

REV.
A

AS85049/96

FEDERAL SUPPLY CLASS
5935

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION: SAE AS85049.

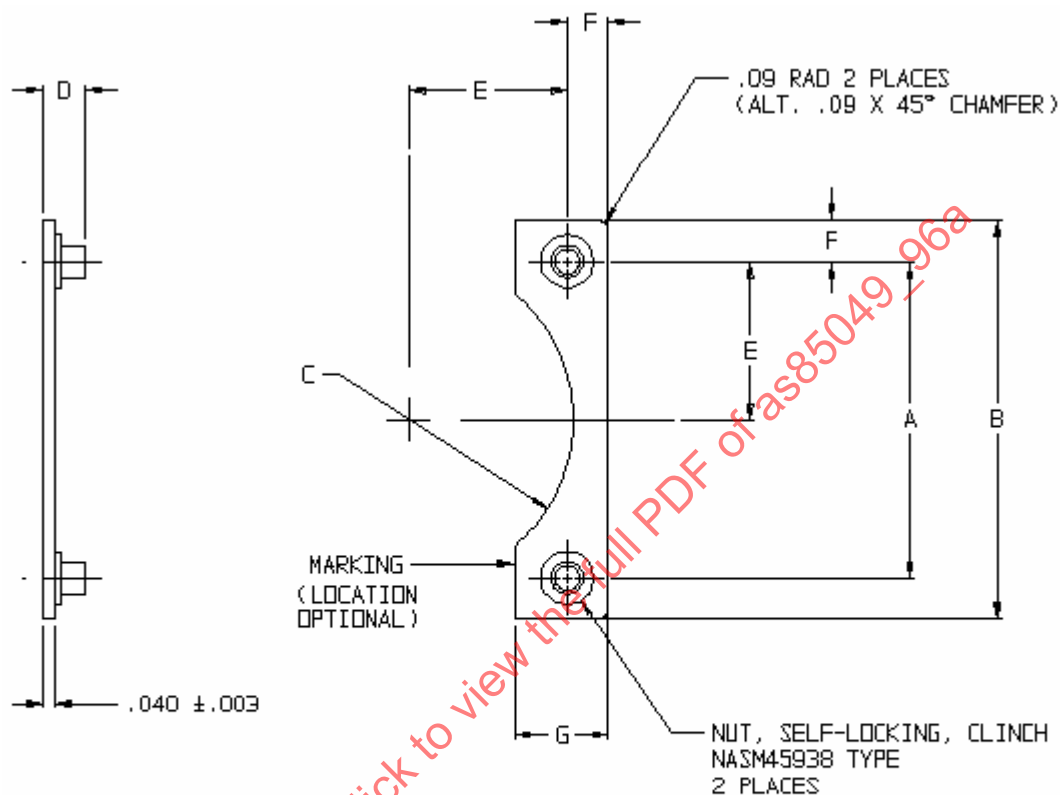
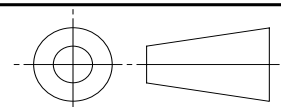


FIGURE 1

THIRD ANGLE PROJECTION



CUSTODIAN: SAE AE-8/AE-8C1

SAE Aerospace
 An SAE International Group
AEROSPACE STANDARD
 CONNECTOR ACCESSORIES, ELECTRICAL,
 MOUNTING DEVICE, FLANGE TYPE, CATEGORY 7,
 1/4 PERIMETER

AS85049/96
 SHEET 1 OF 5

REV.
A

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ISSUED 2001-07 REVISED 2004-04

TABLE 1 - DIMENSIONS

DASH NUMBER	THRD UNJC -3B	A ± .005	B MAX	C ± .015	D	E ± .005	F ± .010	G MAX
3	4-40	.625	.940	.320	.106/.166	.312	.150	.310
7	4-40	.719	1.031	.359	.106/.166	.359	.149	.308
8	4-40	.594	.906	.277	.106/.166	.297	.148	.306
10	4-40	.719	1.031	.359	.106/.166	.359	.149	.308
12	4-40	.812	1.124	.425	.106/.166	.406	.148	.306
14	4-40	.906	1.218	.492	.106/.166	.453	.148	.306
16	4-40	.969	1.281	.547	.106/.166	.484	.149	.308
18	4-40	1.062	1.405	.610	.106/.166	.531	.164	.338
19	4-40	.906	1.218	.492	.106/.166	.453	.148	.306
20	4-40	1.156	1.525	.672	.106/.166	.578	.177	.364
22	4-40	1.250	1.655	.739	.106/.166	.625	.195	.400
24	6-32	1.375	1.790	.797	.123/.183	.687	.193	.396
25	6-32	1.500	1.874	.845	.123/.183	.750	.179	.368
27	4-40	.969	1.281	.547	.106/.166	.484	.149	.308
28	6-32	1.562	2.015	.920	.123/.183	.781	.219	.448
32	6-32	1.750	2.327	1.058	.123/.183	.875	.281	.572
36	6-32	1.938	2.515	1.170	.123/.183	.969	.281	.572
37	4-40	1.187	1.515	.670	.106/.166	.593	.157	.324
61	4-40	1.437	1.827	.812	.106/.166	.718	.188	.386

NOTES:

1. DIMENSIONS ARE INCHES.
2. UNLESS OTHERWISE SPECIFIED, TOLERANCE IS $\pm .010$.
3. FOR MOUNTING FLANGE CROSS REFERENCE INFORMATION, SEE TABLE 2.
4. THE CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT.

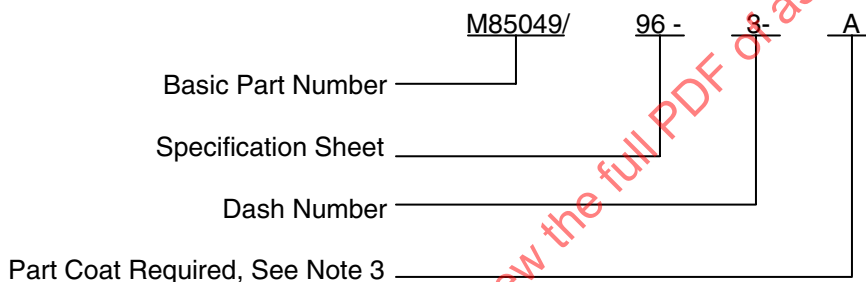
INCH	MM	INCH	MM	INCH	MM
0.003	0.08	0.531	13.49	1.219	30.96
0.006	0.15	0.537	13.64	1.234	31.34
0.010	0.25	0.560	14.22	1.250	31.75
0.012	0.30	0.562	14.27	1.286	32.66
0.013	0.33	0.594	15.09	1.312	33.32
0.016	0.41	0.614	15.60	1.344	34.14
0.020	0.51	0.625	15.88	1.357	34.47
0.025	0.64	0.627	15.93	1.363	34.62
0.027	0.68	0.641	16.28	1.375	34.92
0.032	0.81	0.662	16.81	1.438	36.53
0.051	1.30	0.672	17.07	1.547	39.29
0.062	1.57	0.676	17.17	1.562	39.67
0.064	1.63	0.719	18.26	1.590	40.39
0.094	2.39	0.738	18.75	1.611	40.92
0.156	3.96	0.744	18.90	1.625	41.28
0.188	4.78	0.750	19.05	1.670	42.42
0.209	5.30	0.781	19.84	1.734	44.04
0.219	5.56	0.797	20.24	1.750	44.45
0.230	5.84	0.800	20.32	1.781	45.24
0.231	5.87	0.812	20.62	1.844	46.84
0.254	6.45	0.870	22.10	1.865	47.37
0.281	7.14	0.875	22.23	1.875	47.63
0.302	7.67	0.922	23.41	1.920	48.77
0.312	7.92	0.926	23.52	2.000	50.8
0.315	8.00	0.937	23.80	2.083	52.91
0.320	8.13	0.940	23.88	2.162	54.91
0.344	8.74	0.969	24.61	2.250	57.15
0.375	9.53	1.000	25.4	2.332	59.23
0.389	9.88	1.016	25.81	2.365	60.07
0.406	10.31	1.031	26.19	2.375	60.33
0.428	10.87	1.037	26.34	2.412	61.26
0.438	11.13	1.047	26.59	2.500	63.5
0.440	11.18	1.062	26.97	2.625	66.68
0.441	11.20	1.094	27.79	2.812	71.42
0.445	11.30	1.107	28.12	2.832	71.93
0.473	12.01	1.172	29.77	2.912	73.96
0.510	12.95	1.180	29.97	3.000	76.2
0.515	13.08	1.200	30.48	3.312	84.12

REQUIREMENTS:

DESIGN AND CONSTRUCTION:

1. DIMENSIONS AND CONFIGURATION SHALL BE IN ACCORDANCE WITH FIGURE 1, TABLE 1.
2. FIGURE 1, MOUNTING FLANGES SHALL BE OF A CONSTRUCTION WITH PREDRILLED OR PUNCHED HOLES IN ALUMINUM ALLOY INCORPORATING SELF LOCKING NUTS, CLINCH TYPE.
3. MATERIAL AND FINISH: FLANGES, ALUMINUM ALLOY IAW SAE AS85049, CHEMICAL CONVERSION COATING PER MIL-C-5541, CLASS 1A. WHEN SPECIFIED IN THE PART NUMBER, BY LETTER 'A' DESIGNATOR, 2 COATS OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I, SHALL BE APPLIED EITHER BEFORE OR AFTER NUT INSTALLATION AND OVERSPRAY IS ALLOWED PROVIDED THE PERFORMANCE CHARACTERISTICS OF THE NUT ARE NOT DEGRADED AND ALL OTHER REQUIREMENTS ARE MET.
4. CLINCH NUTS: IN ACCORDANCE WITH NASM45938, CLEAN AND DE-SCALE IN ACCORDANCE WITH ASTM A 380 AND PASSIVATED IN ACCORDANCE AMS-QQ-P-35, FOLLOWED BY A SOLID FILM LUBRICANT COATING PER MIL-PRF-46010.
5. MARKING: IN ACCORDANCE WITH MIL-STD-1285 AND AS FOLLOWS:

Part or Identifying Number (PIN):



6. QUALIFICATION: SEE SAE AS85049, CATEGORY 7, WITH THE FOLLOWING ADDITIONS:
 - a. INSTALLATION: WHEN TESTED AS SPECIFIED HEREIN EVIDENCE OF COCKING, LOOSENESS, SPLITS OR CRACKS SHALL BE CAUSE FOR REJECTION.
 - b. SALT SPRAY: IN ACCORDANCE WITH SAE AS85049, 3.5.3, 4.6.4, 4.6.4.1
 - c. VIBRATION: IN ACCORDANCE WITH SAE AS85049, 3.5.4, 4.6.5, 4.6.5.1
 - d. SHOCK: IN ACCORDANCE WITH SAE AS85049, 3.5.5, 4.6.6.1
 - e. LOCKING TORQUE: IN ACCORDANCE WITH NASM25027.
 - f. TORQUE OUT: IN ACCORDANCE WITH NASM45938, EXCEPT THE REQUIREMENT SHALL BE 15 IN LB MINIMUM FOR 4-40 THREADED NUTS AND 20 IN LB MINIMUM FOR 6-32 THREADED NUTS.
 - g. PUSH OUT: IN ACCORDANCE WITH NASM45938, EXCEPT THE REQUIREMENT SHALL BE 88 LB MINIMUM FOR 4-40 THREADED NUTS AND 105 LB MINIMUM FOR 6-32 THREADED NUTS.
 - h. POST EXAMINATION