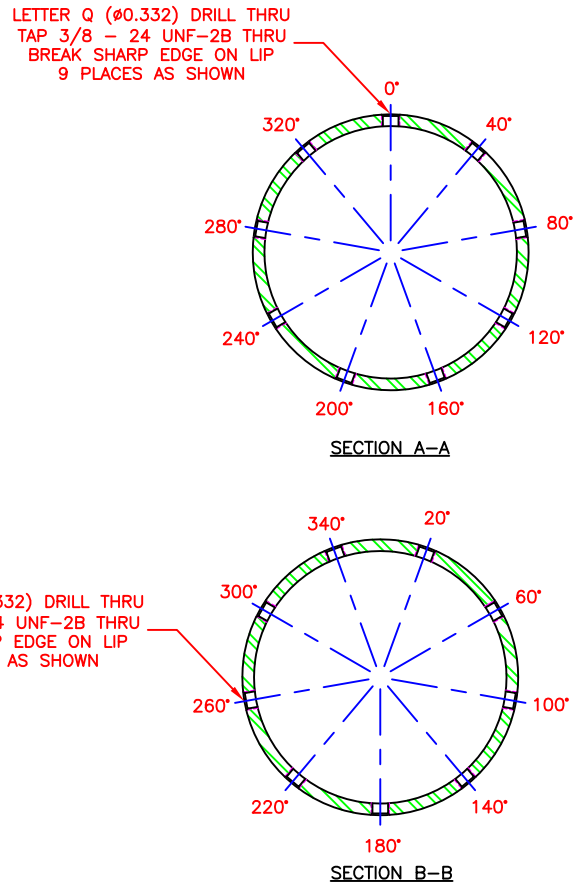
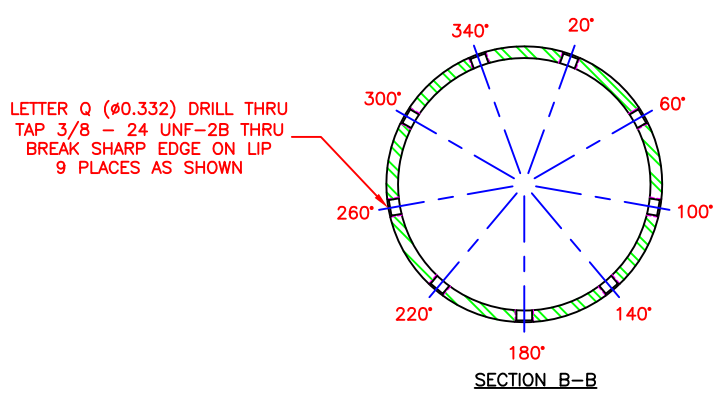
REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	INITIAL ISSUE	04 FEB 13	K.H.



SECTION A–A

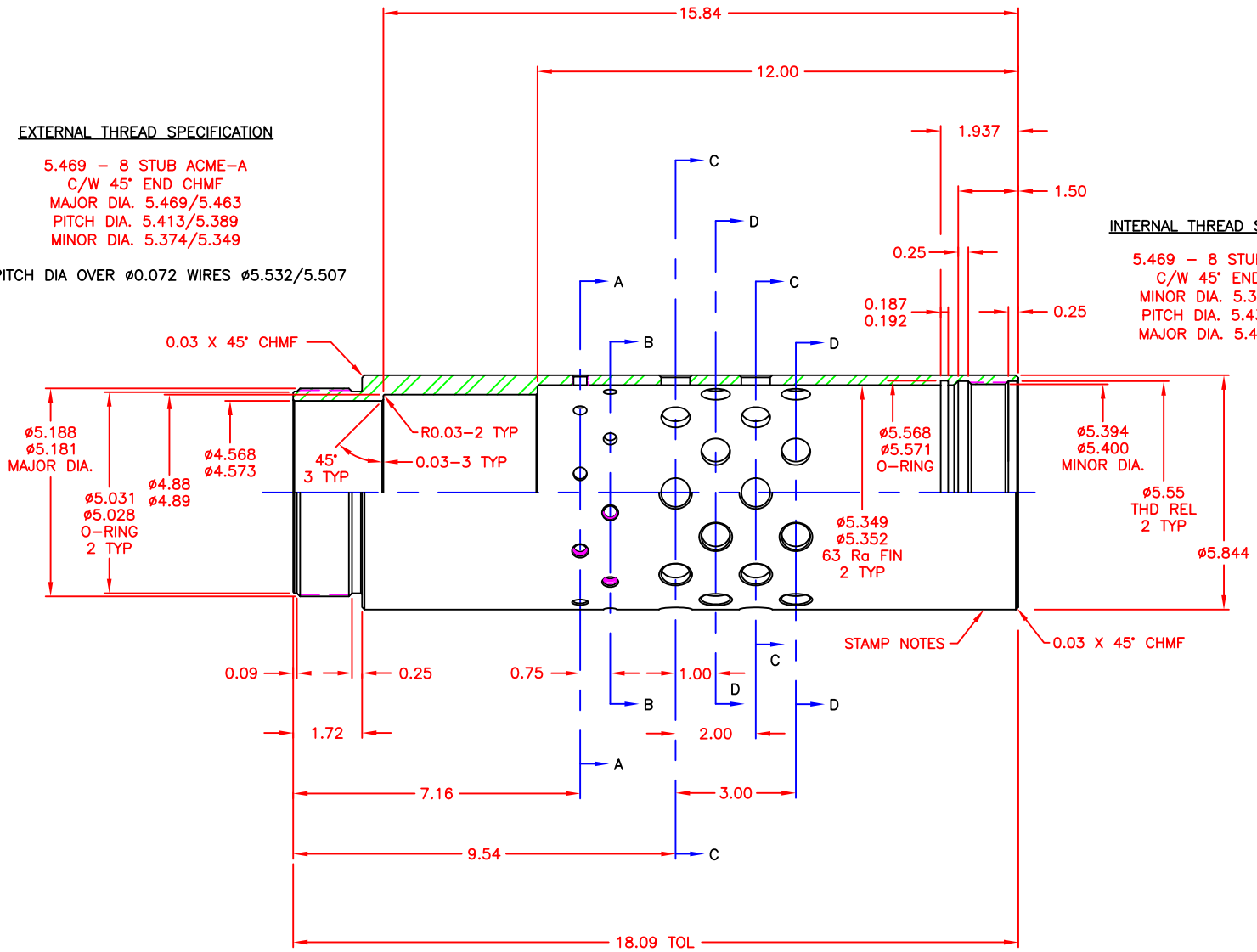


SECTION B–B

EXTERNAL THREAD SPECIFICATION

5.469 – 8 STUB ACME–A
C/W 45° END CHMF
MAJOR DIA. 5.469/5.463
PITCH DIA. 5.413/5.389
MINOR DIA. 5.374/5.349

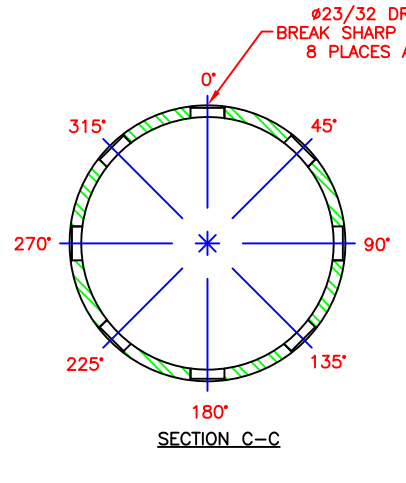
NOTE PITCH DIA OVER ø0.072 WIRES ø5.532/5.507



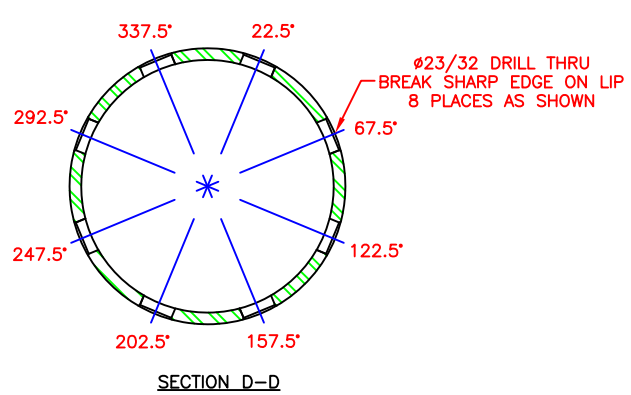
QUARTER SECTION THRU CENTRE LINE

INTERNAL THREAD SPECIFICATION

5.469 – 8 STUB ACME–B
C/W 45° END CHMF
MINOR DIA. 5.394/5.400
PITCH DIA. 5.431/5.456
MAJOR DIA. 5.489/5.513



SECTION C–C



SECTION D–D

NOTE: 1. FOR USE WITH 2–253 O–RING, NO B/U's (1) [INTERNAL],
2. FOR USE WITH 2–250 O–RING, NO B/U's (1), BASTARD GLAND [EXTERNAL],
3. SEE ASSEMBLY DETAIL FOR SHEAR SCREW SPECIFICATION,
4. STAMP PART NUMBER, MATERIAL ID CODE & MANUFACTURER LOGO,
5. REMOVE RAG EDGE FROM FLANKS OF THREADING, 2 PLACES,
6. CASE HARDEN BY LIQUID NITRATION, 0.005/0.008 INCH DEPTH,
7. WATER QUENCH IS NOT PERMISSIBLE DURING LIQUID NITRATION PROCESS,
8. PERMISSIBLE TO LEAVE OIL FILM ON COMPONENT AFTER LIQUID NITRATION PROCESS,
9. DEBUR & BREAK ALL SHARP EDGES.

SPECIFICATIONS UNLESS NOTED
1. TOLERANCE – CONCENTRICITY
.000 ±.005 – .005 T.I.R.
.00 ±.015 – .015 T.I.R.
.0 ±.030 – .030 T.I.R.
ANGULAR ±0°30'
2. SURFACE FINISH – 125 Ra
3. BREAK EDGES – .03 X 45°
4. FILLETS – .03 R MAXIMUM
5. DO NOT SCALE DRAWING.

MATERIAL
ø6.0 X ø4 1/4 X 18 1/2 TOL
AISI 4140/4130 HRc 28–32
P110 OR EQUIVALENT

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CAD SCALE	FULL	
	BY	DATE
DRN	K.H.	04 FEB 13
ISS	K.H.	01 MAR 13
APP		

Sturni–Hueston Engineering Ltd
Edmonton, Alberta Canada

PORTED HOUSING
FOR
ø4 1/2 X 11.6#
LADYFINGER
[ø6 1/4 OPEN HOLE]

DWG No. D–LAD1141104 B