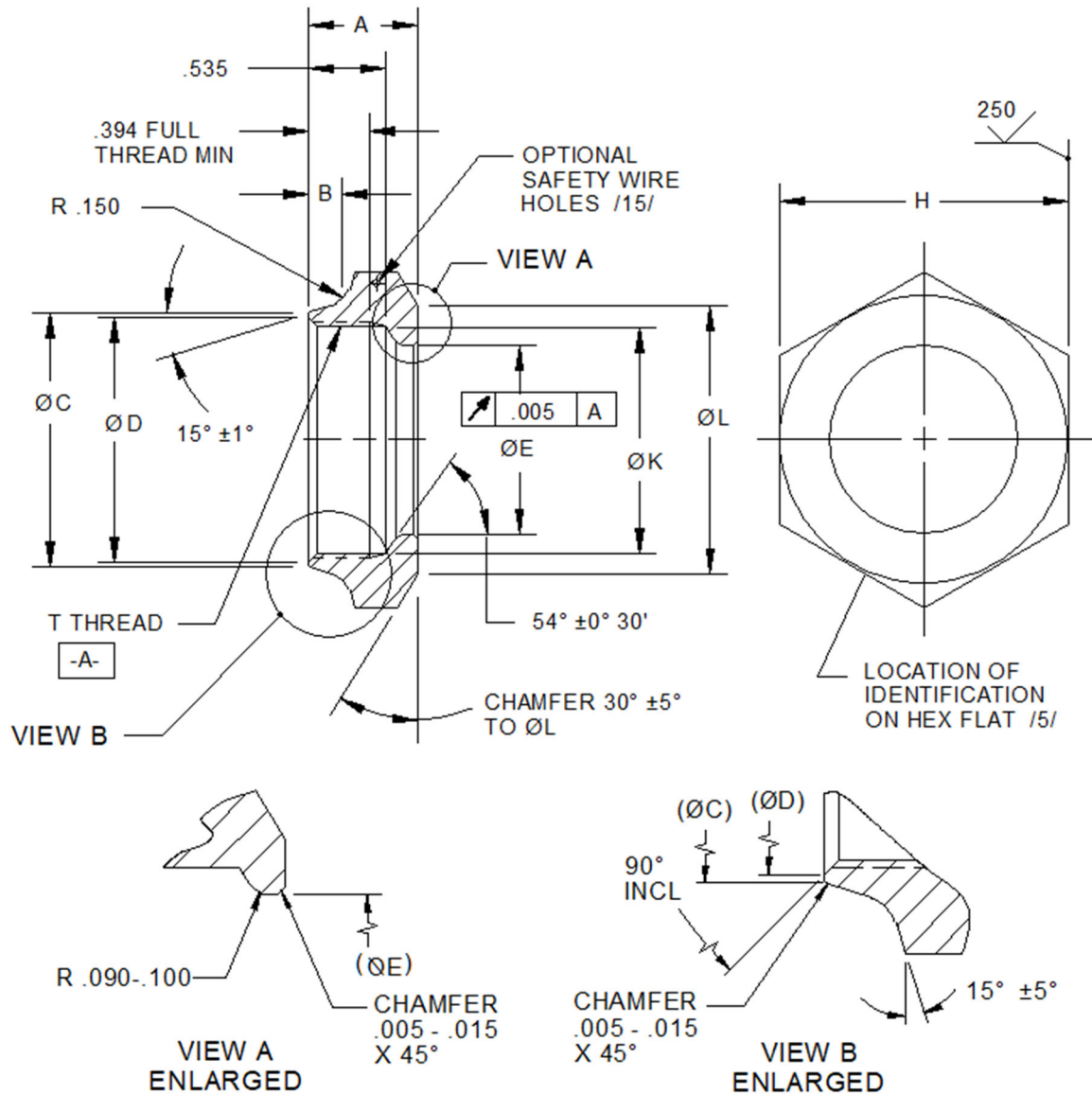
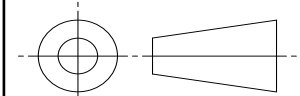


FIGURE 1 - NUT, SHORT FLARELESS

For more information on this standard, visit
<https://www.sae.org/standards/content/AS4660C/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS18280 /4/



AEROSPACE STANDARD

NUT, SHORT FLARELESS

AS4660™
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TABLE 1 - DIMENSIONS A-L AND WEIGHTS

BASIC NO. AS4660												LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES	LB/EA APPROX REF TI
/14/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879	A	B	C ±.005	D	E +.005/- .000	H	K ±.0050	L				
20	1.250	1.5625-12 UNJ-3B	.759	.250	1.678	1.572	1.330	1.802-1.817	1.4864	1.792		.084	.231	.132
24	1.500	1.8125-12 UNJ-3B	.760	.234	1.928	1.822	1.580	2.052-2.072	1.7364	2.042		.097	.266	.155

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

CADMIUM IS CARCINOGENIC TO HUMANS (INTERNATIONAL AGENCY FOR RESEARCH ON CANCER (IARC), GROUP 1) AND IS HAZARDOUS TO ECOSYSTEMS AND HUMAN HEALTH. SUGGEST USE OF ALTERNATIVE MATERIALS, WHEN POSSIBLE.

/1/ MATERIAL:

- a. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY PER AMS4928.
- b. CODE LETTER V: TYPE 15-5PH CORROSION-RESISTANT STEEL PER AMS5659.
- c. CODE LETTER W: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. HEAT TREATMENT:

- a. ALUMINUM ALLOY: NONE.
- b. CORROSION-RESISTANT STEEL: HEAT TREAT TO CONDITION H1075 PER AMS2759/3.
- c. TITANIUM: NONE.

/3/ FINISH:

- a. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486. APPLY DRY FILM LUBRICANT PER AS5272, TYPE I, TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.
- b. MATERIAL CODE LETTER V:
 - (1) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER AMS2700 TYPE 2 OR TYPE 8. APPLY DRY FILM LUBRICANT PER AS5272, TYPE I, TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.
 - (2) V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR PER MIL-PRF-8625, TYPE II, CLASS 2, DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595. APPLY DRY FILM LUBRICANT PER AS5272, TYPE I, TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.

/4/ PROCUREMENT SPECIFICATION: AS18280, EXCEPT AS SPECIFIED IN THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) SHALL BE LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS18280 FOR THIS STANDARD. REFER TO www.eAuditNet.com FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

6. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION-RESISTANT STEEL AT 3000 PSI
- b. SIZES -20 AND -24 ALUMINUM ALLOY AT 600 PSI

THE PREVIOUS -28 SIZE WAS REMOVED FROM THIS STANDARD DUE TO NON-DEVELOPMENT OF THIS SIZE.

	AEROSPACE STANDARD	AS4660™	REV.
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