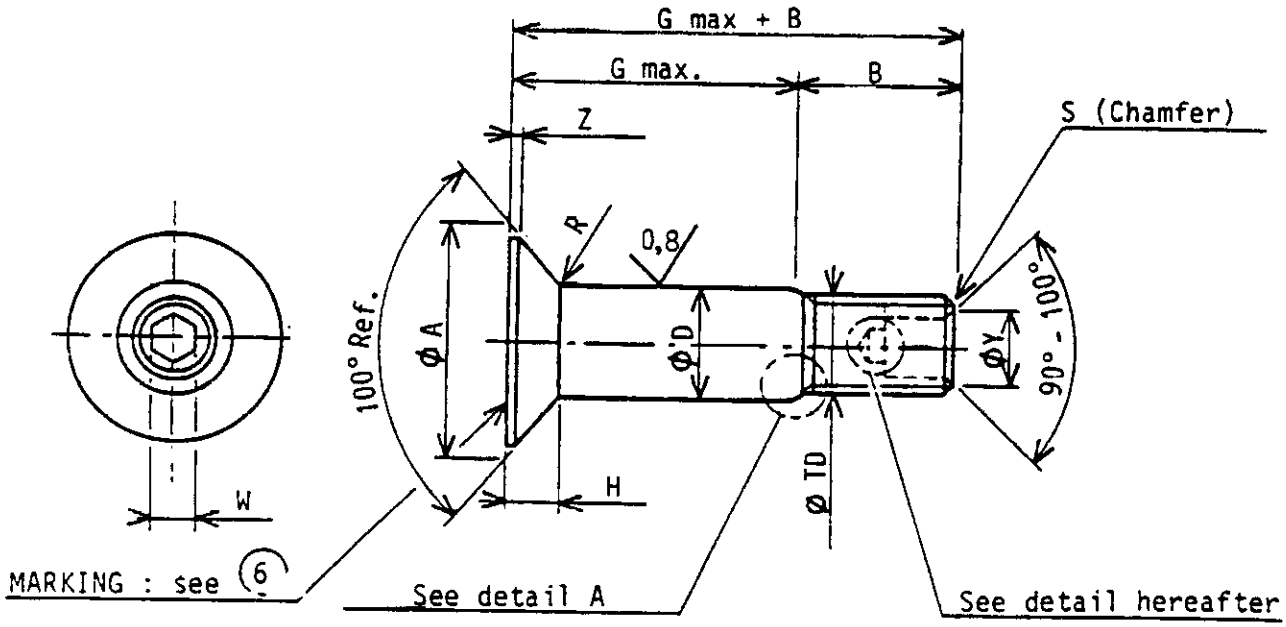
Dimension in mm

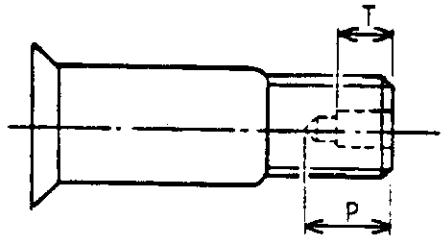
- This standard has been prepared according to manufacturer definitions. Possible patents which may refer to the product are not mentioned. Aerospatiale denies all responsability related to any dispute arising from manufacture, use or sale of parts corresponding to this standard.

SUMMARY

(1) DESCRIPTION :



BORING DEPTH (6 to flat mould)



Ø CODE Nr	P max.
3	3,2
4	3,7
5	4,4
6	5,4
7	6,4
8	7,4
9	8,6
10	8,8

Approved	Title	Classification
AIRBUS INDUSTRIE	BOLT - 100° CSK HEAD, SHORT THREAD	ASNA2352
	Issue: 03/86 Revision: (B) 04/87	Page 01 of 04

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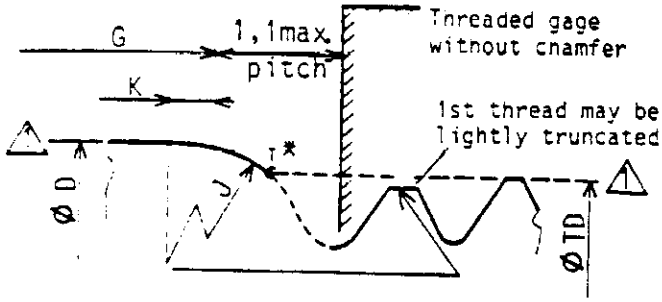
(1) (Contd) :

DETAIL A

DEFINITION OF THE BARREL-THREAD AREA



Ø CODE Nr	J mini.	K ref.	max. installation interference µ
3	2,2	0,41	90
4	3,2	0,48	110
5	5,5	0,64	125
6			
7			128
8			
9			/
10			

* The diameter measured at point I should be less than or equal to max. TD Ø .

⚠1 Check diameter D (barrel) and TD (thread) concentricity in order to prevent interference between thread and boring during installation with strong interference.

(2) DIAMETERS, DIMENSIONS, WEIGHTS, LOADS CODE NUMBERS :

ITEM CODE Nr	NOMINAL Ø	THREAD UNJF-3A MODIFIED	Ø A	E Ref.	Ø D	Ø TD	F	H	R	S	Z max.
3	3/16	.1900-32	9,685 9,563	7,366	4,813 4,788	4,673 4,597	0,127	2,044 1,994	0,762 0,508	0,79 x 37°	0,381
4	1/4	.2500-28	12,867 12,745	8,128	6,337 6,312	6,197 6,121	0,152	2,743 2,692	0,762 0,508	0,79 x 37°	0,381
5	5/16	.3125-24	16,090 15,968	9,652	7,925 7,899	7,772 7,670	0,177	3,429 3,378	1,016 0,762	1,19 x 37°	0,381
6	3/8	.3750-24	19,314 19,192	10,668	9,512 9,487	9,347 9,245	0,203	4,114 4,064	1,016 0,762	1,19 x 37°	0,381
7	7/16	.4375-20	22,565 22,382	12,319	11,099 11,074	10,947 10,820	0,228	4,813 4,737	1,270 1,016	1,19 x 37°	0,558
8	1/2	.5000-20	25,753 25,572	13,335	12,687 12,662	12,522 12,395	0,254	5,486 5,410	1,270 1,016	1,19 x 37°	0,558

ITEM CODE Nr	PROFILE W Hexagonal	PROFILE T	PROFILE Ø Y	WEIGHT g Head and "T"	WEIGHT g Smooth part	mini. DOUBLE SHEAR STRENGTH (daN)	mini. TENSILE STRENGTH (daN)	AXIAL TENSILE FATIGUE LOAD (daN) F max. *
3	2,047 2,009	2,540 2,032	3,022 2,641	0,87	0,11	2393	1414	467
4	2,456 2,405	2,794 2,286	3,606 3,099	1,79	0,19	4136	2589	867
5	3,289 3,225	3,302 2,794	4,572 4,064	3,43	0,28	6494	4092	1397
6	4,107 4,018	4,064 3,556	5,512 5,004	5,77	0,37	9341	6227	2158
7	4,902 4,813	4,826 4,318	6,426 5,918	9,06	0,48	12722	8407	2910
8	5,694 5,605	5,588 5,080	7,340 6,832	13,25	0,65	16592	11387	3960

* F mini. = 0,1 F max.

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(3) GRIP LENGTH CODE NUMBER, LENGTHS :

LENGTH CODE Nr	G + 0,127	LENGTH G max. + B + 0,25 − 0,10					
		3	4	5	6	7	8
1	1,59	8,95	9,72	11,24			
2	3,18	10,54	11,31	12,83	13,85		
3	4,76	12,12	12,89	14,41	15,43	17,08	
4	6,35	13,71	14,48	16,00	17,02	18,67	19,68
5	7,94	15,30	16,07	17,59	18,61	20,26	21,27
6	9,52	16,88	17,65	19,17	20,19	21,84	22,85
7	11,11	18,47	19,24	20,76	21,78	23,43	24,44
8	12,70	20,06	20,83	22,35	23,37	25,02	26,03
9	14,29	21,65	22,42	23,94	24,96	26,61	27,62
10	15,88	23,24	24,01	25,53	26,55	28,20	29,21
11	17,46	24,82	25,59	27,11	28,13	29,78	30,79
12	19,05	26,41	27,18	28,70	29,72	31,37	32,38
13	20,64	28,00	28,77	30,29	31,31	32,96	33,97
14	22,22	29,58	30,35	31,87	32,89	34,54	35,55
15	23,81	31,17	31,94	33,46	34,48	36,13	37,14
16	25,40	32,76	33,53	35,05	36,07	37,72	38,73
17	26,99	34,35	35,12	36,64	37,66	39,31	40,32
18	28,58	35,94	36,71	38,23	39,25	40,90	41,91
19	30,16	37,52	38,29	39,81	40,83	42,48	43,49
20	31,75	39,11	39,88	41,40	42,42	44,07	45,08
21	33,34	40,70	41,47	42,99	44,01	45,66	46,67
22	34,92	42,28	43,05	44,57	45,59	47,24	48,25
23	36,51	43,87	44,64	46,16	47,18	48,83	49,84
24	38,10	45,46	46,23	47,75	48,77	50,42	51,43
25	39,69	47,05	47,82	49,34	50,36	52,01	53,02
26	41,28	48,64	49,41	50,93	51,95	53,60	54,61
27	42,86	50,22	50,99	52,51	53,53	55,18	56,19
28	44,45	51,81	52,58	54,10	55,12	56,77	57,78
29	46,04	53,40	54,17	55,69	56,71	58,36	59,37
30	47,62	54,98	55,75	57,27	58,29	59,94	60,95
31	49,21	56,57	57,34	58,86	59,88	61,53	62,54
32	50,80	58,16	58,93	60,45	61,47	63,12	64,13
34	53,98	61,34	62,11	63,63	64,65	66,30	67,31
36	57,15	64,51	65,28	66,80	67,82	69,47	70,48
38	60,32	67,68	68,45	69,97	70,99	72,64	73,65
40	63,50	70,86	71,63	73,15	74,17	75,82	76,83
42	66,68	74,04	74,81	76,33	77,35	79,00	80,01
44	69,85	77,21	77,98	79,50	80,52	82,17	83,18
46	73,02	80,38	81,15	82,67	83,69	85,34	86,35
48	76,20	83,56	84,33	85,85	86,87	88,52	89,53
50	79,38	86,74	87,51	89,03	90,05	91,70	92,71
52	82,55	89,91	90,68	92,20	93,22	94,87	95,88
54	85,72	93,08	93,85	95,37	96,39	98,04	99,05
56	88,90	96,26	97,03	98,55	99,57	101,22	102,23
58	92,08	99,44	100,21	101,73	102,75	104,40	105,41
60	95,25	102,61	103,38	104,90	105,92	107,57	108,58

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(4) MATERIAL, FINISH, LUBRICATION :

MATERIAL	CODE	FINISH	LUBRICATION
Titanium alloy 6Al-4V as per specification AMS 4928 or AMS 4967 R = 1100 Mpa mini. - Rc = 650 Mpa mini.	T	Sulfuric-acid anodizing	As per A/DET/0013

(5) CODED PART NUMBER :

Example of part number identification to be used on drawings :

ASN-A2352T6-20 , Bolt

Example of part number construction :

ASN-A2352 T 6-20

Standard Nr
Material code
Length code Nr
Diameter code Nr

(6) GENERAL CHARACTERISTICS :

- Recessed marking, max. depth 0,25 and must indicate :
  the diameter code Nr, the material code and the manufacturer's logo.
- Surface condition : as per ANSI B46-1.
- Rolled thread as per MIL.S.8879 except Ø TD.
- Tolerances, concentricity :
  Tapered surface of head and Ø D : 0,127 (TCR).
  Cylindrical part of head and Ø D : within the values of F.
- Height H is dimensioned using the maximum Ø D.

CALCULATION OF BOLT WEIGHT :

Add the weight of the head and threaded part (invariable weights) to the weight of the smooth part (variable weight).

Total weight of the head and threaded part :
1st column in the weight table.

Weight of the smooth part :
Multiply the value of the 2nd column of the table (value according to diameter code number) by the bolt length code number.

Example : BOLT ASN-A2352T6-20

Invariable weight :		5,77
Variable weight :	0,37 x 20 =	7,40
Total weight :		13,17 g

(7) TECHNICAL SPECIFICATION : A/DET 0062

(8) QUALIFIED MANUFACTURERS :

Refer to the list of qualified manufacturers and products, available at Standardization Departments.

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