

AS3255

WRENCHING CONFIGURATION
PER AS 870 FOR
THIS DISTANCE

B .012 (0.30)

.5625
(14.29)
NOM

45°

Ø .760
(19.30)
Ø .740
(18.80)

- D -
B .012 (0.30)

CHAMFER 28°-32° TO
Ø .552-.572 (14.03-14.52)

MARK PART NO. AND
MANUFACTURER'S IDENT
PER AS 478 CLASS A

Ø .060-.080 (1.53-2.03)
CSK 90° TO Ø .090-.110 (2.29-2.79)
4 HOLES EQUALLY SPACED

⊕ C D M Ø .020 (0.50) M

32 (0.8 µm)

.505
.485
(12.82)
(12.32)

.260 (6.60)
.240 (6.10)

.389 (9.88)

.232 (5.90)
MIN

5° MAX

140° MIN

32 (0.8 µm)

35°-55°

Ø .416 (10.56)
Ø .396 (10.06)

Ø .472 (11.98)
Ø .462 (11.74)

.5000-20 UNJF-3A
MIL-S-8879

- B - SEE NOTE 1

.002 X L

A .006 (0.15)

.030 (0.76)
.020 (0.51) R

35° MIN TO ROOT
OF DOUBLE HEX

0.15 (0.38) R MAX

32 (0.8 µm)

SECTION THRU
THREAD PROFILE

32 (0.8 µm)

32 (0.8 µm)

32 (0.8 µm)

32 (0.8 µm)

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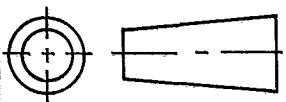
32 (0.8 µm)

32 (0.8 µm)

FED SUP CODE
5306

- FOR PART NUMBERS AS3255-03 THRU AS3255-24 THE THREAD PD SHALL REPLACE DATUM B.
- MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5662.
- HARDNESS: 36-45 HRC.
- FINISH: SILVER PLATE AMS 2411 .0002-.0006 THICK AT THREAD PD. DIMENSIONS SPECIFIED ARE AFTER PLATING.
- FLUORESCENT PENETRANT INSPECTION BEFORE PLATING PER AMS 2645.
- MANUFACTURING SPECIFICATION: AMS 7466.
- SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36-1978, REQUIREMENTS PER ANSI B46.1-1978. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 MICROINCHES (3.2 MICROMETRES) EXCEPT UPSET HEAD.
- BREAK SHARP EDGES .003-.015 (0.08-0.38) UNLESS OTHERWISE SPECIFIED.
- DIMENSIONS IN INCHES (MILLIMETRES). METRIC CONVERSIONS ARE INTERNATIONAL SYSTEM UNITS (SI). UNLESS OTHERWISE SPECIFIED, TOLERANCES: ANGULAR DIMENSIONS $\pm 5^\circ$.
- DIMENSIONING AND TOLERANCING: ANSI Y14.5-1973.
- DO NOT USE UNASSIGNED PART NUMBERS.

THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE E-25, ENGINE AND PROPELLER STANDARD UTILITY PARTS

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

AEROSPACE STANDARD
BOLT, MACHINE-DOUBLE HEX EXTENDED WASHER HEAD,
DRILLED, PD SHANK, SILVER PLATED .5000-20 UNJF-3A

AS3255

SHEET 1 OF 2

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