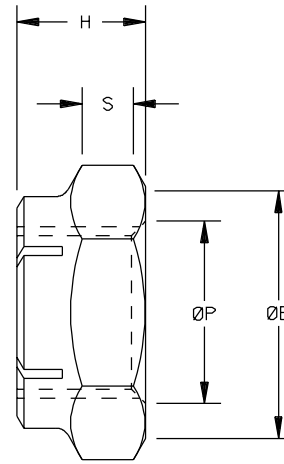
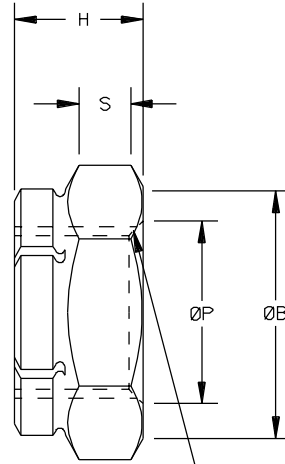


MARK "S" OR "SPS"
ON .190 SIZE AND
LARGER ALSO MARK
STAINLESS MATERIAL
WITH "C". LOCATION
OPTIONAL AS SHOWN.
MULTIPLE MARKING
PERMITTED



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

STYLE A

STYLE B

EITHER SYLE 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 | |
| FK | 632 | .138-32 UNJC-3B | | | | | | | | 1,270 | 650 | 560 | |
| FK | 640 | .138-40 UNJF-3B | .305 | .339 | .141 | .181 | .036 | .313 | .305 | 1,420 | 730 | 625 | .20 |
| FK | 832 | .164-32 UNJC-3B | | | | | | | | 1,960 | 1,010 | 865 | |
| FK | 836 | .164-36 UNJF-3B | .336 | .375 | .188 | .208 | .070 | .345 | .336 | 2,060 | 1,060 | 908 | .35 |
| FK | 1024 | .190-24 UNJC-3B | | | | | | | | 2,450 | 1,270 | 1,090 | |
| FK | 1032 | .190-32 UNJF-3B | .367 | .410 | .188 | .230 | .065 | .376 | .367 | 2,800 | 1,450 | 1,240 | .38 |
| FK | 1224 | .216-24 UNJC-3B | | | | | | | | 3,380 | 1,740 | 1,490 | |
| FK | 1228 | .216-28 UNJF-3B | .430 | .481 | .209 | .258 | .071 | .439 | .430 | 3,610 | 1,860 | 1,590 | .62 |
| FK | 420 | .250-20 UNC-2B | | | | | | | | 4,450 | 2,290 | 1,960 | |
| FK | 428 | .250-28 UNJF-3B | .430 | .481 | .219 | .293 | .075 | .439 | .430 | 5,090 | 2,620 | 2,240 | .61 |
| FKF | 518 | .312-18 UNC-2B | | | | | | | | 4,980 | 3,030 | 2,590 | |
| FK | 524 | .312-24 UNJF-3B | .492 | .552 | .266 | .356 | .097 | .502 | .492 | 5,510 | 3,350 | 2,870 | .97 |
| FKF | 616 | .375-16 UNC-2B | | | | | | | | 7,360 | 3,890 | 3,330 | |
| FK | 624 | .375-24 UNJF-3B | .553 | .623 | .282 | .418 | .108 | .564 | .553 | 8,340 | 4,390 | 3,760 | 1.69 |
| FKF | 714 | .437-14 UNC-2B | .616 | .694 | | | .138 | .627 | .616 | 10,100 | 5,290 | 4,530 | 1.71 |
| FK | 720 | .437-20 UNJF-3B | .616 | .694 | .328 | .487 | .138 | .627 | .616 | 11,300 | 5,900 | 5,060 | 1.71 |
| FK | 720 UN | .437-20 UNJF-3B | .679 | .765 | | | .120 | .690 | .679 | 11,300 | 5,900 | 6,170 | 2.13 |
| FKF | 813 | .500-13 UNC-2B | | | | | | | | 11,400 | 6,480 | 5,550 | |
| FK | 820 | .500-20 UNJF-3B | .741 | .836 | .328 | .551 | .121 | .752 | .741 | 12,800 | 7,250 | 6,210 | 2.39 |
| FK | 912 | .562-12 UNC-2B | | | | | | | | 14,600 | 10,060 | 8,620 | |
| FK | 918 | .562-18 UNJF-3B | .865 | .978 | .368 | .614 | .135 | .877 | .865 | 16,200 | 11,100 | 9,510 | 3.66 |
| FKF | 1011 | .625-11 UNC-2B | | | | | | | | 18,100 | 10,700 | 9,170 | |
| FK | 1018 | .625-18 UNJF-3B | .928 | 1.049 | .399 | .676 | .147 | .940 | .928 | 20,500 | 12,100 | 10,370 | 4.38 |
| FKF | 1210 | .750-10 UNC-2B | | | | | | | | 26,800 | 13,100 | 11,200 | |
| FK | 1216 | .750-16 UNJF-3B | 1.052 | 1.192 | .415 | .807 | .155 | 1.064 | 1.052 | 29,800 | 14,600 | 12,510 | 6.04 |
| FKF | 1409 | .875-9 UNC-2B | | | | | | | | 36,940 | 20,400 | 17,500 | |
| FK | 1414 | .875-14 UNJF-3B | 1.239 | 1.405 | .477 | .938 | .166 | 1.252 | 1.239 | 40,800 | 22,500 | 19,280 | 9.44 |
| FKF | 1608 | 1.000-8 UNC-2B | | | | | | | | 48,500 | 26,800 | 22,970 | |
| FK | 1612 | 1.000-12 UNJF-3B | 1.427 | 1.619 | .571 | 1.064 | .218 | 1.440 | 1.427 | 53,000 | 28,000 | 24,000 | 15.24 |
| FK | 1614 | 1.000-14 UNJF-3B | | | | | | | | 54,400 | 28,200 | 24,170 | |
| FK | 1812 | 1.125-12 UNJF-3B | 1.614 | 1.832 | .634 | 1.191 | .238 | 1.627 | 1.614 | 68,500 | 29,900 | 25,620 | 19.19 |
| FK | 2012 | 1.250-12 UNJF-3B | 1.801 | 2.046 | .759 | 1.315 | .311 | 1.814 | 1.801 | 85,800 | 37,500 | 32,140 | 39.14 |
| FK | 2212 | 1.375-12 UNJF-3B | 1.988 | 2.259 | .821 | 1.440 | .325 | 2.002 | 1.988 | 90,700 | 40,300 | 34,540 | 41.99 |
| FK | 2412 | 1.500-12 UNJF-3B | 2.176 | 2.473 | .884 | 1.565 | .350 | 2.190 | 2.176 | 109,000 | 48,400 | 41,480 | 57.56 |

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

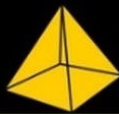


FSCM NO. 56878
CUSTODIAN:
JENKINTOWN, PA.

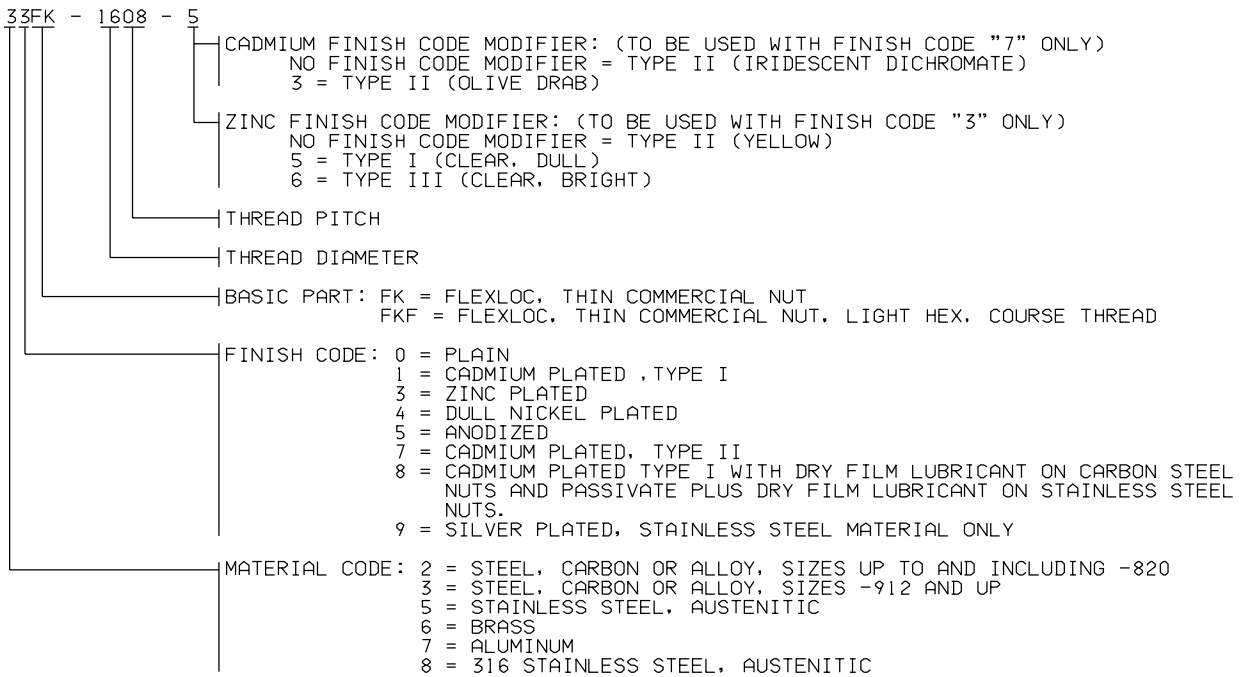
STANDARDS AND SPECIFICATIONS
NASM25027
AS APPLICABLE

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

PART NUMBER: **FK & FKF**
SHEET 1 OF 2



1. MATERIAL: STEEL, CARBON.
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 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/Fn 5. (CARBON STEEL ONLY)
ANODIZE PER MIL-A-8625. (ALUMINUM ONLY)
3. WEIGHTS APPLY TO CARBON STEEL NUTS.
4. LUBRICANT: UNLESS OTHERWISE SPECIFIED, PARTS SHALL BE SUPPLIED WITH A NON-DRY LUBRICANT (WAX TYPE), AND WHEN SPECIFIED, MOLYBDENUM DISULFIDE DRY FILM LUBRICANT.
5. THREADS: BEFORE LUBRICATION PER MIL-S-7742 CLASS 2B AND AS8879 FOR CLASS 3B.
6. 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.
7. DISCONTINUITIES PER NASM25027.
8. DIMENSIONS SHALL BE MET PRIOR TO LUBRICATION ON DRY FILM LUBRICATED NUTS.
9. DIMENSIONS ARE IN INCHES.
10. BREAK SHARP EDGES.
11. SURFACE TEXTURE PER ANSI B46.1 SHALL NOT EXCEED 125 MICROINCHES UNLESS OTHERWISE SPECIFIED.
12. USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO BE USED ON EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
13. PART NUMBERING SYSTEM:



EXAMPLES: 33FK-1812-5 = 1.125 DIAMETER, THIN COMMERCIAL, SELF-LOCKING FLEXLOC MADE FROM CARBON STEEL WITH ZINC PLATE PER ASTM B633, TYPE I (CLEAR, DULL), Fe/Zn5.

59FKF-1608 = 1.000 DIAMETER, THIN COMMERCIAL, LIGHT HEX, COARSE THREAD, SELF-LOCKING FLEXLOC MADE FROM STAINLESS STEEL WITH SILVER PLATE PER AMS 2410.