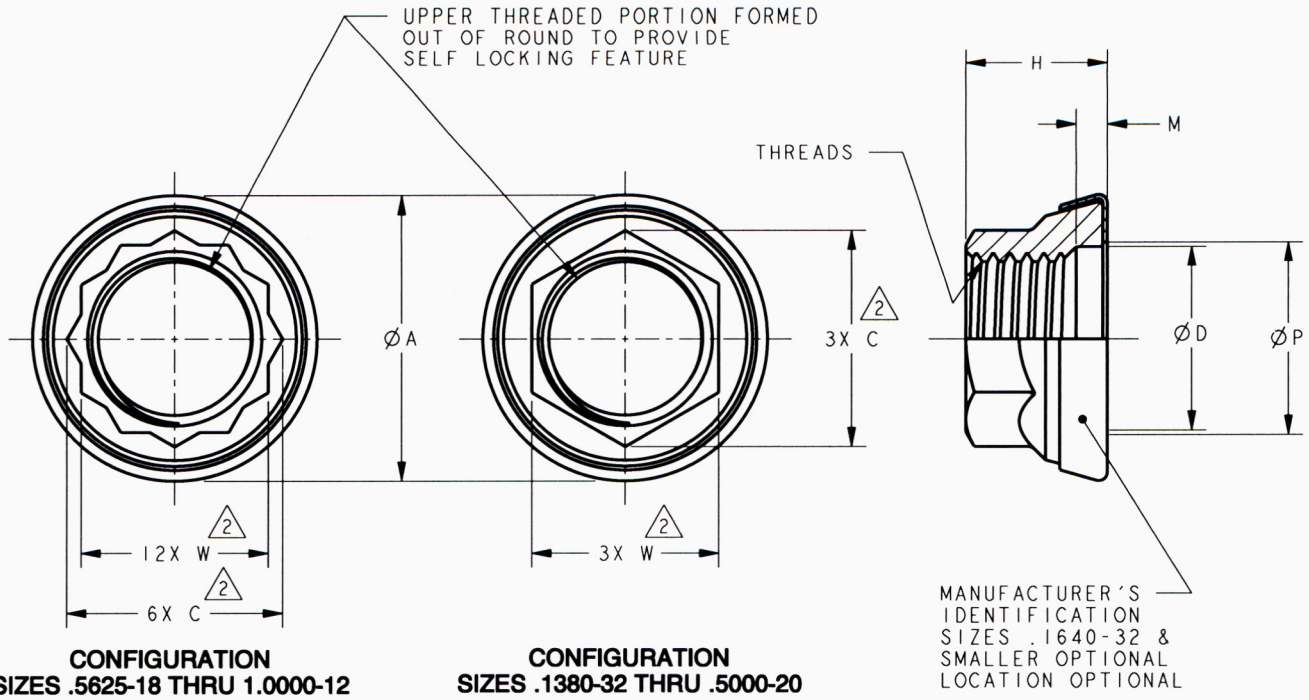


MANUFACTURER OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT OF HOWMET FASTENING SYSTEMS IS ABSOLUTELY PROHIBITED.



CONFIGURATION
SIZES .5625-18 THRU 1.0000-12

CONFIGURATION
SIZES .1380-32 THRU .5000-20

MANUFACTURER'S IDENTIFICATION SIZES .1640-32 & SMALLER OPTIONAL LOCATION OPTIONAL

THIS DRAWING EMBODIES HOWMET FASTENING SYSTEMS CONFIDENTIAL, PROPRIETARY DESIGN & ALL DESIGN, MANUFACTURING PRODUCTION, USE & SALE RIGHTS REGARDING SAME ARE EXPRESSLY RESERVED.

HFS PART NO.	THREADS PER AS8879	ØA	C	ØD	H	M	ØP	W	AXIAL TENSILE STRENGTH lbf MIN	APPROX WEIGHT lbs / 100	
		MAX	MIN		MAX		MAX				
KFN542 -	06	.1380-32UNJC-3B	.320	.207	.176 .171	.220		.181	.189 .181	1,670	.10
	05	.1640-36UNJF-3B	.340	.242	.202 .197			.207	.220 .212	2,800	.17
	08	.1640-32UNJC-3B			.240						
	3	.1900-32UNJF-3B	.363	.277	.228 .223	.243	.233	.251 .243	3,470	.24	
	4	.2500-28UNJF-3B	.460	.348	.288 .283	.280	.097 .087	.293	.313 .306	6,200	.47
	5	.3125-24UNJF-3B	.560	.419	.352 .347	.340		.357	.376 .367	9,800	.78
	6	.3750-24UNJF-3B	.660	.491	.417 .412	.355		.422	.439 .430	13,000	.93
	7	.4375-20UNJF-3B	.760	.561	.484 .479	.400		.489	.502 .492	18,000	1.44
	8	.5000-20UNJF-3B	.860	.631	.551 .546	.430		.556	.564 .553	24,000	1.94
	9	.5625-18UNJF-3B	1.005	.700	.640 .635	.530	.115	.645	.627 .616	33,000	3.08
	10	.6250-18UNJF-3B	1.100	.846	.710 .705	.575	.105	.715	.752 .741	43,000	5.00
	12	.7500-16UNJF-3B	1.310	.987	.845 .840	.670	.125 .115	.850	.877 .865	61,000	7.88
	14	.8750-14UNJF-3B	1.480	1.130	.985 .980	.770	.145 .135	.990	1.002 .990	73,900	11.45
1612	1.0000-12UNJF-3B	1.690	1.271	1.125 1.120	.870	.165 .155	1.130	1.127 1.115	85,700	16.00	

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FILE STORED AS: S_KFN542

APPROVED DATE 07APR1983
REV. LETTER AND DATE H 27DEC2025
CUSTOMER: -

CURRENT DESIGN ACTIVITY:



HOWMET AEROSPACE

Howmet Fastening Systems
800 S State College Boulevard
Fullerton, California, 92831

TITLE:

NUT - 6 AND 12 POINT CAPTIVE WASHER, SELF LOCKING, ASSEMBLY

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & ASME Y14.5-2018 TOLERANCES: DECIMALS = ±.010; ANGLES = ±2°

CURRENT DESIGN ACTIVITY:

CAGE CODE: 15653

SALES DRAWING No.

KFN542-(*)

SHEET 1 OF 2


http://www.hfs.howmet.com TEL: (714)871-1550

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

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
MATERIAL: NUT ---- 8740 ALLOY STEEL PER AMS6322 (UNS G87400),
 4340 ALLOY STEEL PER AMS6415 (UNS G43406), OR
 4140 ALLOY STEEL PER AMS6382 (UNS G41400).
 WASHER - NO CODE -- C1050 CARBON STEEL PER AMS5085 (UNS G10500).
 C CODE --- A286 CORROSION RESISTANT STEEL PER AMS5525 (UNS S66286).

HEAT TREAT: NUT ---- HRC 39-43 PER AMS2759.
 WASHER - HRC 40-45 PER AMS2759 FOR C1050 MATERIAL.
 HRC 32 MIN PER AMS2759 FOR A286 MATERIAL.

FINISH:  KFN542-(*) --- NUT & WASHER - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
 KFN542C(*)DF - NUT ---- CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2,
 PLUS SOLID FOLM LUBE PER AS5272.
 WASHER - PASSIVATE PER AMS2700.

PERFORMANCE: KFS 1009, EXCEPT AS FOLLOWS:
 A) AXIAL TENSILE STRENGTH AS TABULATED.
 B) LOCKING TORQUE TO BE 5.0 in-lbf MAXIMUM AND BREAKAWAY TORQUE TO BE 1.0 in-lbf MINIMUM FOR THE .1380-32 SIZE.


TEMPERATURE: 450°F MAXIMUM.

- NOTES:  FINISH FOR .1640-36 SIZE ONLY:
 CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, WITH OLIVE DRAB CHROMATE FINISH FOR IDENTIFICATION PURPOSES.
 DIMENSIONS C & W APPLY BEFORE FORMING SELF LOCKING FEATURE.
 3. PARTS ARE SUPPLIED IN ASSEMBLED CONDITION ONLY.
 4. PACKAGING: PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING. ADD S AFTER DASH NUMBER FOR SPINDLE PACKAGED NUTS FOR USE WITH K-FAST™ AUTOMATIC TOOLS. EXAMPLE: KFN542-4S OR KFN542C4DFS.

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FILE STORED AS: S-KFN542

APPROVED DATE 07APR1983	CURRENT DESIGN ACTIVITY:	TITLE: NUT - 6 AND 12 POINT CAPTIVE WASHER, SELF LOCKING, ASSEMBLY	CURRENT DESIGN ACTIVITY: CAGE CODE: 15653
REV. LETTER AND DATE H 27DEC2025	 HOWMET AEROSPACE Howmet Fastening Systems 800 S State College Boulevard Fullerton, California, 92831	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & ASME Y14.5-2018 TOLERANCES: DECIMALS = ±.010; ANGLES = ±2°	SALES DRAWING No.
CUSTOMER: -			KFN542-(*)