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AS8539™

FEDERAL SUPPLY CLASS
5110

RATIONALE

THE STANDARD SETS FORTH THE DIMENSIONS AND GAGING SYSTEM FOR THE TORX® PARALOBE® DRIVE SYSTEM AND IS SUPPLEMENTAL TO FASTENER STANDARDS DEVELOPED THAT INCORPORATE THIS DRIVE FEATURE.

AS8539 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.

SCOPE

THIS STANDARD SPECIFIES BASIC DIMENSIONS, CHARACTERISTICS, AND ENGINEERING REQUIREMENTS FOR TORX® PARALOBE® DRIVER BITS.

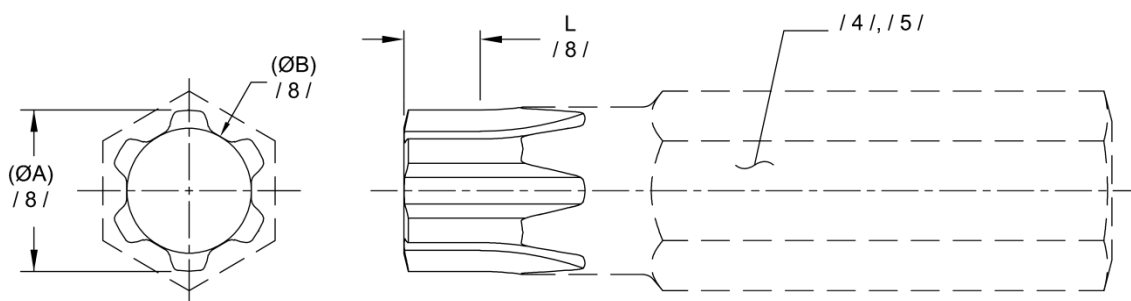
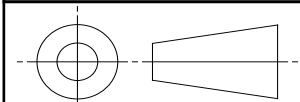


FIGURE 1 - BASIC DRIVER BIT CONFIGURATION

For more information on this standard, visit
<https://www.sae.org/standards/content/AS8539/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

BIT, INTERNAL RECESS DRIVER,
TORX® PARALOBE® DRIVE,
DIMENSIONS OF DRIVER AND GAGE

AS8539™
SHEET 1 OF 7

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TABLE 1 - BASIC DRIVER BIT CONFIGURATION DIMENSIONS

AS8539 DASH NO.	DRIVE SIZE DESCRIPTOR	(ØA) CONFIGURATION DIAMETER	(ØB) CONFIGURATION INSCRIBED DIAMETER	L CONFIGURATION LENGTH MIN	CONFIGURATION TORQUE LBF-IN MIN
001	1SI	.035	.025	.015	1.55
002	2SI	.040	.028	.018	2.27
003	3SI	.048	.033	.021	3.75
004	4SI	.054	.039	.024	5.86
005	5SI	.059	.044	.025	7.89
006	6SI	.071	.055	.030	14.6
007	7SI	.083	.063	.036	22.2
008	8SI	.096	.073	.042	35.5
009	9SI	.104	.079	.044	45.2
010	10SI	.114	.086	.048	59.2
015	15SI	.136	.104	.058	103
020	20SI	.161	.124	.067	173
025	25SI	.185	.140	.077	256
027	27SI	.208	.161	.086	375
030	30SI	.230	.178	.096	510
040	40SI	.277	.213	.116	884
045	45SI	.326	.255	.137	1480
050	50SI	.368	.284	.157	2100
055	55SI	.467	.371	.200	4460
060	60SI	.552	.430	.240	7170
070	70SI	.648	.509	.283	11700
080	80SI	.732	.568	.322	16700
090	90SI	.832	.654	.367	24900
100	100SI	.924	.727	.408	34100
110	110SI	.999	.763	.444	41600



AEROSPACE STANDARD

BIT, INTERNAL RECESS DRIVER,
TORX® PARALOBE® DRIVE,
DIMENSIONS OF DRIVER AND GAGE

AS8539™
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Documents

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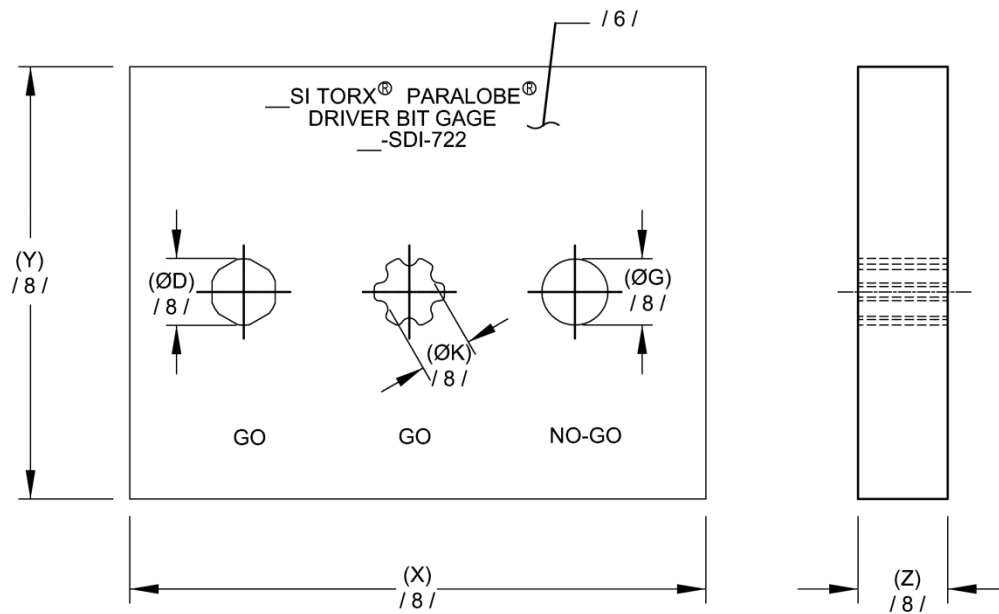


FIGURE 2 - DRIVER BIT INSPECTION GAGE

1. DRIVER BIT INSPECTION

1.1 DIMENSIONAL EXAMINATION

THE DRIVER BIT SHALL BE APPROPRIATE FOR THE DRIVE SIZE AND THE DRIVER BIT CONFIGURATION DIMENSIONS SHALL BE INSPECTED WITH THE GO NO-GO GAGES SPECIFIED IN TABLE 2.

THE DRIVER BIT CONFIGURATION LENGTH (L) TO BE MEASURED WITH A CALIPER OR OTHER APPROPRIATE METHOD.

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	BIT, INTERNAL RECESS DRIVER, TORX® PARALOBE® DRIVE, DIMENSIONS OF DRIVER AND GAGE		Documents