

FED. SUPPLY CLASS

5307

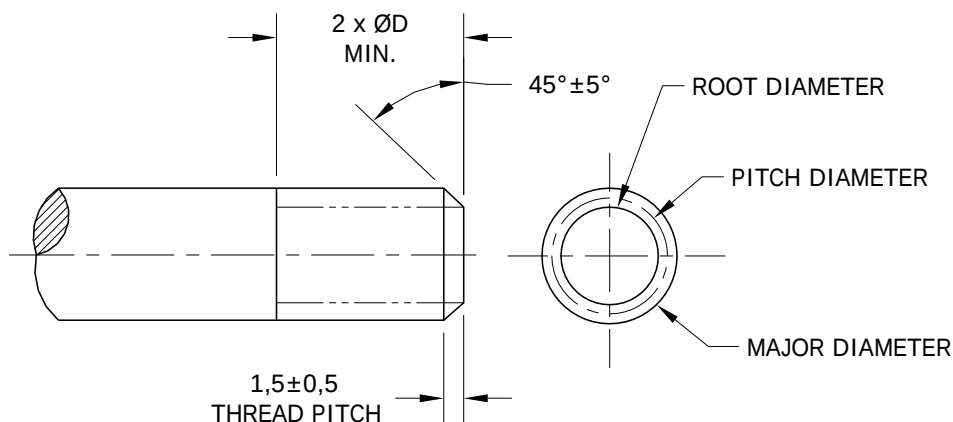


TABLE I – THREAD DIMENSIONS ⁽³⁾

SIZE	MAXIMUM STUD	MINIMUM MANDREL			
	PITCH DIAMETER 0 -0,01	MAJOR DIAMETER 0 -0,01	PITCH DIAMETER 0 -0,01	TOLERANCE IN LEAD PER mm	TOLERANCE ON HALF ANGLE OF THREAD IN MINUTES
MJ3 X 0,5	2,662	2,894	2,627	± 0,0003	± 15
MJ3,5 X 0,6	3,096	3,375	3,057		
MJ4 X 0,7	3,530	3,860	3,489		
MJ5 X 0,8	4,464	4,850	4,420		
MJ6 X 1	5,333	5,820	5,279		
MJ7 X 1	6,333	6,820	6,279		
MJ8 X 1	7,332	7,820	7,279		
MJ10 X 1,25	9,169	9,788	9,113		
MJ12 X 1,25	11,167	11,788	11,103		
MJ14 X 1,5	13,003	13,003	12,936		
MJ16 X 1,5	15,002	15,764	14,936	± 10	± 10
MJ18 X 1,5	17,001	17,764	16,936		
MJ20 X 1,5	19,000	19,764	18,936		
MJ22 X 1,5	20,999	21,764	20,936		
MJ24 X 2	22,673	23,720	22,595		
MJ27 X 2	25,672	26,720	25,595		
MJ30 X 2	28,670	29,720	28,595		

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	NONE

CUSTODIAN	NATIONAL AEROSPACE STANDARDS COMMITTEE
TITLE	STUD AND MANDREL TEST FIXTURE, SELF-LOCKING NUTS, METRIC

REVISION	3
CLASSIFICATION DESIGN STANDARD	DA0010

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE:

FORM 12-01

REVISION DATE: MARCH 31, 2015

ISSUE DATE: SEPTEMBER 1977

MAXIMUM STUD:

MATERIAL: STEEL

HEAT TREATMENT: 36 HRC MIN

FINISH: CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

THREADS: PER FED-STD-H28/21 EXCEPT THE PITCH DIAMETER DIMENSION SHALL BE AS SHOWN IN TABLE I.

MINIMUM MANDREL:

MATERIAL: STEEL

HEAT TREAT: 58-64 HRC

SURFACE TEXTURE: 0,8 MICROMETERS Ra MAXIMUM PER ASME B46.1.

THREADS: PER FED-STD-H28/21 EXCEPT AS NOTED IN TABLE I.
BREAK SHARP EDGES ON LEAD THREADS 0,1 TO 0,4.

NOTES:

- (1) STUDS AND MANDRELS ARE USED IN VARIOUS TESTS CONDUCTED ON SELF-LOCKING NUTS.
- (2) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- ③ (3) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (4) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (5) DIMENSIONS IN MILLIMETERS.
- (6) DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- ③ (7) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

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