



- NOTES:
1. FINISH .125 EXCEPT AS NOTED.
 2. ALL CORNERS AND EDGES SHALL BE ROUNDED OR BROKEN .005-0.010 UNLESS OTHERWISE SPECIFIED.
 3. ROCKWELL READINGS SHALL BE TAKEN ON LOCKING LUGS AND REAR END OF BOLT.
 4. EACH LOCKING LUG SHALL BE PERPENDICULAR WITHIN .0005 WITH AXIS ESTABLISHED BY .725 DIA-.002 AND .707 DIA-.002. (F)
 5. MATERIAL: STEEL, CPM 8200, EXCEPT UNSPECIFIED. (M)
 6. MATERIALS SHALL BE CONTROLLED AS REQUIRED, TO SURE MANUFACTURER'S HEAT TREATMENT PROCESS AND ASSURE THAT SPECIFIED MANDATORY PHYSICAL PROPERTIES ARE MET. AUSTENITIC GRAIN SIZE 5 TO 8.
 7. HEAT TREATMENT: RECOMMENDED HEAT TREATMENT PROCEDURE: CARBURIZING AT 1550°F TO 1600°F FOR SPECIFIED CASE DEPTH, WITHOUT REHEATING, QUENCH IN OIL OR NEUTRAL SALT BATH FROM 1600°F TO 160°F; IF REHEATED, QUENCH FROM 1600°F TO MANDATORY REQUIREMENTS:
 - a. NORMALIZE BEFORE MACHINING.
 - b. CARBURIZE TO CASE DEPTH .02 TO .018.
 - c. TEMPER ONE HOUR MINIMUM AT 350°F TO 450°F.
 - d. CORE, ROCKWELL HARDNESS C33 TO C42 SURFACE.
 ROCKWELL HARDNESS 065-71 OR REFERRED METHOD 30N-74 MINIMUM ON A PROPERLY PREPARED SURFACE.
 8. MICROSTRUCTURE OF CORE SHALL NOT CONTAIN (E) (F) MORE THAN 10% FREE FERRITE AFTER HEAT TREATMENT PER AMS 2315.
 9. THE USE OF A STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED.
 10. WHEN GAS CARBURIZING IS USED THE CARBON CONTENT SHALL NOT EXCEED 0.84% AT SURFACE OF COMPONENT PER AMS 2702.
 11. FINAL PROTECTIVE FINISH: FINISH 3.3.1.2 OF MIL-STD-171.
 12. MIL-W-8850 SHALL APPLY.

- NOTES:
1. (Q) SURFACE HARDNESS POINTS FOR ROCKWELL TESTING - USE WITH FIXTURE F7796306.
 2. TEST SPECIMEN FOR CASE DEPTH, FREE FERRITE, AND OR HARDNESS TESTS. BOLTS SHALL BE SECTIONED AS INDICATED ABOVE. SURFACES SHALL BE GROUND (FINE GRIND) PARALLEL AS SHOWN. SURFACE SHALL BE PREPARED FOR TESTS IN ACCORDANCE WITH AMS 2315A.

DATA FOR HARDNESS TESTING
SCALE - NTS (P)

REV	DESCRIPTION	DATE	BY	CHKD
1	ISSUED FOR PRODUCTION	10/15/57	R. H. HANCOCK	J. W. HANCOCK
2	REVISION			
3	REVISION			
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PART NO. 7790185

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