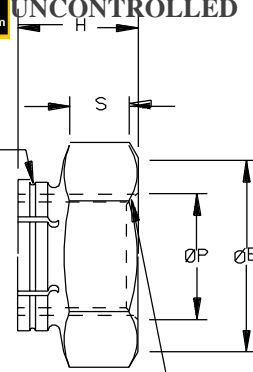


GROOVE ON BAND TO IDENTIFY 8 PITCH SERIES



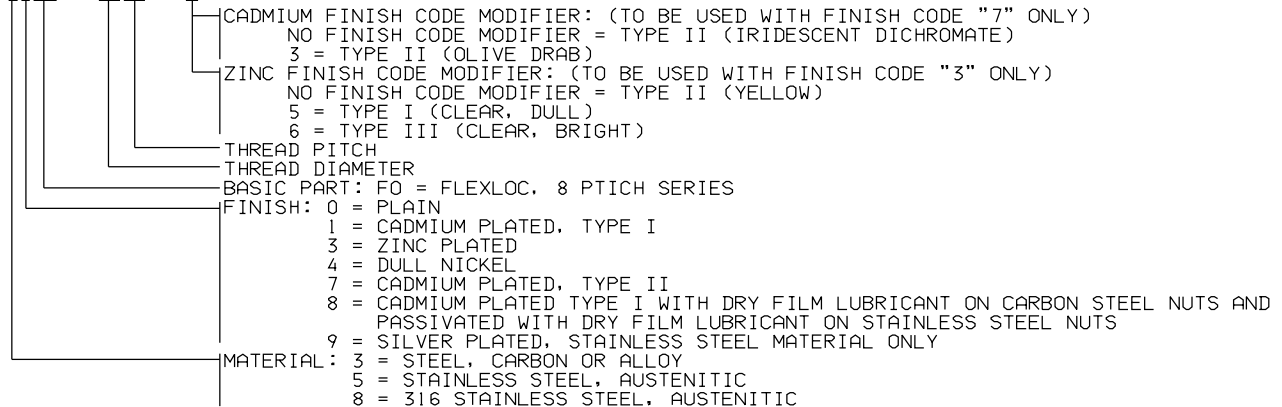
COUNTERSINK COUNTERBORE OR RADIUS RELIEF THREAD WITHIN THE LIMITS OF ØP

MARK "S" OR "SPS" LOCATION OPTIONAL AS SHOWN. ADD "C" FOR STAINLESS MATERIAL MULTIPLE MARKING PERMITTED

DASH NUMBER	THREADS PER MIL-S-7742	ØB MIN	C MIN	H MAX	ØP MAX	S MIN	W MAX/MIN	AXIAL STRENGTH LBS MIN	WEIGHT APPROX LBS/100
1608	1.0000-8 UNC-2B	1.614	1.832	1.010	1.064	.479	1.627/1.614	84,800	37.48
1808	1.1250-8 UN-2B	1.801	2.046	1.135	1.191	.549	1.814/1.801	111,000	52.13
2008	1.2500-8 UN-2B	1.988	2.259	1.260	1.315	.616	2.002/1.988	130,000	69.61
2208	1.3750-8 UN-2B	2.176	2.473	1.385	1.440	.684	2.190/2.176	160,000	90.84
2408	1.5000-8 UN-2B	2.363	2.688	1.510	1.565	.748	2.377/2.363	194,000	115.61
2608	1.6250-8 UN-2B	2.549	2.899	1.635	1.690	.814	2.564/2.549	231,000	144.09
2808	1.7500-8 UN-2B	2.737	3.114	1.760	1.815	.882	2.752/2.737	270,000	177.83
3008	1.8750-8 UN-2B	2.925	3.328	1.885	1.940	.950	2.940/2.925	313,000	217.10
3208	2.0000-8 UN-2B	3.112	3.542	2.010	2.065	1.018	3.127/3.112	360,000	261.36
3608	2.2500-8 UN-2B	3.487	3.970	2.260	2.320	1.170	3.502/3.487	427,000	316.40
4008	2.5000-8 UN-2B	3.862	4.398	2.510	2.570	1.250	3.877/3.862	600,000	435.00

- MATERIAL: CARBON STEEL, STAINLESS STEEL, AUSTENITIC, 316 STAINLESS STEEL, AUSTENITIC.
- FINISH: CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 2. (CARBON STEEL ONLY)  
 CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. (CARBON STEEL ONLY)  
 DULL NICKEL PER AMS 2403. (CARBON STEEL ONLY)  
 SILVER PLATE PER AMS 2410. (STAINLESS STEEL ONLY)  
 ZINC PLATE PER ASTM B 6333, TYPE DEFINED BY FINISH CODE MODIFIER, Fe/Zn 5. (CARBON STEEL ONLY)  
 PLAIN. (CARBON STEEL PARTS WILL BE SUPPLIED WITH RUST PREVENTATIVE OIL, AND STAINLESS STEEL PARTS WILL BE PASSIVATED)
- LUBRICANT: UNLESS OTHERWISE SPECIFIED, PARTS SHALL BE SUPPLIED WITH A NON-DRY LUBRICANT (WAX TYPE), AND WHEN SPECIFIED, MOLYBDENUM DISULFIDE DRY FILM LUBRICANT.
- THREADS: BEFORE LUBRICATION PER MIL-S-7742.
- LOCKING TORQUE PER NASM25027 AS APPLICABLE, EXCEPT REUSABILITY NOT REQUIRED ON UNPLATED STAINLESS STEEL NUTS AND LIMITED TO 5 REUSE CYCLES ON UNPLATED, DRY FILM LUBRICATED, STAINLESS STEEL NUTS.
- DISCONTINUITIES PER NASM25027.
- DIMENSIONS SHALL BE MET PRIOR TO LUBRICATION ON DRY FILM LUBRICATED NUTS.
- DIMENSIONS ARE IN INCHES.
- BREAK SHARP EDGES.
- SURFACE TEXTURE PER ANSI B46.1 SHALL NOT EXCEED 125 MICROINCHES UNLESS OTHERWISE SPECIFIED.
- USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO BE USED ON EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
- PART NUMBER SYSTEM:

33FO - 1608 - 5



EXAMPLES: 33FO-1608-5 = 1.000 DIAMETER, 8 PITCH THREAD, SELF-LOCKING FLEXLOC MADE FROM CARBON STEEL WITH ZINC PLATE PER ASTM B633, TYPE I (CLEAR,DULL), Fe/Zn5.  
 59FO-2808 = 1.750 DIAMETER, 9 PITCH THREAD, SELF-LOCKING FLEXLOC MADE FROM STAINLESS STEEL WITH SILVER PLATE PER AMS 2410.

INFORMATION ON THIS DOCUMENT IS A TRADE SECRET, PROPRIETARY, AND SHALL NOT BE USED OR REPRODUCED IN WHOLE OR IN PART WITHOUT WRITTEN AUTHORIZATION OF SPS TECHNOLOGIES.

TOLERANCES ±.010 AND ±2" SURFACE ROUGHNESS 125 UNLESS OTHERWISE NOTED DRAWN BY: STEVE FOSTER APPROVED: M ZATAVESKI APPROVED: M LAWLER	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M DATE: 1/14/91 DATE: 4/28/2000	SPS TECHNOLOGIES	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS NASM25027 EXCEPT AS NOTED PART NUMBER: ( ) ( ) FO - ( ) - ( ) SHEET 1 OF 1
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DRAWING NUMBER: SPS-N-09457  
 ISSUE DATE: 10/01/52  
 REVISION: 6  
 1/15/91  
 REVISED AND REDRAWN: 7  
 10/04/91  
 8  
 6/16/95  
 9  
 2/21/96  
 10  
 11/24/97  
 11  
 4/14/2000