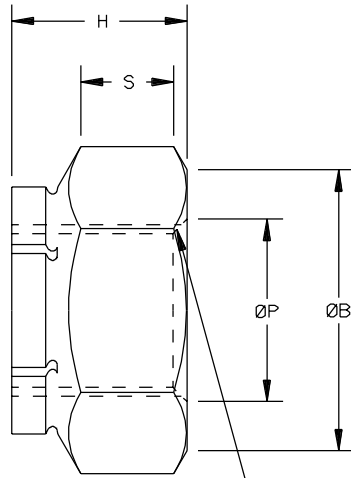
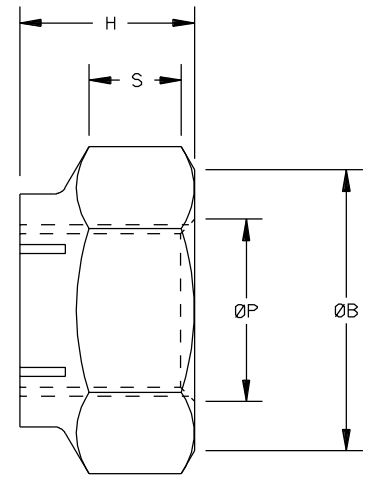


MARK "S" OR "SPS"  
ALSO MARK STAINLESS  
MATERIAL WITH A "C".  
LOCATION OPTIONAL  
AS SHOWN. MULTIPLE  
MARKING PERMITTED



STYLE A



STYLE B

COUNTERSINK, COUNTERBORE, OR RADIUS RELIEF  
TO THREADS WITHIN THE LIMITS OF ØP

EITHER STYLE TO BE SUPPLIED AT SPS' OPTION

TYPE	DASH NUMBER	THREADS SEE NOTE 5	ØB MIN	C MIN	H MAX	ØP MAX	S MIN	W		AXIAL STRENGTH LBS MIN			WEIGHT APPROX LBS/100
								MAX	MIN	STEEL AND STAINLESS	ALUMINUM	BRASS	
FAC	420	.250-20 UNC-2B	.492	.552	.290	.293	.094	.502	.492	5,730	4,000	2,040	1.02
FA	518	.312-18 UNC-2B	.553	.623	.321	.356	.113	.564	.553	9,600	5,800	3,680	1.47
FA	616	.375-16 UNC-2B	.616	.694	.384	.418	.144	.627	.616	13,800	6,900	5,420	2.09
FA	714	.437-14 UNC-2B	.741	.836	.446	.487	.163	.752	.741	14,900	7,470	6,400	3.37
FA	813	.500-13 UNC-2B	.803	.907	.509	.551	.196	.814	.803	22,000	11,000	9,430	4.38
FAC	912	.562-12 UNC-2B	.928	1.049	.571	.614	.216	.940	.928	27,000	13,700	11,700	8.58
FA	1011	.625-11 UNC-2B	.990	1.121	.634	.676	.245	1.002	.990	34,000	17,000	14,500	8.22
FA	1210	.750-10 UNC-2B	1.115	1.263	.759	.807	.325	1.127	1.115	50,000	24,900	21,300	12.23
FA	1409	.875-9 UNC-2B	1.301	1.476	.884	.938	.397	1.314	1.301	64,600	34,100	29,200	19.44
FA	1608	1.000-8 UNC-2B	1.489	1.690	1.009	1.064	.462	1.502	1.489	85,000	42,400	37,900	30.13
FN	1807	1.125-7 UNC-2B	1.801	2.046	1.134	1.191	.549	1.814	1.801	106,000	53,000	46,700	52.13
FN	2007	1.250-7 UNC-2B	1.988	2.259	1.259	1.315	.616	2.002	1.988	125,000	63,300	55,000	69.61
FN	2206	1.375-6 UNC-2B	2.176	2.473	1.384	1.440	.684	2.190	2.176	145,000	72,500	62,100	90.84
FN	2406	1.500-6 UNC-2B	2.363	2.688	1.509	1.565	.748	2.377	2.363	182,000	91,000	78,000	115.61
FN	2605	1.625-5 1/2 NS-2B	2.549	2.900	1.634	1.690	.814	2.564	2.549	194,000	97,000	83,100	144.09
FN	2805	1.750-5 UNC-2B	2.737	3.114	1.759	1.815	.882	2.752	2.737	233,000	116,500	99,800	177.83
FN	3005	1.875-5 NS-2B	2.925	3.329	1.884	1.940	.950	2.940	2.925	257,000	128,500	110,100	217.10
FN	3204	2.000-4 1/2 UNC-2B	3.112	3.542	2.009	2.065	1.018	3.127	3.112	310,000	155,000	132,700	261.36

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: 7/29/91  
DATE: 4/25/2000



TITLE  
NUT, FLEXLOC, HEAVY DUTY SERIES, SELF-LOCKING

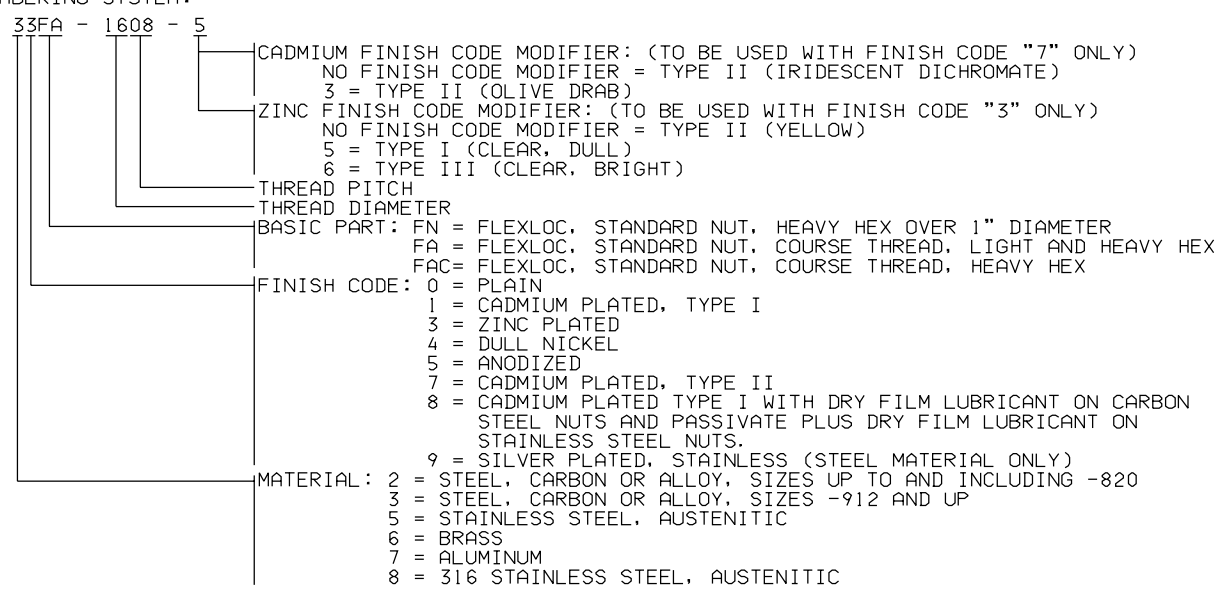
FSCM NO. 56878  
CUSTODIAN:  
JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS  
NASM25027  
AS APPLICABLE

PART NUMBER: **FN, FA & FAC**  
SHEET 1 OF 2



1. MATERIAL: CARBON STEEL.  
STAINLESS STEEL, AUSTENITIC.  
316 STAINLESS STEEL, AUSTENITIC.  
BRASS, NAVAL HALF HARD.  
ALUMINUM, 2024-T4 OR 2024-T351.
2. FINISH: PLAIN. (CARBON STEEL PARTS WILL BE SUPPLIED WITH A RUST PREVENTATIVE OIL, AND STAINLESS STEEL PARTS WILL BE PASSIVATED)  
CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 2. (CARBON STEEL AND BRASS ONLY)  
CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. (CARBON STEEL ONLY)  
DULL NICKEL PLATE PER AMS 2403. (CARBON STEEL ONLY)  
SILVER PLATE PER AMS 2410. (STAINLESS STEEL ONLY)  
ZINC PLATE PER ASTM B633, TYPE DEFINED BY FINISH CODE MODIFIER, Fe/Zn 5. (CARBON STEEL ONLY)  
ANODIZE PER MIL-A-8625. (ALUMINUM ONLY)
3. LUBRICANT: UNLESS OTHERWISE SPECIFIED, PARTS SHALL BE SUPPLIED WITH A NON-DRY LUBRICANT (WAX TYPE), AND WHEN SPECIFIED, MOLYBDENUM DISULFIDE DRY FILM LUBRICANT.
4. THREADS: BEFORE LUBRICATION PER MIL-S-7742 CLASS 2B.
5. 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.
6. DISCONTINUITIES PER NASM25027.
7. DIMENSIONS SHALL BE MET PRIOR TO LUBRICATION ON DRY FILM LUBRICATED NUTS.
8. DIMENSIONS ARE IN INCHES.
9. BREAK SHARP EDGES.
10. SURFACE TEXTURE PER ANSI B46.1 SHALL NOT EXCEED 125 MICROINCHES UNLESS OTHERWISE SPECIFIED.
11. USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO BE USED ON EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
12. PART NUMBERING SYSTEM:



EXAMPLES: 33FN-1807-5 = 1.125 DIAMETER, STANDARD, HEAVY HEX, SELF-LOCKING FLEXLOC MADE FROM CARBON STEEL WITH ZINC PLATE PER ASTM B633, TYPE I (CLEAR DULL), Fe/Zn5.

59FAC-2406 = 1.500 DIAMETER, STANDARD, COURSE THREAD, HEAVY HEX, SELF-LOCKING FLEXLOC MADE FROM STAINLESS STEEL WITH SILVER PLATE PER AMS 2410.

TOLERANCES ±.010 AND ±2°  
SURFACE ROUGHNESS 125  
UNLESS OTHERWISE NOTED

THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M



PART NUMBER: **FN, FA & FAC**  
SHEET 2 OF 2