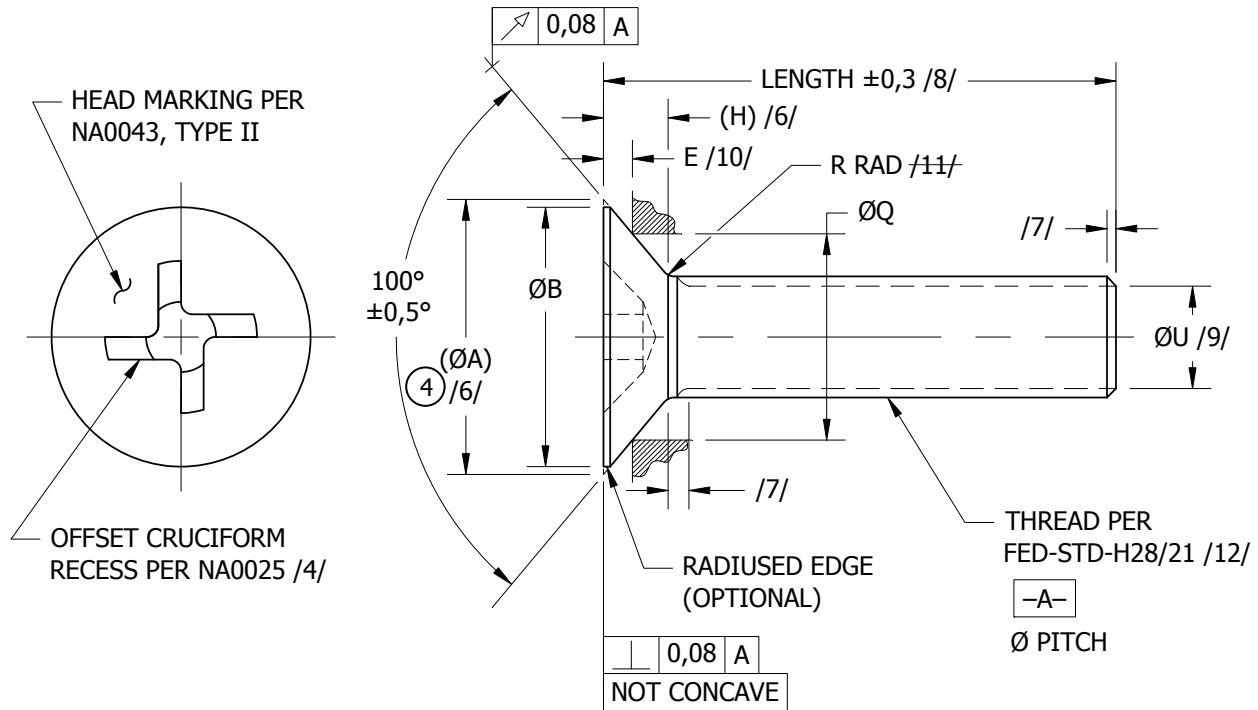


FED. SUPPLY CLASS

5305



4

TABLE I – DIMENSIONS

DIA CODE	THREAD 4h6h	(ØA) MAX /6/	ØB MIN	E GAGE PROT /10/	(H) /6/	ØQ GAGE	R RAD	ØU /9/	OFFSET CRUCIFORM RECESS	
									NO.	INSPECTION TORQUE N•m /4/
030	MJ3 × 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
040	MJ4 × 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
050	MJ5 × 0,8	10,0	9,0	0,72 0,64	2,12	8,305 8,300	0,5 0,3	4,0 3,5	10	5,6
060	MJ6 × 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
080	MJ8 × 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
100	MJ10 × 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

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

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, 100° FLUSH HEAD, OFFSET CRUCIFORM RECESS, FULL THREAD, ALLOY STEEL, 1100 MPa Ft_u, METRIC	CLASSIFICATION PART STANDARD



Documents
SHEET 1 OF 3

REVISION DATE: SEPTEMBER 19, 2014

ISSUE DATE: DECEMBER 1979

MATERIAL:

- ④ ALLOY STEEL – 4140 (UNS G41400) PER AMS6382, 4340 (UNS G43406) PER AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER AMS6322, AMS6325 OR AMS6327.

HEAT TREATMENT:

1100 MPa ULTIMATE TENSILE (36-40 HRC)

FINISH:

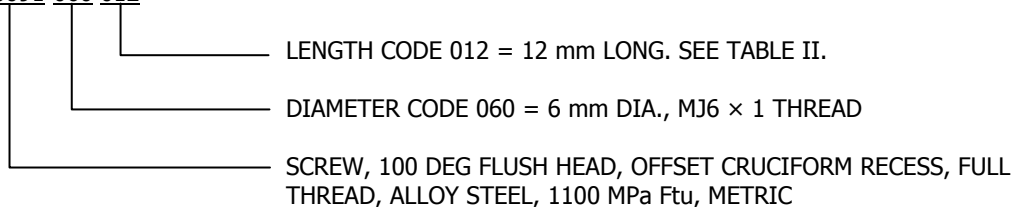
CADMIUM PLATING IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 2 (8-14 μ m THICK)

CODE:

BASIC DRAWING NUMBER, FOLLOWED BY A DASH AND THREE DIGITS TO INDICATE NOMINAL DIAMETER AS TABULATED, AND A SECOND THREE DIGITS TO DESIGNATE NOMINAL LENGTH. SEE TABLE II FOR LIMITS.

EXAMPLE OF PART NUMBER:

NA0091-060 012



NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET, AND ALL THREAD ELEMENTS 0,8 μ m MAX. ALL OTHER SURFACE 3,2 μ m MAX PER ASME B46.1.
- (2) SCREWS SHALL BE FREE FROM BURRS AND SLIVERS. BREAK SHARP EDGES 0,1 TO 0,4.
- (3) DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE SPECIFIED. DIMENSIONS TO BE MET AFTER PLATING.
- /4/ RECESS SHALL BE TORQUE TESTED IN BOTH INSTALLATION AND REMOVAL DIRECTION WITH THE APPROPRIATE DRIVER PER NA0025 AND 66 N MAX AXIAL FORCE. FASTENER FRACTURE OR METAL RAISED MORE THAN 0,15 OVER RECESS EDGE SHALL BE CAUSE FOR REJECTION. SAMPLE PER ASQ Z1.4, 4% AQL, LEVEL S-1.
- (5) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /6/ DIMENSIONS $\varnothing$ A AND H ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION. VALUES $\varnothing$ A AND H ARE CALCULATED LIMITS RESULTING FROM TOLERANCES ON $\varnothing$ B, E, $\varnothing$ Q, AND HEAD ANGLE.
- /7/ INCOMPLETE THREADS IN ACCORDANCE WITH FED-STD-H28/21.
- /8/ 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.

REVISION

4

Documents
SHEET 2



Document Sharing Hub

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