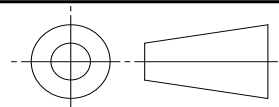


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REV. E	FEDERAL SUPPLY CLASS 5120	
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PROCUREMENT SPECIFICATION: NONE		
	AEROSPACE STANDARD WRENCHING CONFIGURATION, BI-HEXAGONAL (12 POINT) DRIVE, DESIGN STANDARD FOR	AS870
		REV. E

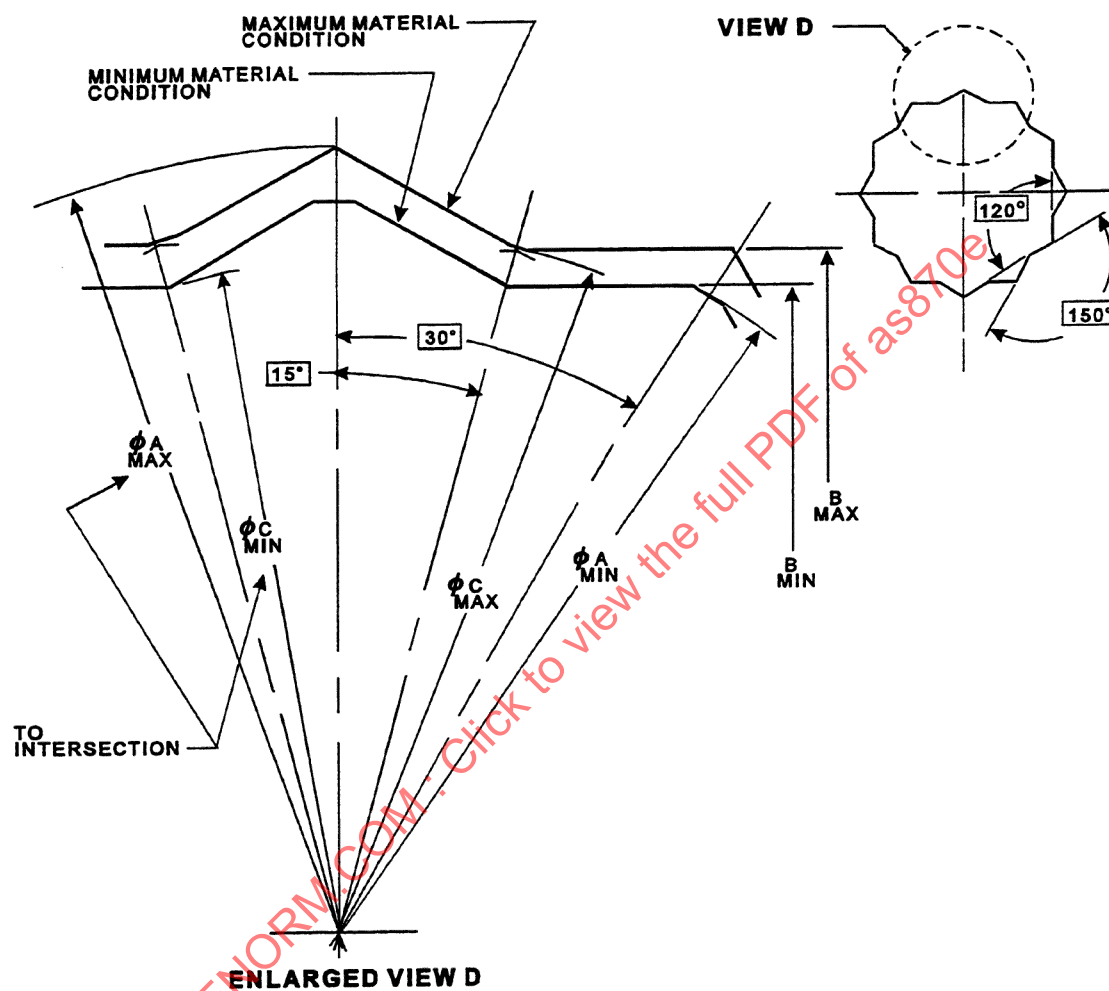


FIGURE 1

	AEROSPACE STANDARD		AS870 SHEET 1 OF 3	REV. E
	WRENCHING CONFIGURATION, BI-HEXAGONAL (12 POINT) DRIVE, DESIGN STANDARD FOR			

TABLE 1

AS870 DASH NO.	NOMINAL WRENCHING ELEMENT SIZE	MAXIMUM MATERIAL SIZE øA MAX /1/	MAXIMUM MATERIAL SIZE B MAX /2/	MAXIMUM MATERIAL SIZE øC MAX /3/	MINIMUM MATERIAL SIZE øA MIN /4/	MINIMUM MATERIAL SIZE B MIN /5/	MINIMUM MATERIAL SIZE øC MIN /6/
06	.1875	.2182	.189	.197	.209	.184	.1905
07	.2188	.2540	.220	.229	.244	.215	.2226
08	.2500	.2898	.251	.262	.278	.245	.2536
09	.2812	.3256	.282	.294	.313	.276	.2857
10	.3125	.3614	.313	.326	.348	.307	.3178
11	.3438	.3984	.345	.360	.385	.339	.3510
12	.3750	.4342	.376	.392	.420	.370	.3831
14	.4375	.5069	.439	.458	.490	.432	.4472
16	.5000	.5797	.502	.524	.562	.495	.5125
18	.5625	.6513	.564	.588	.632	.557	.5766
20	.6250	.7240	.627	.654	.703	.617	.6388
22	.6875	.7967	.690	.720	.775	.680	.7040
24	.7500	.8683	.752	.784	.844	.740	.7661
25	.7812	.9041	.783	.817	.879	.771	.7982
26	.8125	.9399	.814	.849	.914	.802	.8303
28	.8750	1.0127	.877	.915	.986	.865	.8955
30	.9375	1.0854	.940	.980	1.058	.928	.9607
32	1.0000	1.1570	1.002	1.045	1.129	.990	1.0249
34	1.0625	1.2286	1.064	1.110	1.199	1.052	1.0891
36	1.1250	1.3013	1.127	1.175	1.271	1.115	1.1543
38	1.1875	1.3741	1.190	1.241	1.343	1.178	1.2196
40	1.2500	1.4457	1.252	1.306	1.409	1.236	1.2796
42	1.3125	1.5173	1.314	1.371	1.480	1.298	1.3438
44	1.3750	1.5900	1.377	1.436	1.552	1.361	1.4090
46	1.4375	1.6628	1.440	1.502	1.623	1.424	1.4742
48	1.5000	1.7344	1.502	1.567	1.694	1.486	1.5384
50	1.5625	1.8071	1.565	1.632	1.766	1.549	1.6036
52	1.6250	1.8787	1.627	1.697	1.837	1.611	1.6678
54	1.6875	1.9514	1.690	1.763	1.908	1.674	1.7331
56	1.7500	2.0230	1.752	1.828	1.979	1.736	1.7972
58	1.8125	2.0958	1.815	1.893	2.051	1.799	1.8625
60	1.8750	2.1674	1.877	1.958	2.122	1.861	1.9266
62	1.9375	2.2401	1.940	2.023	2.193	1.924	1.9919
64	2.0000	2.3117	2.002	2.088	2.262	1.984	2.0540
66	2.0625	2.3833	2.064	2.153	2.332	2.046	2.1182
68	2.1250	2.4560	2.127	2.218	2.404	2.109	2.1834
70	2.1875	2.5288	2.190	2.284	2.476	2.172	2.2486
72	2.2500	2.6004	2.252	2.349	2.547	2.234	2.3128
74	2.3125	2.6720	2.314	2.414	2.617	2.296	2.3770
76	2.3750	2.7447	2.377	2.479	2.689	2.359	2.4422

/1/ A MAX = 1.1547 X B MAX

/2/ B MAX = NOMINAL WRENCHING SIZE +.001 (WHERE NOM. WRENCHING SIZE IS LESS THAN .500)
NOMINAL WRENCHING SIZE +.002 (WHERE NOM. WRENCHING SIZE IS .500 OR GREATER).

/3/ C MAX = 1.043 X B MAX

/4/ A MIN = 1.135 X B MIN (WHERE B MIN IS LESS THAN .617)
1.140 X B MIN (WHERE B MIN IS .617 OR GREATER)/5/ B MIN = B MAX LESS TOLERANCE TO ANSI B4.1 - h12 (WHERE B MAX IS LESS THAN .627)
B MAX LESS TOLERANCE TO ANSI B4.1 - h13 (WHERE B MAX IS .627 OR GREATER)

/6/ C MIN = 1.035276 X B MIN



AEROSPACE STANDARD

WRENCHING CONFIGURATION, BI-HEXAGONAL
(12 POINT) DRIVE,
DESIGN STANDARD FORAS870
SHEET 2 OF 3REV.
E