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REV.
A

AS4702

FEDERAL SUPPLY CLASS
4730

RATIONALE

AS4702A HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

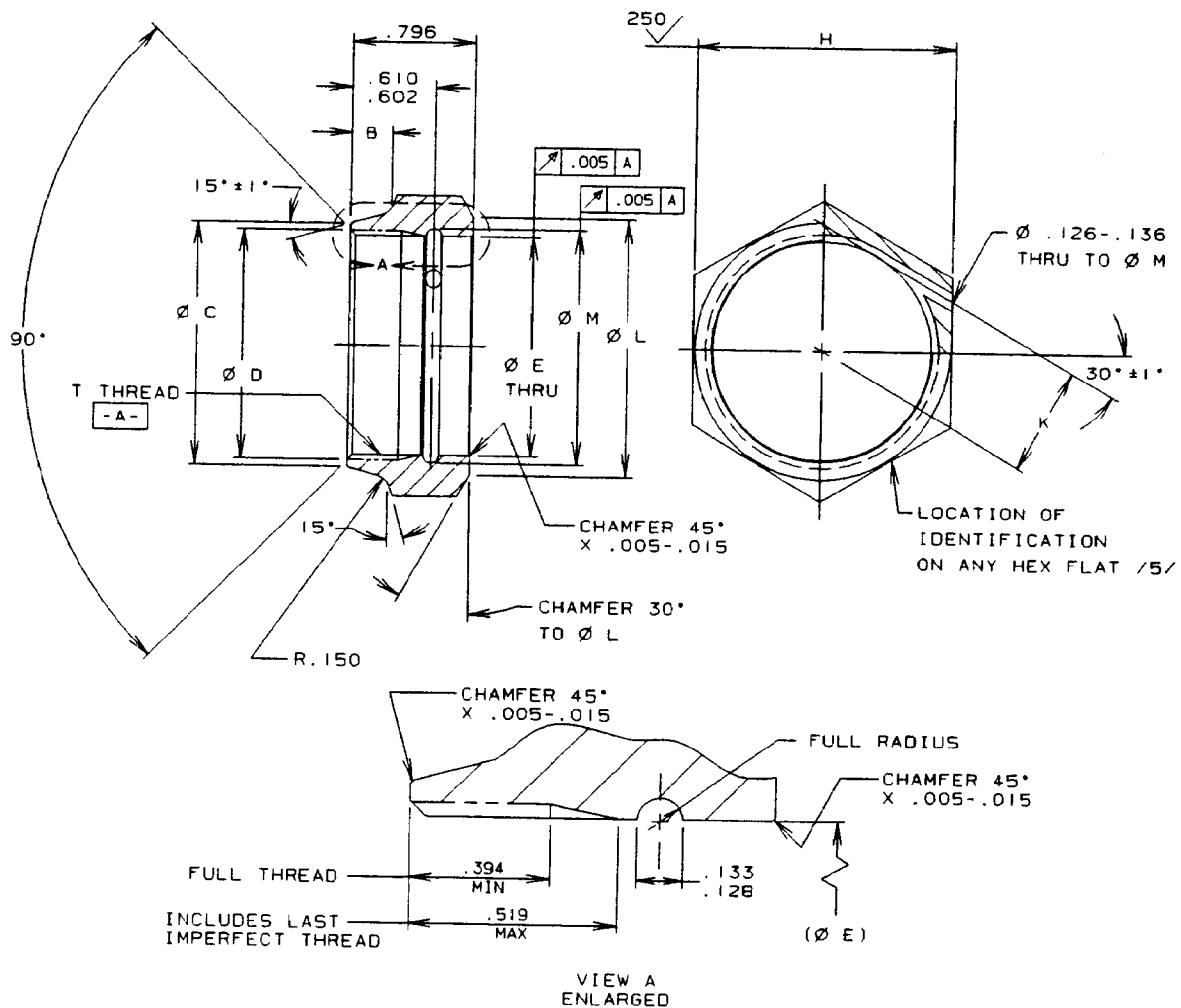


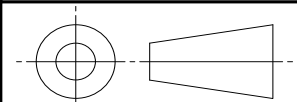
FIGURE 1 - NUT, RETAINED

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO.												LB/EA		
AS4702	(NOMINAL											MAX	MAX	MAX
/14/	TUBE	T THREAD PER	C		E		K		M		ALUM	CRES	TI	
SIZE CODE	SIZE)	MIL-S-8879	B	±.005	D	±.0050	H	±.005	L	±.005				
20	1.250	1.5625-12 UNJ-3B	.290	1.678	1.572	1.4864	1.802-1.817	.735	1.792	1.601	.076	.211	.121	
24	1.500	1.8125-12 UNJ-3B	.272	1.928	1.822	1.7364	2.052-2.072	.858	2.042	1.848	.091	.250	.144	
28	1.750	2.1250-12 UNJ-3B	.250	2.240	2.135	2.0489	2.365-2.385	1.012	2.355	2.158	.110	.305	.175	

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS4702A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280



AEROSPACE STANDARD

NUT, RETAINED, SHORT FLARELESS

AS4702
SHEET 1 OF 3

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Documents

NOTES:

/1/ MATERIAL:

- a. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928
- b. CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS 5659
- c. CODE LETTER W: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T: NONE
- b. MATERIAL CODE LETTER V: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3
- c. MATERIAL CODE LETTER W: NONE

/3/ FINISH:

- a. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT IN ACCORDANCE WITH AMS 2486. APPLY DRY FILM LUBRICANT PER MIL-L-46010, 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 QQ-P-35, TYPE II OR VIII. APPLY DRY FILM LUBRICANT PER MIL-L-46010, 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 QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595. APPLY DRY FILM LUBRICANT PER MIL-L-46010, TYPE I TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED.

/4/ PROCUREMENT SPECIFICATION: MIL-F-18280 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

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

6. THIS PART IS DESIGNED FOR USE WITH AS4701 WIRE AND AS4703 FITTING END IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 psi
- b. SIZE -28 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND SIZES -20, -24, AND -28 ALUMINUM ALLOY AT 600 psi

7. THE (R) 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 SPECIFICATION. IF THE SYMBOL IS NEXT TO THE SPECIFICATION TITLE, IT INDICATES A COMPLETE REVISION OF THE REPORT.

8. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

9. INTERPRETATION OF DRAWING PER ARP4296.

10. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra.

11. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

	AEROSPACE STANDARD		AS4702 SHEET 2 OF 3	REV. A
	NUT, RETAINED, SHORT FLARELESS			



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