

MARK "S" OR "SPS"  
ON .190 SIZE AND  
LARGER. ALSO MARK  
STAINLESS MATERIAL  
WITH "C". LOCATION  
OPTIONAL AS SHOWN.  
MULTIPLE MARKING  
PERMITTED.

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

STYLE A

STYLE B

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	
FA	256	.086-56 UNJC-3B	.243	.268	.155	.129	.050	.251	.243	650	457	252	.15
FA	348	.099-48 UNJC-3B	.243	.268	.155	.142	.050	.251	.243	865	605	333	.15
FA	440	.112-40 UNJC-3B								1,080	750	414	
FC	448	.112-48 UNJF-3B	.243	.268	.155	.155	.050	.251	.243	1,190	830	458	.14
FA	540	.125-40 UNJC-3B								1,400	990	546	
FC	544	.125-44 UNJF-3B	.243	.268	.155	.168	.052	.251	.243	1,450	1,030	568	.13
FA	632	.138-32 UNJC-3B								1,620	1,130	624	
FC	640	.138-40 UNJF-3B	.305	.339	.180	.181	.075	.313	.305	1,890	1,320	728	.27
FA	832	.164-32 UNJC-3B								2,510	1,720	936	
FC	836	.164-36 UNJF-3B	.336	.375	.243	.208	.105	.345	.336	2,620	1,800	979	.46
FA	1024	.190-24 UNJC-3B								3,120	2,140	1,130	
FC	1032	.190-32 UNJF-3B	.367	.410	.243	.230	.085	.376	.367	3,590	2,460	1,300	.53
FA	1224	.216-24 UNJC-3B								4,350	3,000	1,530	
FC	1228	.216-28 UNJF-3B	.430	.481	.290	.258	.122	.439	.430	4,630	3,190	1,630	.89
FA	420	.250-20 UNC-2B			.290	.258	.122			5,730	4,000	2,040	
FC	428	.250-28 UNJF-3B	.430	.481	.320	.293	.135	.439	.430	6,550	4,580	2,330	.80
FAF	518	.312-18 UNC-2B			.462	.427	.210			9,600	5,800	3,680	.90
FC	524	.312-24 UNJF-3B	.492	.552	.353	.356	.150	.502	.492	9,950	6,390	3,810	1.30
FAF	616	.375-16 UNC-2B			.462	.418	.210			13,800	6,900	5,420	1.30
FC	624	.375-24 UNJF-3B	.553	.623	.462	.418	.210	.564	.553	13,500	7,250	5,700	1.95
FAF	714	.437-14 UNC-2B	.616	.694	.462	.427	.210	.627	.616	14,900	7,470	6,400	2.30
FC	720	.437-20 UNJF-3B	.616	.694	.462	.427	.210	.627	.616	15,450	7,750	7,730	2.30
FC	720 UN	.437-20 UNJF-3B	.679	.765	.462	.427	.210	.690	.679	18,300	9,150	8,520	2.85
FAF	813	.500-13 UNC-2B			.602	.551	.285			22,000	11,000	9,430	2.85
FC	820	.500-20 UNJF-3B	.741	.836	.602	.551	.285	.752	.741	23,800	11,900	10,300	4.35
FA	912	.562-12 UNC-2B			.696	.614	.385			27,000	13,700	11,700	5.73
FC	918	.562-18 UNJF-3B	.865	.978	.696	.614	.385	.877	.865	30,000	15,200	13,000	7.15
FAF	1011	.625-11 UNC-2B		1.049	.759	.676	.410			34,000	17,000	14,500	7.15
FC	1018	.625-18 UNJF-3B	.928	1.049	.759	.676	.410	.940	.928	38,400	19,200	16,300	8.73
FAF	1210	.750-10 UNC-2B			.884	.807	.505			50,000	24,900	21,300	
FC	1216	.750-16 UNJF-3B	1.052	1.192	.884	.807	.505	1.064	1.052	52,300	26,100	23,700	12.38
FAF	1409	.875-9 UNC-2B			1.009	.938	.570			64,600	34,100	29,200	
FC	1414	.875-14 UNJF-3B	1.239	1.405	1.009	.938	.570	1.252	1.239	71,400	37,700	32,400	19.46
FAF	1608	1.000-8 UNC-2B			1.134	1.064	.635			85,000	42,400	37,900	
FC	1612	1.000-12 UNJF-3B	1.427	1.619	1.134	1.064	.635	1.440	1.427	92,500	44,200	40,800	28.52
FC	1614	1.000-14 UNJS-3B								92,500	46,200	41,400	
FC	1812	1.125-12 UNJF-3B	1.614	1.832	1.259	1.191	.710	1.627	1.614	119,000	59,500	52,400	41.95
FC	2012	1.250-12 UNJF-3B	1.801	2.046	1.446	1.315	.795	1.814	1.801	148,000	75,000	65,200	60.37
FC	2212	1.375-12 UNJF-3B	1.988	2.259	1.509	1.440	.815	2.002	1.988	170,000	85,000	72,800	87.71
FC	2412	1.500-12 UNJF-3B	2.176	2.473	1.759	1.565	.970	2.190	2.176	206,000	103,000	88,300	114.48
FC	2812	1.750-12 UNJ-3B	2.737	3.114	2.010	1.815	1.124	2.752	2.737	273,000	136,500	117,000	194.20
FC	3012	1.875-12 UNJ-3B	2.925	3.328	2.140	1.940	1.190	2.940	2.925	316,000	158,000	135,400	235.10
FC	3212	2.000-12 UNJ-3B	3.112	3.542	2.260	2.065	1.260	3.127	3.112	362,000	181,000	155,000	280.92

\* UN FOLLOWING DASH NUMBER SIGNIFIES UNIFIED HEX.

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: 7/16/91  
DATE: 9/17/02



TITLE  
NUT, FLEXLOC, LIGHT HEX SERIES, SELF-LOCKING

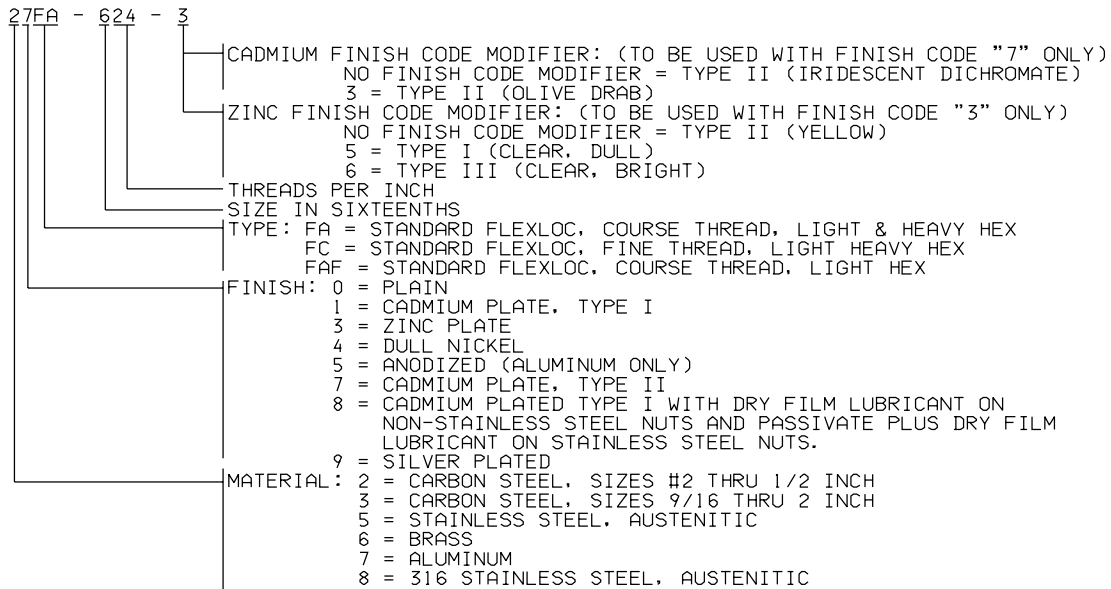
FSCM NO. 56878  
CUSTODIAN:  
JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS  
NASM25027  
AS APPLICABLE

PART NUMBER: **FC, FA & FAF**  
SHEET 1 OF 2  
ER-020



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 AND BRASS 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)  
DULL NICKEL PER AMS 2403. (CARBON STEEL ONLY)
3. LUBRICANT: PARTS SHALL BE SUPPLIED WITH A NON-DRY LUBRICANT (WAX TYPE) SOLUBLE IN THE CLEANER SPECIFIED IN NASM25027, AND WHEN SPECIFIED, MOLYBDENUM DISULFIDE DRY FILM LUBRICANT PER NASM25027.
4. LOCKING TORQUE PER NASM25027 AS APPLICABLE. SIZES ABOVE THOSE LISTED IN NASM25027 SHALL MEET THE LOCKING TORQUE REQUIREMENTS OF THE LARGEST SIZE LISTED. REUSABILITY NOT REQUIRED FOR UNPLATED STAINLESS STEEL NUTS, AND LIMITED TO FIVE REUSE CYCLES ON UNPLATED, DRY FILM LUBRICATED, STAINLESS STEEL NUTS.
5. THREADS ARE BEFORE LUBRICATION PER AS8879 FOR CLASS 3B THREAD AND MIL-S-7742 FOR CLASS 2B THREAD.
6. DIMENSIONS SHALL BE MET PRIOR TO LUBRICATION ON DRY FILM LUBRICATED NUTS.
7. DIMENSIONS ARE IN INCHES.
8. WEIGHTS APPLY TO STEEL NUTS ONLY.
9. BREAK SHARP EDGES.
10. PART NUMBER SYSTEM:



11. USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO BE USED ON EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
12. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.
13. PART NUMBERS OTHER THAN LISTED ON THIS DRAWING SHALL NOT BE USED.