

STAMP "S" OR "SPS"
ON .190 SIZE AND
LARGER. LOCATION
OPTIONAL AS SHOWN.
MULTIPLE MARKING
PERMITTED

DASH NUMBER	THREAD SIZE	C MIN	ØD +.005 -.000	ØE +.000 -.003	ØF +.000 -.004	H +.005 -.015	S MIN	W		X	AXIAL STRENGTH POUNDS MINIMUM
								MAX	MIN		
440	.112-40 UNJC-3B	.268	.139	.183	.191	.150	.070	.251	.243	.005	1,080
448	.112-48 UNJF-3B	.268	.139	.183	.191	.150	.070	.251	.243	.005	1,080
632	.138-32 UNJC-3B	.339	.165	.216	.224	.175	.095	.313	.305	.006	1,620
640	.138-40 UNJF-3B	.339	.165	.216	.224	.175	.095	.313	.305	.006	1,620
832	.164-32 UNJC-3B	.410	.220	.267	.277	.238	.122	.376	.367	.006	2,510
836	.164-36 UNJF-3B	.410	.220	.267	.277	.238	.122	.376	.367	.006	2,510
1024	.190-24 UNJC-3B	.410	.220	.267	.277	.238	.114	.376	.367	.006	3,590
1032	.190-32 UNJF-3B	.410	.220	.267	.277	.238	.114	.376	.367	.006	3,590
420	.250-20 UNC-2B	.481	.280	.351	.361	.316	.168	.439	.430	.007	6,550
428	.250-28 UNJF-3B	.481	.280	.351	.361	.316	.168	.439	.430	.007	6,550
518	.312-18 UNC-2B	.552	.341	.407	.417	.348	.184	.502	.492	.007	9,600
524	.312-24 UNJF-3B	.552	.341	.407	.417	.348	.184	.502	.492	.007	9,600
616	.375-16 UNC-2B	.623	.405	.471	.487	.457	.250	.564	.553	.008	14,500
624	.375-24 UNJF-3B	.623	.405	.471	.487	.457	.250	.564	.553	.008	14,500
714	.437-14 UNC-2B	.765	.467	.530	.546	.457	.243	.690	.679	.009	15,500
720	.437-20 UNJF-3B	.765	.467	.530	.546	.457	.243	.690	.679	.009	15,500
813	.500-13 UNC-2B	.836	.531	.608	.624	.597	.336	.752	.741	.009	23,800
820	.500-20 UNJF-3B	.836	.531	.608	.624	.597	.336	.752	.741	.009	23,800

SHANK CODE	L ±.005	M +.000 -.010	N ±.005	MATERIAL THICKNESS RANGE		APPROXIMATE WEIGHT POUNDS PER 100								
				MAX	MIN	#4	#6	#8	#10	1/4	5/16	3/8	7/16	1/2
1	.063	.048	.053	.032	.020	.16	.30	.56	.51	1.06	1.40			
2	.085	.060	.075	.053	.032	.17	.31	.57	.52	1.08	1.43			
3	.105	.085	.095	.073	.053	.17	.32	.58	.53	1.10	1.45			
4	.135	.085	.125	.103	.073	.18	.33	.59	.55	1.13	1.48	2.25	3.20	
5	.165	.085	.155	.133	.103	.19	.34	.61	.56	1.16	1.53	2.28	3.24	5.00
7	.195	.085	.185	.163	.133	.20	.36	.62	.58	1.19	1.56	2.33	3.26	5.07
6	.225	.085	.215	.193	.163	.21	.37	.65	.59	1.22	1.59	2.36	3.32	5.13

INSTALLATION DETAILS			
NUT SIZE	RECOMMENDED HOLE SIZE		CLINCHING PRESSURE POUNDS
	MAX	MIN	
.112	.186	.184	2,000
.138	.219	.217	3,000
.164	.271	.268	4,000
.190	.271	.268	4,000
.250	.355	.352	5,000
.312	.411	.408	5,500
.375	.475	.472	6,500
.437	.534	.531	7,500
.500	.612	.609	9,000

FOR INSTALLATION TOOL REFER TO SPS-N-24033

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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: 10/23/91 DATE: 12/18/01	SPS TECHNOLOGIES	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS NASM25027 EXCEPT AS NOTED PART NUMBER: () () FP () - () SHEET 1 OF 2
TITLE NUT, FLEXLOC, HEXAGON, SELF-LOCKING REGULAR HEIGHT, CLINCH 450°F. -800°F, STAINLESS STEEL			ER-020	

DRAWING NUMBER: SPS-N-57568
 ISSUE DATE: 3/12/58
 REVISION: 8
 REVISED AND REPRAN: 10/23/91
 9
 11/02/98
 10
 4/07/2000
 11
 12/12/01



DRAWING NUMBER
SPS-N-57568

ISSUE DATE
3/12/58

REVISION

(8)

REVISED AND REDRAWN 10/23/91

(9)

11/02/98

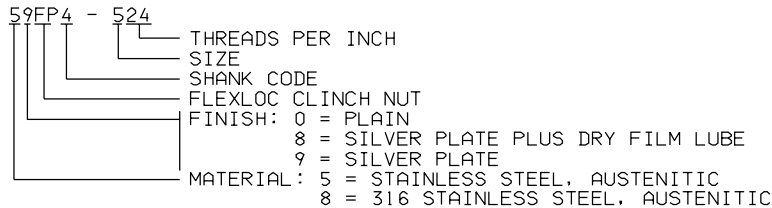
(10)

4/07/2000

(11)

12/12/01

1. MATERIAL: STAINLESS STEEL, AUSTENITIC.
316 STAINLESS STEEL, AUSTENITIC.
2. FINISH: PLAIN, PASSIVATED.
STAINLESS STEEL, SILVER PLATED PLUS MOLYBDENUM DISULFIDE DRY FILM LUBRICANT.
SILVER PLATE PER AMS 2410, THICKNESS .0002 MINIMUM ON EXTERIOR SURFACES.
3. LUBRICANT: UNLESS OTHERWISE SPECIFIED PARTS SHALL BE SUPPLIED WITH A NON-DRY LUBRICANT (WAX TYPE) SOLUBLE IN THE CLEANER SPECIFIED IN NASM25027, AND WHEN SPECIFIED DRY FILM LUBRICANT APPROVED PER NASM25027.
4. LOCKING TORQUE PER NASM25027 EXCEPT REUSABILITY NOT REQUIRED ON PLAIN FINISH NUTS AND REUSABILITY OF DRY FILM LUBRICATED PARTS LIMITED TO 5 CYCLES.
5. PARTS TO MEET PUSH OUT AND TORQUE OUT REQUIREMENTS OF NASM25027 WHEN TESTED IN STEEL SHEETS OF 20 HRC MAXIMUM HARDNESS.
6. THREADS PER AS8879 FOR CLASS 3B THREAD AND MIL-S-7742 FOR CLASS 2B THREAD.
7. DIMENSIONS TO BE MET PRIOR TO LUBRICANT.
8. DIMENSIONS ARE IN INCHES.
9. PART NUMBER SYSTEM:



10. DESIGN AND USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO BE USED ON 3A EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
11. PART NUMBERS OTHER THAN LISTED ON THIS DRAWING SHALL NOT BE USED.
12. SURFACE TEXTURE: ASME B46.1 UNLESS OTHERWISE SPECIFIED, THE SURFACE TEXTURE SHALL NOT EXCEED 125 MICROINCHES.
13. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.
14. REFERENCE: SPS-N-05896 FOR CARBON STEEL CLINCH NUT
SPS-N-57569 FOR BRASS CLINCH NUT
SPS-N-57570 FOR ALUMINUM CLINCH NUT

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

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



PART NUMBER: () () FP () - ()

SHEET 2 OF 2

ER-020