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REV. A
AS85643/2

FEDERAL SUPPLY CLASS
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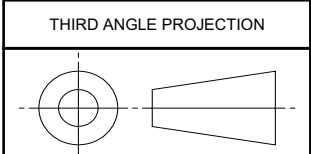
RATIONALE

AS85643/2 STABILIZED BECAUSE THE CONTENT IS MATURE AND STILL RELEVANT BUT THERE ARE MORE RECENT STANDARDS THAT SHOULD BE CONSIDERED. THIS STANDARD HAS BEEN STABILIZED. CONSIDERATION SHOULD ALSO BE GIVEN TO USING THE NAS, NATIONAL AEROSPACE STANDARD WHEN SETTING REQUIREMENTS FOR PRODUCTS.

STABILIZED NOTICE

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SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS85643/2A>



CUSTODIAN: EG-1/EG-1B		PROCUREMENT SPECIFICATION: NONE	
	AEROSPACE STANDARD		AS85643/2
	BIT, SCREWDRIVER, PHILLIPS, RIBBED, CRUCIFORM, LONG SHANK, EXTERNAL HEXAGON SHANK, POWER DRIVEN		

ISSUED 1998-05 REAFFIRMED 2004-01 STABILIZED 2013-09

NOTICE

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	AEROSPACE STANDARD	AS85643/2 SHEET 1 OF 7	REV. A
	BIT, SCREWDRIVER, PHILLIPS, RIBBED, CRUCIFORM, LONG SHANK, EXTERNAL HEXAGON SHANK, POWER DRIVEN		

THE COMPLETE REQUIREMENTS FOR ACQUIRING THE BITS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION AND THE LATEST ISSUE OF MIL-B-85643.

1. REQUIREMENTS:

1.1 MATERIAL: UNS T41901 (AISI S-1) OR UNS T41902 (AISI S-2) TOOL STEEL IN ACCORDANCE WITH QQ-T-570, TYPE S1 OR S2.

1.2 DIMENSIONS AND CONFIGURATION:

BIT AND RETAINING GROOVE: IN ACCORDANCE WITH FIGURE 1 AND TABLE I. LENGTH IN ACCORDANCE WITH TABLE II.

DRIVER POINT: IN ACCORDANCE WITH FIGURE 1, FIGURE 2 AND TABLE III.

1.2.1 CRUCIFORM DRIVER BIT GAGE: IN ACCORDANCE WITH FIGURE 3 AND TABLE IV.

1.3 HARDNESS: ROCKWELL 58 TO 62 HRC.

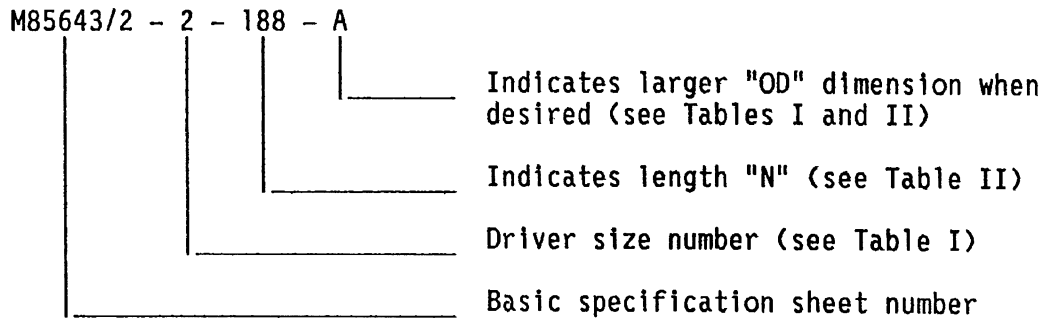
1.4 IDENTIFICATION: STAMP MILITARY PART NUMBER (SEE 1.8) AND MANUFACTURER'S NAME, TRADEMARK OR SYMBOLS.

1.5 TEST RECESS: THE TEST RECESS CONFIGURATION AND DIMENSIONS SHALL CONFORM TO FIGURE 4 AND TABLE V.

1.6 MINIMUM ULTIMATE TORQUE LOADS: IN ACCORDANCE WITH TABLE I AND MIL-B-85643.

1.7 TORQUE FATIGUE LOADS: IN ACCORDANCE WITH TABLE I AND MIL-B-85643.

1.8 EXAMPLE OF MILITARY PART NUMBER.



1.9 ACR AND PHILLIPS ARE REGISTERED TRADEMARKS OF PHILLIPS SCREW COMPANY. PATENT 4,187,892 EXPIRES 12 FEBRUARY 1997. THE GOVERNMENT DOES NOT HAVE A ROYALTY-FREE LICENSE.

	AEROSPACE STANDARD	AS85643/2 SHEET 2 OF 7	REV. A
	BIT, SCREWDRIVER, PHILLIPS, RIBBED, CRUCIFORM, LONG SHANK, EXTERNAL HEXAGON SHANK, POWER DRIVEN		