

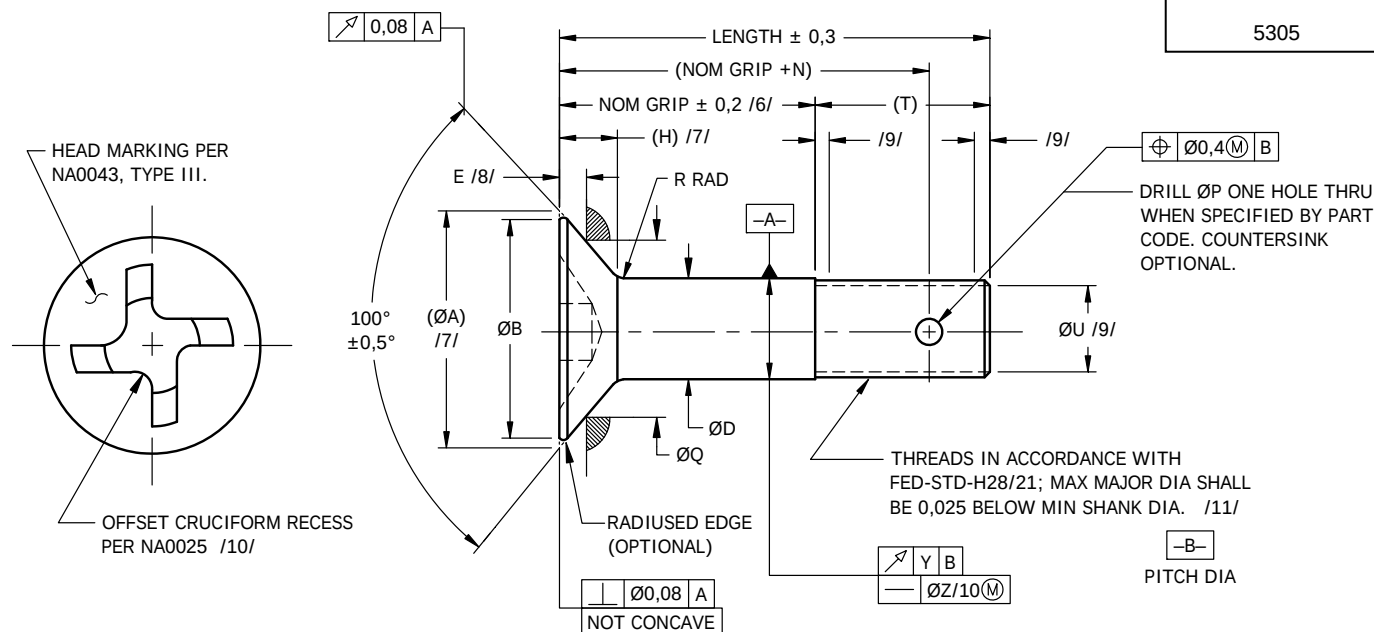


FIGURE 1 – SCREW CONFIGURATION

TABLE I – DIMENSIONS

DIA CODE	THREAD 4h6h	(ØA) /7/	ØB MIN	ØD	E GAGE PROT /8/	(H) /7/	N BASIC	ØP	ØQ GAGE /8/	R RAD	(T)	ØU /9/	Y FIM	Z FIM
030	MJ3 x 0,5	6,0	5,4	2,990 2,965	0,51 0,43	1,27	—	—	4,805 4,800	0,4 0,2	6,0	2,3 1,8	0,10	0,02
035	MJ3,5 x 0,6	7,0	6,3	3,490 3,465	0,54 0,46	1,5	—	—	5,705 5,700	0,4 0,2	6,5	2,7 2,2	0,12	0,02
040	MJ4 x 0,7	8,0	7,2	3,990 3,965	0,63 0,55	1,67	5,0	1,24 1,10	6,505 6,500	0,4 0,2	7,5	3,0 2,5	0,12	0,02
050	MJ5 x 0,8	10,0	9,0	4,990 4,965	0,72 0,64	2,12	6,0	1,64 1,50	8,305 8,300	0,5 0,3	9,0	3,9 3,4	0,12	0,02
060	MJ6 x 1	12,0	10,8	5,990 5,965	0,80 0,72	2,54	7,0	1,64 1,50	10,105 10,100	0,7 0,5	10,0	4,7 4,2	0,12	0,02
080	MJ8 x 1	16,0	14,8	7,987 7,962	0,93 0,85	3,4	7,5	2,04 1,90	13,805 13,800	0,7 0,5	11,5	6,7 6,2	0,15	0,02
100	MJ10 x 1,25	20,0	18,8	9,987 9,962	1,06 0,98	4,24	9,0	2,54 2,40	17,505 17,500	0,8 0,6	14,5	8,4 7,9	0,15	0,015
120	MJ12 x 1,25	24,0	22,8	11,984 11,959	1,27 1,19	5,08	10,0	2,54 2,40	21,005 21,000	0,9 0,6	16,0	10,4 9,9	0,18	0,015
140	MJ14 x 1,5	28,0	26,8	13,984 13,959	1,48 1,40	5,93	12,0	3,14 3,00	24,505 24,500	1,1 0,8	19,0	12,0 11,5	0,18	0,015
160	MJ16 x 1,5	32,0	30,8	15,984 15,959	1,70 1,62	6,79	13,0	3,14 3,00	28,005 28,000	1,1 0,8	20,5	14,0 13,5	0,18	0,015
180	MJ18 x 1,5	36,0	34,8	17,984 17,959	1,91 1,83	7,63	14,0	3,98 3,80	31,505 31,500	1,3 1,0	22,5	16,0 15,5	0,18	0,015
200	MJ20 x 1,5	40,0	38,8	19,980 19,955	2,12 2,04	8,48	15,0	3,98 3,80	35,005 35,000	1,3 1,0	24,5	18,0 17,5	0,21	0,015

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REVISION

4

PROCUREMENT SPECIFICATION

NA0008

TITLE

**SCREW, CLOSE TOLERANCE, 100° FLUSH HEAD,
OFFSET CRUCIFORM RECESS, ALLOY STEEL,
660 MPa SHEAR, METRIC**

CLASSIFICATION
PART STANDARD

Documents
SHEET 1 OF 5

MATERIAL:

ALLOY STEEL PER PROCUREMENT SPECIFICATION.

HEAT TREAT:

660 MPa MINIMUM ULTIMATE SHEAR (36-40 HRC).

FINISH:

CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 (8-14 μ m THICK).

CODE:

FIRST THREE NUMBERS INDICATE NOMINAL SHANK DIAMETER IN MILLIMETERS AND TENTHS AS
TABULATED.

SECOND THREE NUMBERS DESIGNATE NOMINAL GRIP LENGTH IN MILLIMETERS AS TABULATED.
CODE LETTER "D" FOLLOWING BASIC PART NUMBER INDICATES DRILLED THREAD. /5/

EXAMPLE OF PART NUMBER:

NA0038-080016 = SCREW: MJ8 x 1 THREAD; 16 mm GRIP.
NA0038D080016 = SCREW: MJ8 x 1 THREAD; 16 mm GRIP; DRILLED THREAD.
NA0038-090016 = SCREW: MJ8 x 1 THREAD; 16 mm GRIP; 1 mm OVERSIZE SHANK.

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET RADIUS, SHANK AND ALL
THREAD ELEMENTS: 0,8 MICROMETERS Ra; ALL OTHER SURFACES: 3,2 MICROMETERS Ra PER ASME
B46.1.
- (2) REMOVE ALL BURRS AND BREAK ALL SHARP EDGES 0,1 TO 0,4.
- (3) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /4/ DIAMETER CODES "035" AND "045" INACTIVE FOR DESIGN AFTER 31 DEC 1990. NO SUPERSEDING
STANDARD. FOR DESCRIPTION OF STATUS NOTES SEE NAS10000.
- /5/ IF REQUIRED, TENSILE TESTING OF BOLTS REQUIRING CROSS-DRILLED THREADS SHALL BE
PERFORMED PRIOR TO DRILLING AND THE APPLICATION OF PLATING AND/OR COATINGS. WHEN BOLTS
HAVE BEEN DRILLED, STRENGTH MAY BE VERIFIED BY SHEAR TESTING, IN LIEU OF TENSILE TESTING,
IN ACCORDANCE WITH MIL-STD-1312. USERS SHOULD BE AWARE THAT FASTENERS WITH CROSS-
DRILLED THREADS MAY EXHIBIT A REDUCTION IN TENSILE STRENGTH.
- /6/ GRIP LENGTH IS FROM TOP OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
- /7/ DIMENSIONS "(ØA)" AND "(H)" ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND
ARE NOT TO BE USED FOR INSPECTION. VALUES "(ØA)" AND "(H)" ARE CALCULATED LIMITS RESULTING
FROM TOLERANCE ON "ØB", "ØD", "E", "ØQ" AND HEAD ANGLE.
- /8/ DIMENSIONS FOR "E" GAGE PROTRUSION SHALL BE INSPECTED PER NA0048.

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Documents
SHEET 2

Document Sharing Hub