

FED. SUPPLY CLASS

5305

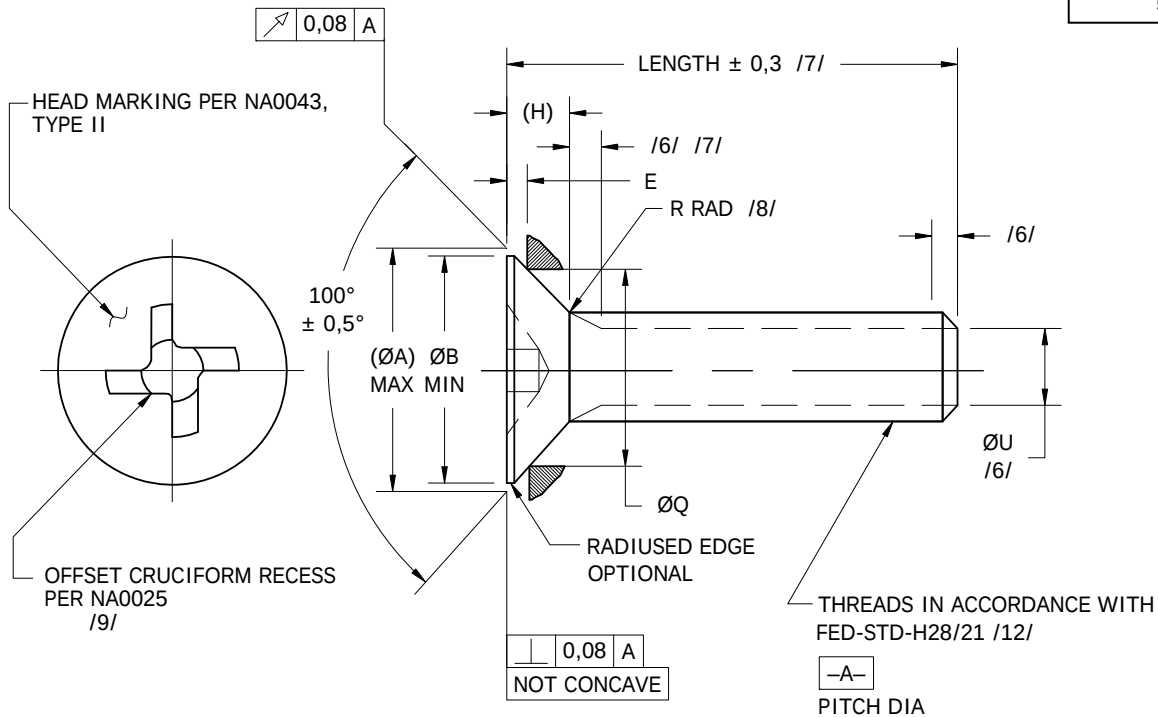


TABLE I – DIMENSIONS

DIA CODE	THREAD 4H6H	(ØA) MAX /10/	ØB MIN	E GAGE PROT /11/	(H) /10/	ØQ GAGE /11/	R RAD	ØU	OFFSET CRUCIFORM RECESS		TENSILE FORCE MIN N
									RECESS NO.	INSPECTION TORQUE N-M /9/	
016	MJ1,6 x 0,35	3,2	2,9	0,30 0,22	0,68	2,505 2,500	0,3 0,1	1,1 0,6	0	0,4	1 300
020	MJ2 x 0,4	4,0	3,6	0,34 0,26	0,85	3,205 3,200	0,3 0,1	1,4 0,9	1	0,9	2 090
025	MJ2,5 x 0,45	5,0	4,5	0,41 0,34	1,05	4,005 4,000	0,3 0,1	1,9 1,4	3	1,3	3 370
030	MJ3 x 0,5	6,0	5,4	0,51 0,43	1,27	4,805 4,800	0,4 0,2	2,3 1,8	4	1,8	4 930
040	MJ4 x 0,7	8,0	7,2	0,63 0,55	1,69	6,505 6,500	0,4 0,2	3,0 2,5	8	4,2	8 720
050	MJ5 x 0,8	10,0	9,0	0,72 0,64	2,12	8,305 8,300	0,5 0,3	3,9 3,4	10	5,6	13 900
060	MJ6 x 1	12,0	10,8	0,80 0,72	2,54	10,105 10,100	0,7 0,5	4,7 4,2	1/4	14	19 800
080	MJ8 x 1	16,0	14,8	0,93 0,85	3,39	13,805 13,800	0,7 0,5	6,7 6,2	5/16	28	37 300
100	MJ10 x 1,25	20,0	18,8	1,06 0,98	4,24	17,505 17,500	0,8 0,6	8,4 7,9	3/8	48	58 300

② COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NA0026 EXCEPT AS NOTED	TITLE SCREW, MACHINE, 100° FLUSH HEAD, OFFSET CRUCIFORM RECESS, FULL THREAD, A286 CRES, 1100 MPa, METRIC	CLASSIFICATION PART STANDARD
		NA0070 SHEET 1 OF 3



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MATERIAL:

A286 CRES PER PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

1100 MPA MINIMUM ULTIMATE TENSILE.

FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

CODE:

FIRST THREE NUMBERS DESIGNATE NOMINAL THREAD SIZE AS TABULATED.
SECOND THREE NUMBERS DESIGNATE NOMINAL LENGTH IN EVEN NUMBER INCREMENTS. SEE
TABLE II FOR RECOMMENDED LIMITS.

EXAMPLE OF PART NUMBER:

NA0070-025016 = SCREW; MJ2,5 x 0,45 THREAD; 16 mm LONG

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) 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 BREAK SHARP EDGES 0,1 TO 0,4.
- (4) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (5) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982M.
- /6/ INCOMPLETE THREADS IN ACCORDANCE WITH FED-STD-H28/21. POINT SHALL BE FLAT AND CHAMFERED TO 45° APPROXIMATELY FROM "ØU".
- /7/ SCREWS 40 MILLIMETERS OR LESS IN LENGTH SHALL HAVE COMPLETE THREADS TO WITHIN TWO THREAD PITCHES OF HEAD BEARING SURFACE. LONGER SCREWS SHALL HAVE A MINIMUM COMPLETE THREAD OF 35 MILLIMETERS. DIAMETER OF UNTHREADED PORTION OF SCREW SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.
- /8/ FILLET RADIUS TO BE COLD WORKED.

REVISION

2

(2) COMPLETELY REVISED



Documents

SHEET 2

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