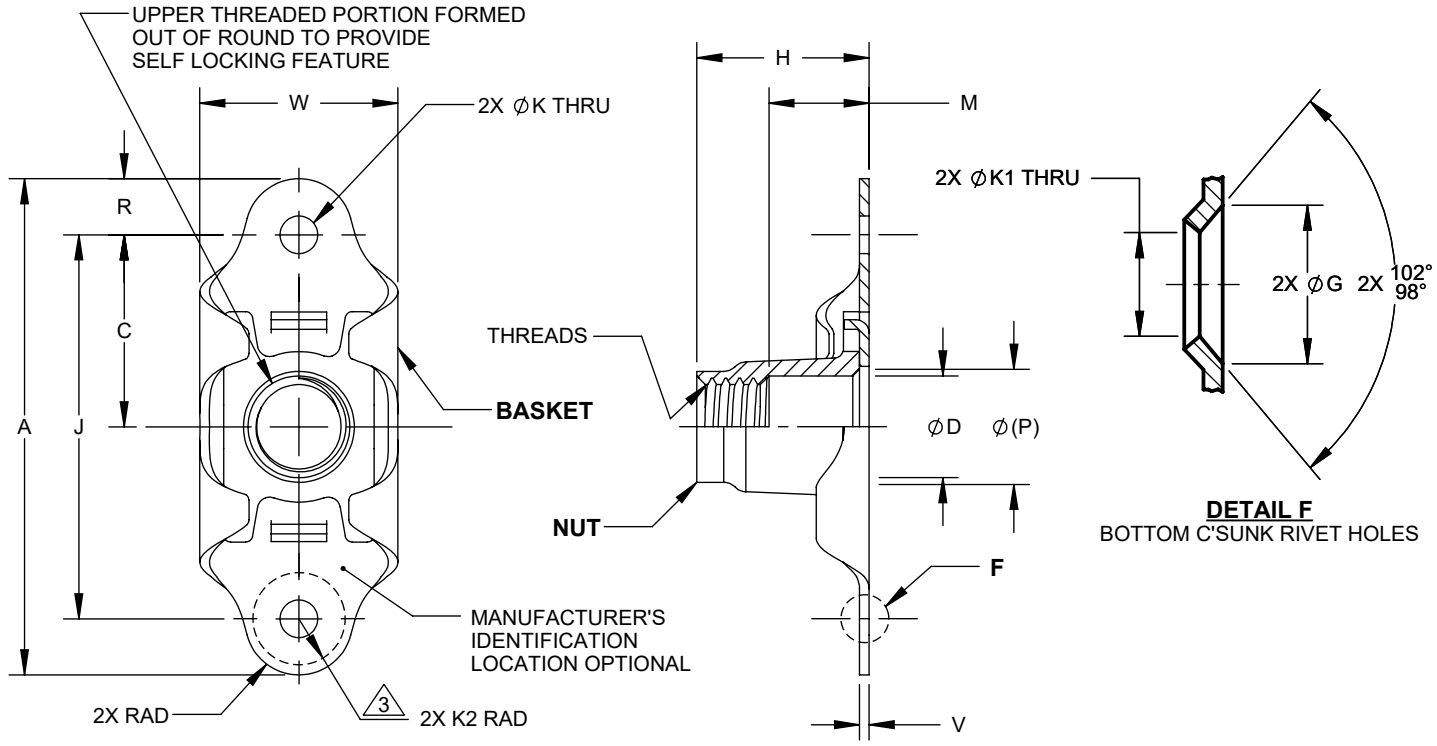
MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT OF HOWMET FASTENING SYSTEMS IS ABSOLUTELY PROHIBITED.



HFS PART NO.		THREADS PER AS8879	A MAX	C	∅D MIN	∅G	H MAX	J	∅K +.005 -.000	∅K1 +.015 -.000	K2 MIN	M MIN	∅(P)	R MIN	V MAX	W MAX	MAXIMUM WEIGHT lbs/100
F1934(*)	3-2	.1900-32UNJF-3B	.948	.349 .339	.194	.210 .190	.312	.690 .686	.098	.098	.098	.125	.250	.100	.032	.416	.41
	3-3						.375					.188					.48
	3-4						.438					.250					.52
	3-5						.500					.312					.55
	3-6						.562					.375					.61
	3-7					---	.625					.438		---	.020		.66
	3-8						.687					.500					.71
	3-9						.749					.562					.76
	3-10						.812					.625					.81
	4-2	.2500-28UNJF-3B	1.292	.505 .495	.254	.210 .190	.344	1.002 .998				.125	.312	.100	.032	.516	.74
	4-3						.406					.188					.80
	4-4						.469					.250					.86
	4-5						.531					.312					1.01
	4-6						.594					.375					1.07
	4-7					---	.656					.438		---	.025		1.13
	4-8						.718					.500					1.20
	4-9						.780					.562					1.26
	4-10						.842					.625					1.32
	5-2	.3125-24UNJF-3B			.317	.240 .220	.391		.130	.130	.130	.125	.375	.125	.045	.609	----
	5-3						.453					.188					
	5-4						.516					.250					
	5-5						.578					.312					
	5-6						.641					.375					
	6-2	.3750-24UNJF-3B			.379	---	.418					.125	.437	---	.025	.680	
	6-3						.481					.188					
	6-4						.543					.250					
	6-5						.605					.312					
	6-6						.668					.375					

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THIRD ANGLE PROJECTION

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APPROVED DATE: 30OCT1969

REV. LETTER AND DATE: B 14MAY2020

CUSTOMER:

CURRENT DESIGN ACTIVITY:

HOWMET AEROSPACE

Howmet Fastening Systems
800 S State College Boulevard
Fullerton, California, 92831
http://www.hfs.howmet.com

TITLE: NUT - ANCHOR, TWO LUG, FLOATING, DEEP C'BORE

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & TO ASME Y14.5-2018 TOLERANCES: DECIMALS = ±.015; ANGLES =±2°

CAGE CODE: 15653

SALES DRAWING No.

F1934(*)(*)-(*)

SHEET 1 OF 2

FILED AS: s_F1934()()-()

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

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MATERIAL: NUT:
4130 ALLOY STEEL PER AMS6370 (UNS G41300), OR
C1050 CARBON STEEL, PER AMS5085 (UNS G10500).

BASKET:
C1050 CARBON STEEL, PER AMS5085 (UNS G10500).

HARDNESS: 45 HRC MAXIMUM.

FINISH: F1934-(*)-(*):
CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2, PLUS SOLID FILM LUBE PER AS5272 TYPE II, CLASS 2.

F1934E(*)-(*):
CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 PLUS WAX.

PERFORMANCE: NASM25027.

TEMPERATURE: 450°F MAX.

VARIATIONS: ADD BC FOR BOTTOM C'SUNK RIVET HOLES.
EXAMPLE: F1934-3-3BC

NOTES:

1. FLOATABILITY: .030 RADIALLY MINIMUM, FROM CENTERED POSITION.
   .020 AXIAL MAXIMUM.
2. SURFACE TEXTURE TO BE 125 MICROINCHES MAX, PER ANSI B46.1.
3. K2 IS CLEARANCE FOR ATTACHING RIVETS.
4. UNLESS OTHERWISE SPECIFIED:
   A) DIMENSIONS APPLY AFTER PLATING, BUT BEFORE LUBRICATION.

THIRD ANGLE PROJECTION

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APPROVED DATE: 30OCT1969	CURRENT DESIGN ACTIVITY: HOWMET AEROSPACE, Howmet Fastening Systems, 800 S State College Boulevard, Fullerton, California, 92831, http://www.hfs.howmet.com	TITLE: NUT - ANCHOR, TWO LUG, FLOATING, DEEP C'BORE	CAGE CODE: 15653
REV. LETTER AND DATE: B 14MAY2020			SALES DRAWING No.
CUSTOMER:		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & TO ASME Y14.5-2018 TOLERANCES: DECIMALS = ±.015; ANGLES =±2°	F1934(*)(*)-(*)
			SHEET 2 OF 2

FILED AS: s_F1934()()-()