

FED. SUPPLY CLASS

5305

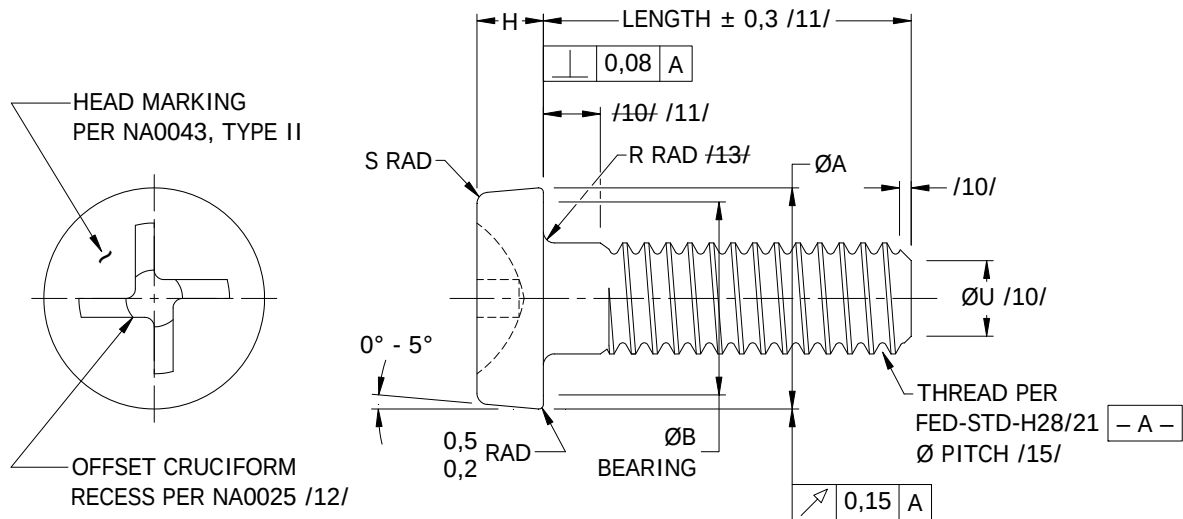


TABLE I – DIMENSIONS AND STRENGTH VALUES

DIA CODE /5/	THREAD 4h6h	ØA	ØB BEARING MIN	H	R RAD MIN	S RAD MIN	ØU	RECESS		TENSILE STRENGTH N MIN /16/
								RECESS NO.	INSPECTION TORQUE N-m /12/	
Ø16 A016	MJ1,6 x 0,35	3,2 2,9	1,9	1,0 0,8	0,3 0,1	0,2	1,1 0,6	0	0,4	~~1 630~~ 1 300
Ø20 A020	MJ2 x 0,4	4,0 3,7	2,7	1,2 1,0	0,3 0,1	0,2	1,4 0,9	1	0,9	~~2 420~~ 2 100
Ø25 A025	MJ2,5 x 0,45	5,0 4,7	3,7	1,5 1,3	0,3 0,1	0,3	1,9 1,4	3	1,3	~~4 210~~ 3 370
Ø30 A030	MJ3 x 0,5	6,0 5,7	4,7	1,8 1,6	0,4 0,2	0,3	2,3 1,8	4	1,8	~~6 160~~ 4 930
Ø40 A040	MJ4 x 0,7	8,0 7,7	6,7	2,4 2,2	0,4 0,2	0,4	3,0 2,5	8	4,2	~~10 900~~ 8 720
Ø50 A050	MJ5 x 0,8	10,0 9,7	8,7	3,0 2,8	0,5 0,3	0,5	3,9 3,4	10	5,6	~~17 400~~ 13 900
Ø60 A060	MJ6 x 1	12,0 11,7	10,7	3,6 3,3	0,7 0,5	0,6	4,7 4,2	1/4	14	~~24 800~~ 19 800
Ø70 A070	MJ7 x 1	14,0 13,7	12,7	4,2 4,0	0,7 0,5	0,7	5,7 5,2	1/4	14	~~34 500~~ 27 900
Ø80 A080	MJ8 x 1	16,0 15,7	14,7	4,8 4,5	0,7 0,5	0,8	6,7 6,2	5/16	28	~~46 600~~ 37 300
Ø100 A100	MJ10 x 1,25	20,0 19,7	18,7	6,0 5,7	0,8 0,6	1,0	8,4 7,9	3/8	48	~~72 900~~ 58 300

/14/

THIRD
ANGLE
PROJECTION

PROCUREMENT
SPECIFICATION

NOTED

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

SCREW, MACHINE, PAN HEAD, OFFSET CRUCIFORM,
A286 CRES, FULL THREAD, 1100 MPa, METRIC

REVISION

8

CLASSIFICATION
PART STANDARD

DI0068

SHEET 1 of 3

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

ISSUE DATE: DECEMBER 1979 REVISION DATE: SEPTEMBER 19, 2014

MATERIAL: A286 CRES (UNS S66286) PER PROCUREMENT SPECIFICATION.

HEAT TREAT: DEVELOP BASIC MATERIAL PROPERTIES WITH CONTROLS PER ~~AMS-H-6875~~ OR AMS2759 /16/: 1,100 MPa MINIMUM ULTIMATE TENSILE.

FINISH: PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
BLACK OXIDE COATING PER MIL-DTL-13924, CLASS 1.

CODE: DIAMETER CODE FROM TABLE I AFTER BASIC NUMBER DESIGNATES NOMINAL THREAD SIZE.
LENGTH CODE DESIGNATES NOMINAL LENGTH IN EVEN NUMBER INCREMENTS.
SEE TABLE II FOR RECOMMENDED LIMITS.
"B" AFTER LENGTH CODE DESIGNATES BLACK OXIDE COATING.

EXAMPLE OF PART NUMBER:

NA0068 030016 = SCREW: MJ3 x 0,5, 16 mm LONG.
NA0068A030016 = SCREW: MJ3 x 0,5, 16 mm LONG, PASSIVATED.
NA0068A030016B = SCREW: MJ3 x 0,5, 16 mm LONG, BLACK OXIDE COATED.

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET RADIUS AND ALL THREAD ELEMENTS: 0,8 µm MAX; ALL OTHER SURFACES: 3,2 µm MAX PER ASME B46.1.
- (2) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, TEST METHOD 3.
- (3) REMOVE ALL BURRS AND SHARP EDGES. BREAK SHARP EDGES 0,1 TO 0,4.
- (4) DIMENSIONS IN MILLIMETERS.
- /5/ NON 'A' PREFIXED DIAMETER CODES CANCELED AFTER APRIL 15, 1993. NO SUPERSEDING STANDARD. FOR DESCRIPTION OF STATUS NOTES SEE NAS10000.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (8) 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.
- /10/ ~~INCOMPLETE THREADS IN ACCORDANCE WITH FED-STD-H28/21~~: POINT SHALL BE FLAT AND CHAMFERED TO APPROXIMATELY 45° FROM "ØU".
- /11/ FOR SCREWS 35 MILLIMETERS IN LENGTH OR LESS, THREAD TO HEAD. LONGER SCREWS SHALL HAVE A MINIMUM THREAD LENGTH OF 36 MILLIMETERS. DIAMETER OF UNTHREADED PORTION SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.

REVISION
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NA0068
SHEET 2

