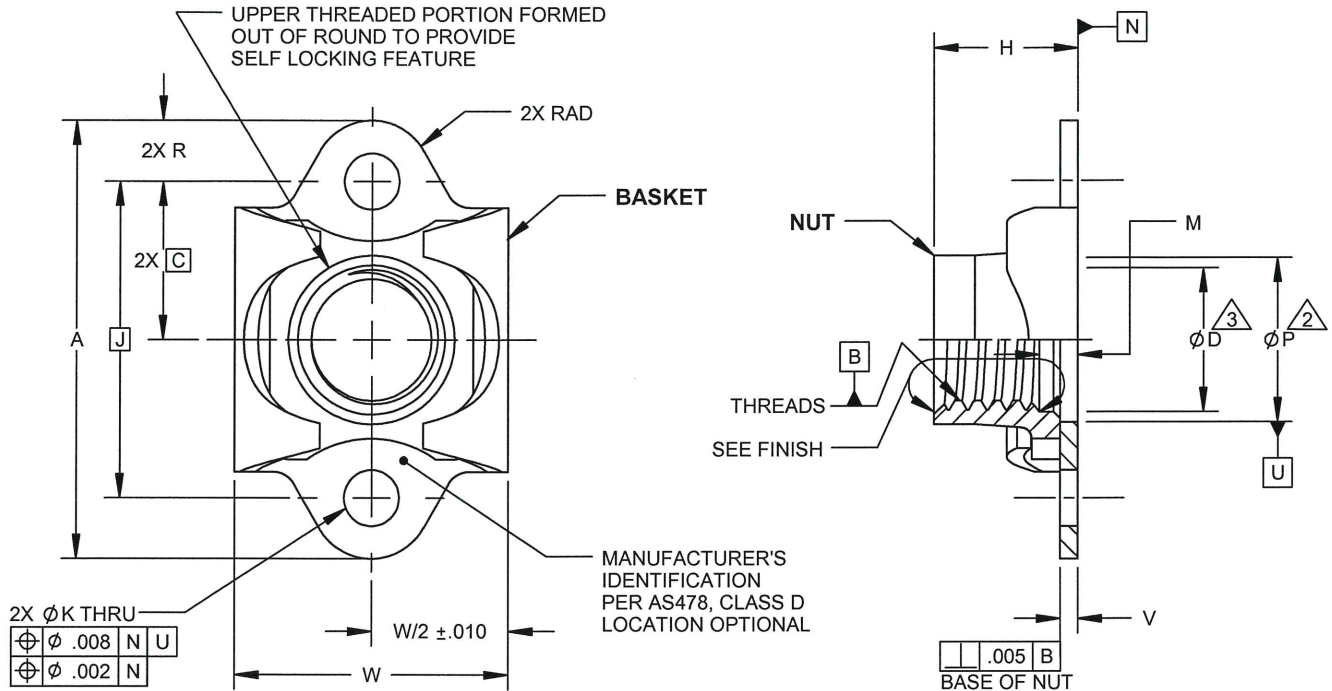


MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN  
CONSENT OF ARCONIC FASTENING SYSTEMS IS ABSOLUTELY PROHIBITED.

AFS PRODUCTS PART NO.	THREADS PER AS8879	ØA MAX	C	ØD MIN	H MAX	J	ØK	M MIN	ØP	R MIN	V	W	AXIAL TENSILE STRENGTH lbf MIN	APPROX WEIGHT lbs/100
MF54208-	06	.1380-32UNJC-3B	.682	.218	.142	.171	.437	.103 .098 .062	.270 .178	.070	.090 .020	.357 .290	1,130	.32
	08	.1640-32UNJC-3B	.707	.234	.168	.250	.468		.270 .204		.090 .025	.367 .290	1,720	.36
	3	.1900-32UNJF-3B	.739	.250	.194		.500		.270 .230	.100	.090 .027	.416 .290	2,460	.39
	4	.2500-28UNJF-3B	.801	.281	.254	.281	.562		.330 .290		.090 .027	.500 .350	4,580	.69
	5	.3125-24UNJF-3B	1.010	.359	.317	.328	.718		.392 .352	.117	.105 .032	.581 .412	7,390	1.10

MATERIAL: NUT --- A286 CORROSION RESISTANT STEEL PER AMS5525, AMS5732 OR AMS5737 (UNS S66286).  
BASKET -- A286 CORROSION RESISTANT STEEL PER AMS5525 (UNS S66286).

HEAT TREAT: Rc 44 MAXIMUM.

FINISH: NUT -- SILVER PLATE PER AMS2411, ON THREADS ONLY, EXCEPT:  
A) SIZE -06 ONLY: OPTIONAL COVERAGE ON COUNTERSINK.  
B) SIZE -08 AND LARGER: OPTIONAL COVERAGE IN COUNTERBORE TO .030 MAX.  
BASKET -- PASSIVATE PER AMS2700, TYPE 2 OR 8.

PERFORMANCE: AS4393, EXCEPT AS FOLLOWS:  
A) AXIAL TENSILE STRENGTH AS TABULATED.  
B) BAKE AT 800°F ±15°F IN LIEU OF 1200°F ±15°F FOR NUTS TESTED AFTER BAKE.  
C) HEAT TREAT AS SPECIFIED.

- NOTES:
- FLOATABILITY: .020 MINIMUM RADIALLY, FROM CENTERED POSITION.
  - SIZE -06: MAY BE C'SUNK OR RADIUSSED WITHIN THE LIMITS OF ØP.
  - SIZES -08 AND LARGER: SHALL HAVE A BOTTOM C'BORE TO THE LIMITS OF ØD AND M.
  - DIMENSIONS APPLY AFTER PLATING.
  - REMOVE BURR AND SHARP EDGES.
  - UNLESS OTHERWISE SPECIFIED:  
SURFACE TEXTURE 125 MICROINCHES PER ASME B46.1.



THIRD ANGLE PROJECTION

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APPROVED DATE

27JUL1992

REV. LETTER AND DATE:

E 30JAN2019

CUSTOMER:

CURRENT DESIGN ACTIVITY:



**ARCONIC**

Arconic Fastening Systems  
Fullerton Operations  
800 S State College Boulevard  
Fullerton, California, 92831

<http://www.arconic.com>

TITLE:

NUT - ANCHOR, 2 LUG,  
MINIATURE, FLOATING,  
SELF-LOCKING, ASSEMBLY

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE  
IN INCHES & TO ASME Y14.5-2009 TOLERANCES:  
DECIMALS = ±.015; ANGLES = ±2°

CAGE CODE: 15653

SALES DRAWING No.

MF54208-(-)

PAGE 1 OF 1

FILED AS: s\_MF54208-(-)

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