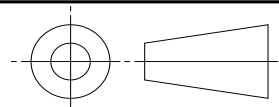


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REV. C	RATIONALE		FEDERAL SUPPLY CLASS 5365
	TABLE 2 REDRAWN FOR CLARITY, SPECS UPDATED, USAGE NOTE ADDED.		
AS51997™	NOTICE		
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NOTICE			
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ANY REQUIREMENTS ASSOCIATED WITH QUALIFIED PRODUCT LISTS (QPL'S) MAY CONTINUE TO BE MANDATORY FOR DoD CONTRACTS. REQUIREMENTS RELATING TO QPL'S HAVE NOT BEEN ADOPTED BY THE SAE FOR THIS STANDARD AND ARE NOT PART OF THIS SAE DOCUMENT.			
CUSTODIAN: E-25		SAE values your input. To provide feedback on this Technical Report, please visit http://standards.sae.org/AS51997C THIRD ANGLE PROJECTION 	
	AEROSPACE STANDARD (R) RING, LOCK, SERRATED-HIGH STRENGTH		AS51997™ SHEET 1 OF 4
		REV. C Documents	

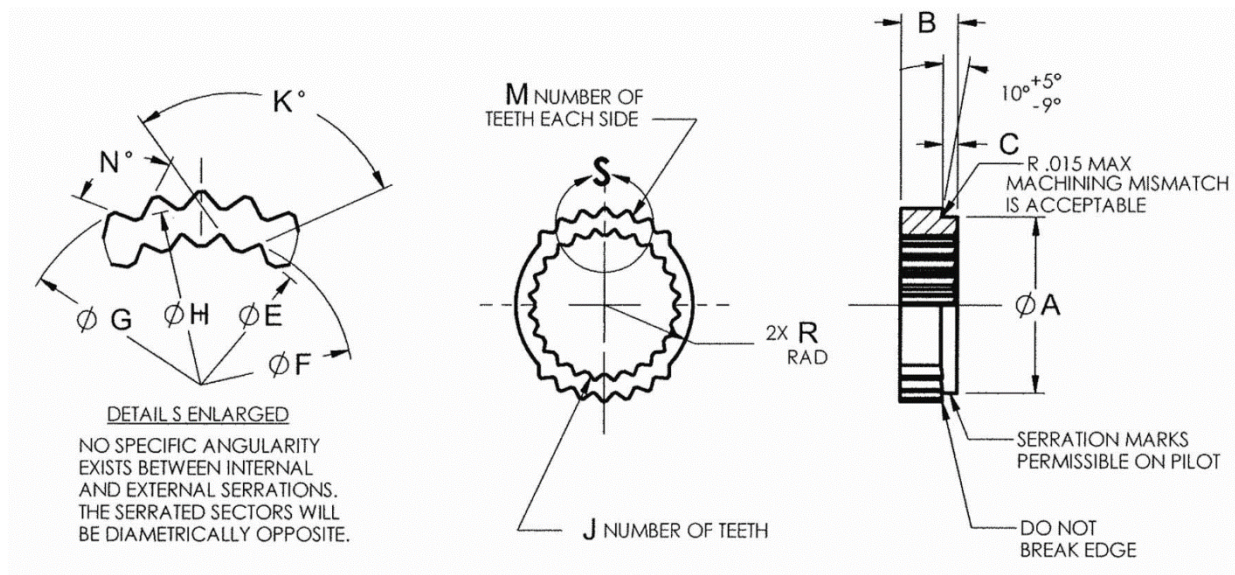


FIGURE 1

TABLE 1 - DIMENSIONS

DASH NUMBERS	ØA +.008 -.007	B +.010 -.005	C	ØE +.004 -.003	ØF	ØG +.005 -.004	ØH +.003 -.006	J	K° +1° -2°	M	N°	R RAD REF
102P	.305	.100	.044	.213	.252	.353	.310	13	102°	4	100°	.154
103P	.368	.110	.044	.266	.315	.416	.373	17	86°	5	98°	.186
104P	.430	.138	.044	.323	.364	.478	.435	20	102°	6	97°	.217
105P	.493	.157	.040	.390	.425	.541	.498	24	102°	7	96°	.248
106P	.606	.157	.040	.468	.505	.657	.611	26	102°	7	96°	.304
107P	.731	.161	.040	.574	.613	.782	.736	26	111°	8	95°	.366
108P	.856	.213	.040	.695	.740	.907	.861	30	111°	9	94°	.429
109P	.981	.213	.040	.794	.845	1.034	.986	30	111°	10	96°	.492

REQUIREMENTS:

- MATERIAL: STEEL, ALLOY, GRADE 4130 (UNS G41300) CONFORMING TO AMS6370 OR GRADE 4140 (UNS G41400) CONFORMING TO AMS6382 OR GRADE 8740 (UNS G87400) PER AMS6322. STEEL, CORROSION-RESISTANT, TYPE A286 (UNS S66286) PER AMS5731, AMS5732, AMS5734, OR AMS5737, HEAT TREATED AND AGED AS APPLICABLE.
- PROTECTIVE COATING OR TREATMENT: STEEL, ALLOY, SHALL BE CADMIUM PLATED CONFORMING TO AMS-QQ-P-416, TYPE II, CLASS 3. STEEL, CORROSION-RESISTANT, SHALL BE CLEANED, DESCALED, AND PASSIVATED IN ACCORDANCE WITH AMS2700.
- PROCUREMENT SPECIFICATION: MIL-DTL-45910.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES Ra.
- HARDNESS: ALLOY STEEL RINGS SHALL HAVE HARDNESS OF 36-45 HRC IN ACCORDANCE WITH PROCUREMENT SPECIFICATION. CORROSION-RESISTANT STEEL RINGS SHALL HAVE A HARDNESS OF 269 HB MINIMUM IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- FILLETS: FILLETS SHALL BE R .015 MAXIMUM.
- EDGES: UNLESS OTHERWISE SPECIFIED, EDGES BROKEN .003 TO .015, EXCEPT SERRATIONS.
- TOLERANCES: LINEAR DIMENSIONS $\pm .005$, ANGULAR DIMENSIONS $\pm 2^\circ$.

	AEROSPACE STANDARD	AS51997™ SHEET 2 OF 4	REV. C
	(R) RING, LOCK, SERRATED-HIGH STRENGTH		

