AIRBUS

NUT – HEXAGONAL, SELF-LOCKING, ALUMINIUM ALLOY

Issue : **J**
Date : **Nov 06**
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SUMMARY

1 - SCOPE AND FIELD OF APPLICATION

This standard specifies the dimensions, tolerances, required characteristics and the masses of a self-locking hexagonal nut.

2 - REFERENCES

ABS1420	:	Aerospace series - Nut - Ordinary, for lightweight threaded pins.
AMS-QQ-A-225/9	:	Aluminium alloy 7075, bar, rod, wire and special shapes ; rolled, drawn or cold finished.
EN2424	:	Aerospace series - Marking of aerospace products.
EN6117	:	Aerospace series - Specification for lubrication of bolts with cetyl alcohol.
MIL-A-8625	:	Anodic coatings, for aluminium and aluminium alloys.
SAE AS8879	:	Screw threads – UNJ profile, inch - Controlled radius root with increased minor diameter.

3 - TERMINOLOGY

Not applicable.

4 - REQUIRED CHARACTERISTICS

4.1 - Configuration, dimensions, tolerances, mass

4.1.1 - Configuration shall be in accordance with the figure.

4.1.2 - Dimensions shall be in accordance with the figure and table 1.

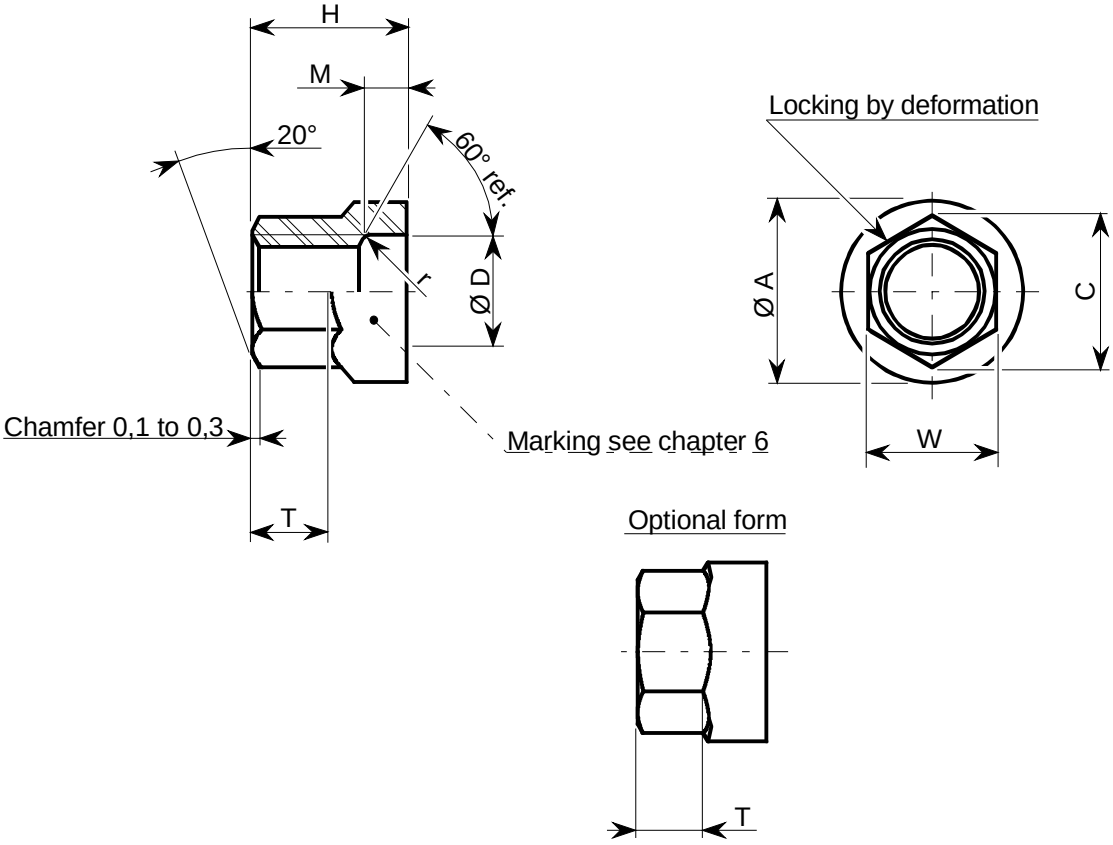
All dimensions are given after finish, but before lubrication.

4.1.3 - Tolerances shall be in accordance with table 1.

4.1.4 - Mass shall be in accordance with table 1.

4.2 - Material, finish, lubrication

Material, finish and lubrication shall be in accordance with table 2.



Dimensions in mm.

Figure - Configuration, dimensions

Table 1 - Dimensions, tolerances, mass

Ø CODE No.	THREAD UNJF-3B as per SAE AS8879	Ø A max.	C Ref.	Ø D min.	H max.	M min.	r Ref.	T min.	W	Min. AXIAL TENSILE STRENGTH (daN)	MASS (kg/1 000 parts)
3	.1900-32	9,02	7,0	5,66	6,5	2,54	0,8	2,5	6,37 6,17	711	0,47
3A	.2160-28	9,91	7,9	6,48	6,90		0,9		7,22 6,93	1 000	0,63
4	.2500-28	11,18	8,8	7,19	7,3	2,64	1,0	2,7	7,95 7,75	1 334	0,81
5	.3125-24	13,59	10,6	8,76	8,5	2,69		3,2	9,55 9,32	2 222	1,36
6	.3750-24	17,35	14,3	10,33	9,4	2,74	1,2	3,8	12,75 12,50	3 114	2,60
7	.4375-20	19,69	16,0	11,94	10,6	2,84	1,4	4,6	14,32 14,05	4 223	3,63
8	.5000-20	22,35	20,3	13,51	11,4	2,89	1,6		17,45 17,07	5 555	5,46
9	.5625-18	23,49	22,1	15,29	12,9	2,99		6,5	19,05 18,67	6 445	6,64
10	.6250-18	25,40		16,86	14,3			7,9	20,86 20,48	8 000	9,60
12	.7500-16	28,45	25,4	19,94	20,1	3,05		8,6	22,30 21,92	12 233	14,4

Dimensions in mm.

Table 2 - Material, finish, lubrication

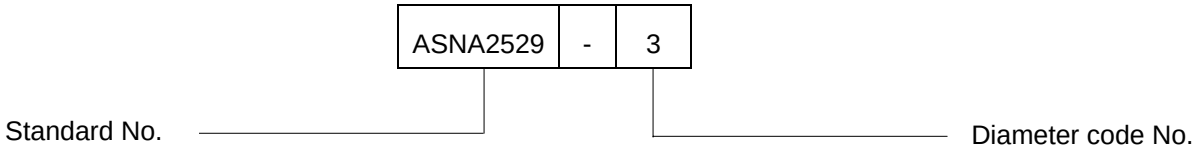
ELEMENT	MATERIAL	FINISH	LUBRICATION
NUT	Aluminium alloy 7075 as per AMS-QQ-A-225/9 T73	Anodizing as per MIL-A-8625, Type II, class 2 (dark blue color)	Cethyl alcohol as per EN6117

5 - DESIGNATION

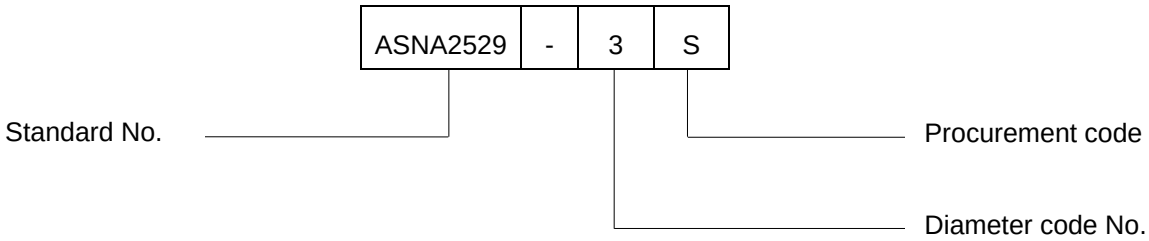
Example of part number identification to be used on drawing schedules:

ASNA2529-3 , Nut

Example of part number construction:



Designation to be used by Procurement Departments only:



NOTE: Add "S" to the coded part number for delivery of nuts in "feeders" (for use with screw driving machines).

6 - MARKING

Parts shall be marked as per EN2424, categories F or G.

7 - TECHNICAL SPECIFICATION

ABS1420.

8 - MANUFACTURERS

Refer to the list of qualified manufacturers and products.

AMENDMENT RECORD SHEET

Issue	Modified paragraph	Modification summary	Justification
A.05.88		New standard.	
B.10.88		Chamfer added in figure. Values of dimensions W and T modified in table 1.	Following note EG/ST 437.127/88 Annex 2
C.04.89		Dimensions C, H and T modified in table 1. In figure: knurling added for identification of diameter code No. 10.	A320
D.10.89		In table 2: material QQ-A-282, 73 condition changed to QQ-A-225/9, 73 condition.	American specification evolvement
E.10.90		In table 1: mass in kg/100 changed to in kg/1 000.	Following mistake
F.09.96		Standard fully amended. Note added in chapter 5.	Memo. No. 60319 of 21.08.96
G.01.00		In table 1, thread modified for Ø code No. 4: 0.2599-28 changed to 0.2500-28.	Following mistake
		”Knurled flange for identification of diameter code No. 10” deleted in figure. Dimension W modified in table 1 for diameter code No. 10: 19,05/18,67 mm changed to 20,86/20,48 mm.	Notes JLM No. 0440293/99 564.2323/99
		Diameter code No. 12 added.	A340/600
H.01.03		Diameter code No. 3A added.	In accordance with manufacturer’s documentation
J.11.06		References updated. Go thread gage penetration deleted. Modification of figure with introduction of dimension T min. and optional form. Mass modified.	Specification defined in ABS1420

Note: Modification to the last standard issue are indicated by a vertical line in the margin.