NATIONAL STOCK NUMBER 2840-01-159-9633 RV

PART NUMBER 644943

I. GENERAL NOTES

A. Parts shall be identified per MIL-STD-130 using the method(s) specified by PWA 310 and the applicable drawing(s).

II. CRITICAL CHARACTERISTICS

A. .4345 / .4330 DIA 7 LANDS — EACH PAIRING OF ADJACENT LANDS MUST LIE WITHIN A CYLINDRICAL ZONE OF .4350 MAX DIA (6 PAIRINGS)

B. ROLLED OR UPSET HEAD

C. Coldworking of head to shank fillet radius.

D. Threads

III. MAJOR Characteristics

A. SURFACE finish

B. DWG NOTE 5

C. SQUARENESS OF LAND WITH SURFACE [B] WITHIN .001 TOTAL

D. Concentricity OF LAND WITH PD of THD WITHIN .002 FIR

E. OVERALL LENGTH

ENGINEERING INSTRUCTIONS
(CONTINUATION SHEET)

NATIONAL STOCK NUMBER 2840-01-159-9633 RV

PART/ASSEMBLY NUMBER 644943

IV. Instructions

A. ALLOY TYPE TEST REQUIRED PER ATTM-MASTER AND ATTM CODE 8.
B. MAGNETIC PARTICLE INSPECTION REQUIRED PER MPS-111 METHOD MPM CODE ME-2 and MC-3
C. VISUAL INSPECT PER MM-148
E. HARDNESS INSPECT PER HIM-1 CODE 1
F. COLDWORKING OF HEAD TO FILLET RADIUS PER AMS 7454 AND SPS-B-676.

V. Controlled Processes

A. ROLLING OR UPSETTING OF HEAD (AMS 7454)
B. ROLLING OF THREADS (AMS 7454)
C. COLDWORKING OF HEAD TO FILLET RADIUS
D. NICKEL CADMIUM PLATING
E. MACROSCOPIC/MICROSCOPIC EXAMS (AMS 7454)
F. ALLOY TYPE TEST
G. MAGNETIC PARTICLE INSPECTION
H. HARDNESS INSPECTION
I. VISUAL INSPECTION
J. MATERIAL (AMS 7454)
K. CERTIFIED REPORTS (AMS 7454)