

MARK "S" OR "SPS"
ON .190 SIZE AND
LARGER ALSO MARK
STAINLESS MATERIAL
WITH "C". LOCATION
OPTIONAL AS SHOWN.
MULTIPLE MARKING
PERMITTED

STYLE A

STYLE B

EITHER SYLE TO BE SUPPLIED AT SPS' OPTION

TYPE	DASH NUMBER	THREADS SEE NOTE 5	ØB MIN	C MIN	H MAX	ØP MAX	S MIN	W		AXIAL STRENGTH LBS MIN			WEIGHT APPROX LBS/100
								MAX	MIN	STEEL AND STAINLESS	ALUMINUM	BRASS	
FK	632	.138-32 UNJC-3B								1,270	650	560	
FK	640	.138-40 UNJF-3B	.305	.339	.141	.181	.036	.313	.305	1,420	730	625	.20
FK	832	.164-32 UNJC-3B								1,960	1,010	865	
FK	836	.164-36 UNJF-3B	.336	.375	.188	.208	.070	.345	.336	2,060	1,060	908	.35
FK	1024	.190-24 UNJC-3B								2,450	1,270	1,090	
FK	1032	.190-32 UNJF-3B	.367	.410	.188	.230	.065	.376	.367	2,800	1,450	1,240	.38
FK	1224	.216-24 UNJC-3B								3,380	1,740	1,490	
FK	1228	.216-28 UNJF-3B	.430	.481	.209	.258	.071	.439	.430	3,610	1,860	1,590	.62
FK	420	.250-20 UNC-2B								4,450	2,290	1,960	
FK	428	.250-28 UNJF-3B	.430	.481	.219	.293	.075	.439	.430	5,090	2,620	2,240	.61
FKF	518	.312-18 UNC-2B								4,980	3,030	2,590	
FK	524	.312-24 UNJF-3B	.492	.552	.266	.356	.097	.502	.492	5,510	3,350	2,870	.97
FKF	616	.375-16 UNC-2B								7,360	3,890	3,330	
FK	624	.375-24 UNJF-3B	.553	.623	.282	.418	.108	.564	.553	8,340	4,390	3,760	1.69
FKF	714	.437-14 UNC-2B	.616	.694			.138	.627	.616	10,100	5,290	4,530	1.71
FK	720	.437-20 UNJF-3B	.616	.694	.328	.487	.138	.627	.616	11,300	5,900	5,060	1.71
FK	720 UN	.437-20 UNJF-3B	.679	.765			.120	.690	.679	11,300	5,900	6,170	2.13
FKF	813	.500-13 UNC-2B								11,400	6,480	5,550	
FK	820	.500-20 UNJF-3B	.741	.836	.328	.551	.121	.752	.741	12,800	7,250	6,210	2.39
FK	912	.562-12 UNC-2B								14,600	10,060	8,620	
FK	918	.562-18 UNJF-3B	.865	.978	.368	.614	.135	.877	.865	16,200	11,100	9,510	3.66
FKF	1011	.625-11 UNC-2B								18,100	10,700	9,170	
FK	1018	.625-18 UNJF-3B	.928	1.049	.399	.676	.147	.940	.928	20,500	12,100	10,370	4.38
FKF	1210	.750-10 UNC-2B								26,800	13,100	11,200	
FK	1216	.750-16 UNJF-3B	1.052	1.192	.415	.807	.155	1.064	1.052	29,800	14,600	12,510	6.04
FKF	1409	.875-9 UNC-2B								36,940	20,400	17,500	
FK	1414	.875-14 UNJF-3B	1.239	1.405	.477	.938	.166	1.252	1.239	40,800	22,500	19,280	9.44
FKF	1608	1.000-8 UNC-2B								48,500	26,800	22,970	
FK	1612	1.000-12 UNJF-3B	1.427	1.619	.571	1.064	.218	1.440	1.427	53,000	28,000	24,000	15.24
FK	1614	1.000-14 UNJF-3B								54,400	28,200	24,170	
FK	1812	1.125-12 UNJF-3B	1.614	1.832	.634	1.191	.238	1.627	1.614	68,500	29,900	25,620	19.19
FK	2012	1.250-12 UNJF-3B	1.801	2.046	.759	1.315	.311	1.814	1.801	85,800	37,500	32,140	39.14
FK	2212	1.375-12 UNJF-3B	1.988	2.259	.821	1.440	.325	2.002	1.988	90,700	40,300	34,540	41.99
FK	2412	1.500-12 UNJF-3B	2.176	2.473	.884	1.565	.350	2.190	2.176	109,000	48,400	41,480	57.56

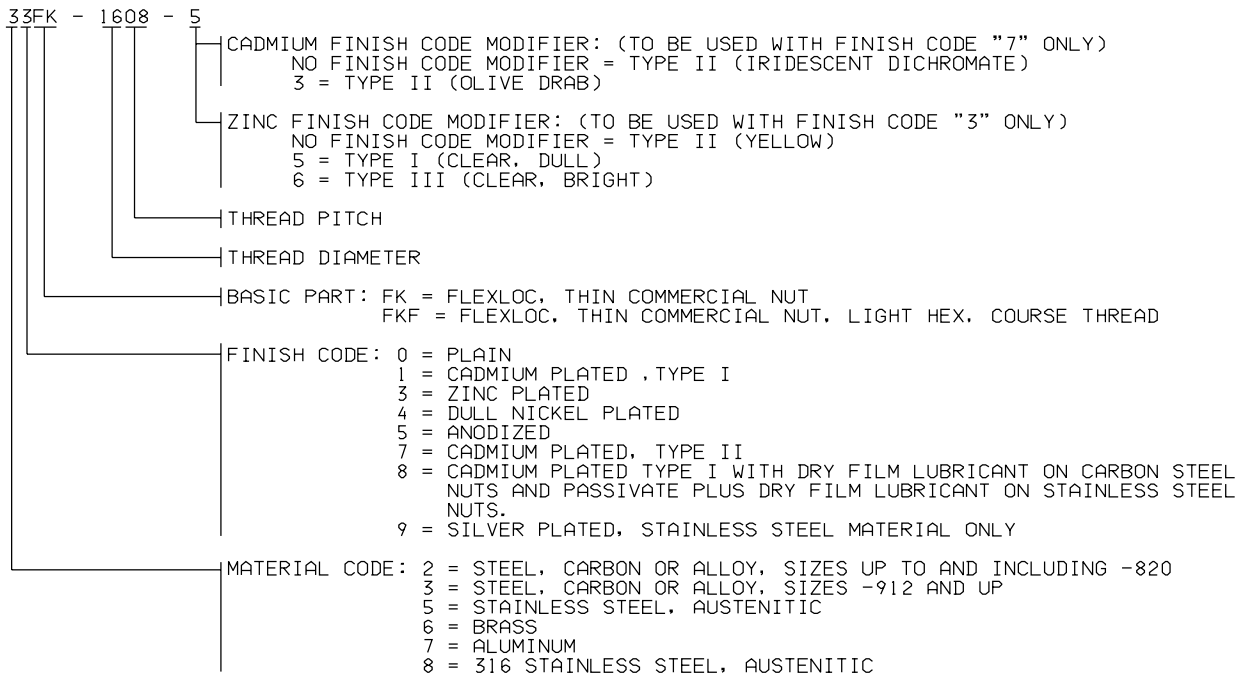
* UN FOLLOWING DASH NUMBER SIGNIFIES UNIFIED HEX.

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TOLERANCES ±.010 AND ±2° SURFACE ROUGHNESS 125 UNLESS OTHERWISE NOTED DRAWN BY: STEVE FOSTER APPROVED: M ZATAVESKI APPROVED: M LAWLER	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M DATE: 7/29/91 DATE: 4/25/2000	SPS TECHNOLOGIES	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS NASM25027 AS APPLICABLE PART NUMBER: FK & FKF SHEET 1 OF 2
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TITLE
NUT, FLEXLOC, THIN, LIGHT HEX SERIES, SELF-LOCKING

1. MATERIAL: STEEL, CARBON.
STAINLESS STEEL, AUSTENITIC.
316 STAINLESS STEEL, AUSTENITIC.
BRASS, NAVAL HALF HARD.
ALUMINUM, 2024-T4 OR 2024-T351.
2. FINISH: PLAIN, (CARBON STEEL PARTS WILL BE SUPPLIED WITH A RUST PREVENTATIVE OIL, AND STAINLESS STEEL PARTS WILL BE PASSIVATED)
CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 2. (CARBON STEEL AND BRASS ONLY)
CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. (CARBON STEEL ONLY)
DULL NICKEL PER AMS 2403 (CARBON STEEL ONLY)
SILVER PLATE PER AMS 2410. (STAINLESS STEEL ONLY)
ZINC PLATE PER ASTM B633, TYPE DEFINED BY FINISH CODE MODIFIER, Fe/Fn 5. (CARBON STEEL ONLY)
ANODIZE PER MIL-A-8625. (ALUMINUM ONLY)
3. WEIGHTS APPLY TO CARBON STEEL NUTS.
4. LUBRICANT: UNLESS OTHERWISE SPECIFIED, PARTS SHALL BE SUPPLIED WITH A NON-DRY LUBRICANT (WAX TYPE), AND WHEN SPECIFIED, MOLYBDENUM DISULFIDE DRY FILM LUBRICANT.
5. THREADS: BEFORE LUBRICATION PER MIL-S-7742 CLASS 2B AND AS8879 FOR CLASS 3B.
6. LOCKING TORQUE PER NASM25027 AS APPLICABLE, EXCEPT REUSABILITY NOT REQUIRED ON UNPLATED STAINLESS STEEL NUTS AND LIMITED TO 5 REUSE CYCLES ON UNPLATED, DRY FILM LUBRICATED, STAINLESS STEEL NUTS.
7. DISCONTINUITIES PER NASM25027.
8. DIMENSIONS SHALL BE MET PRIOR TO LUBRICATION ON DRY FILM LUBRICATED NUTS.
9. DIMENSIONS ARE IN INCHES.
10. BREAK SHARP EDGES.
11. SURFACE TEXTURE PER ANSI B46.1 SHALL NOT EXCEED 125 MICROINCHES UNLESS OTHERWISE SPECIFIED.
12. USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO BE USED ON EXTERNAL THREADS WITHIN THE LIMITATIONS OF MS33588.
13. PART NUMBERING SYSTEM:



EXAMPLES: 33FK-1812-5 = 1.125 DIAMETER, THIN COMMERCIAL, SELF-LOCKING FLEXLOC MADE FROM CARBON STEEL WITH ZINC PLATE PER ASTM B633, TYPE I (CLEAR, DULL), Fe/Zn5.

59FKF-1608 = 1.000 DIAMETER, THIN COMMERCIAL, LIGHT HEX, COARSE THREAD, SELF-LOCKING FLEXLOC MADE FROM STAINLESS STEEL WITH SILVER PLATE PER AMS 2410.