

FED. SUPPLY CLASS

5305

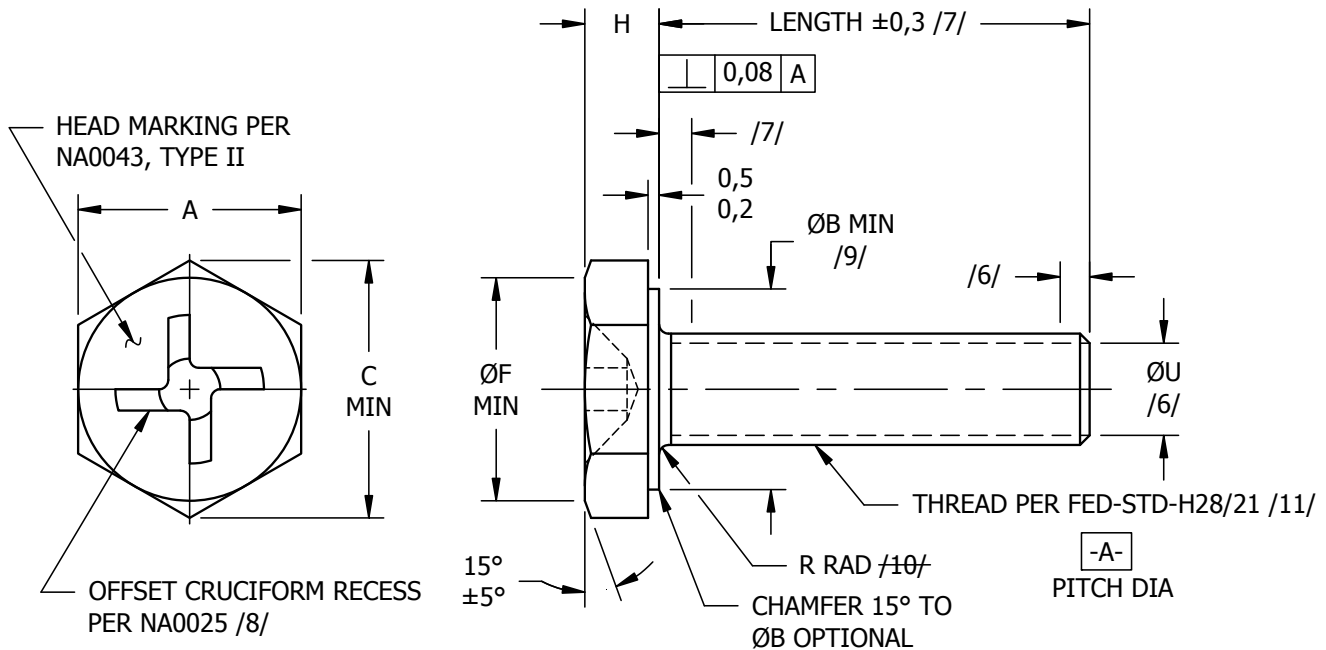


TABLE I – DIMENSIONS

DIA CODE /4/	THREAD 4h6h	A	ØB MIN	C MIN	ØF MIN	H	R RAD	ØU	OFFSET CRUCIFORM RECESS		TENSILE FORCE N MIN
									RECESS NO	INSPECTION TORQUE N·m /8/	
Ø30 A030	MJ3 X 0,5	6,00 5,88	5,4	6,5	5,5	2,0 1,7	0,4 0,2	2,3 1,8	4	1,8	~~6 160~~ 4 930
Ø40 A040	MJ4 X 0,7	7,00 6,85	6,4	7,6	6,5	2,5 2,2	0,4 0,2	3,0 2,5	8	4,2	~~10 900~~ 8 720
Ø50 A050	MJ5 X 0,8	8,00 7,85	7,4	8,7	7,5	3,0 2,7	0,5 0,3	3,9 3,4	10	5,6	~~17 400~~ 13 900
Ø60 A060	MJ6 X 1	10,00 9,78	9,3	10,9	9,4	3,5 3,2	0,7 0,5	4,7 4,2	1/4	14	~~24 800~~ 19 800

MATERIAL:

6AL-4V TITANIUM ALLOY (UNS R56400) PER AMS4928 OR AMS4967.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-81200 OR AMS2801:
1100 MPa MINIMUM ULTIMATE TENSILE.

FINISH:

NONE

⑥ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 6
PROCUREMENT SPECIFICATION NA0007 EXCEPT AS NOTED	TITLE SCREW, HEX HEAD, OFFSET CRUCIFORM RECESS, TITANIUM, FULL THREAD, 1100 MPa, METRIC	CLASSIFICATION PART STANDARD
		NA0113 SHEET 1 OF 3

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:

NA0113-030016 — SCREW: MJ3 X 0,5: 16 mm LONG
NA0113A030016 = SCREW: MJ3 X 0,5: 16 mm LONG

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET RADIUS 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 SHARP EDGES 0,1 TO 0,4.
- (3) DIMENSIONS IN MILLIMETERS.
- /4/ NON "A" PREFIXED DIAMETER CODES CANCELED AFTER APRIL 15, 1993. NO SUPERSEDING STANDARD. FOR DESCRIPTION OF STATUS NOTES SEE NAS10000.
- (5) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /6/ ~~INCOMPLETE THREADS IN ACCORDING WITH FED-STD-H28/21, GAUGING PER SYSTEM 22. POINT SHALL BE FLAT AND CHAMFERED TO 45° APPROXIMATELY FROM "ØU".~~
- /7/ FOR SCREWS 35 mm IN LENGTH OR LESS, THREAD TO HEAD. LONGER SCREWS SHALL HAVE A MINIMUM THREAD LENGTH OF 35 mm. DIAMETER OF UNTHREADED PORTION SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREADS.
- /8/ RECESS SHALL BE TORQUE TESTED IN BOTH INSTALLATION AND REMOVAL DIRECTIONS WITH APPLICABLE DRIVER WITH AXIAL END PRESSURE NOT EXCEEDING 66N. SCREWS ARE REJECTABLE IF MINIMUM TORQUE VALUES SPECIFIED CAUSE FRACTURE OF FASTENER OR DISTORTION WHICH RESULTS IN RAISE OF METAL AT EDGE OF RECESS EXCEEDING 0,15 ABOVE SURROUNDING AREA. SAMPLING SHALL BE PER ASQ Z1.4, 4% AQL, LEVEL S-1.
- /9/ "ØB" SHALL NOT EXCEED ACTUAL WIDTH ACROSS HEX FLATS; MINIMUM AS TABULATED.
- /10/ ~~FILLET RADIUS TO BE COLD WORKED.~~
- /11/ ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22.
- /12/ CODE NUMBERS REPRESENT LENGTH IN WHOLE MILLIMETERS. SPECIFY LENGTHS IN 2 mm INCREMENTS.
- (13) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (14) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (15) 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.

⑥ COMPLETELY REVISED

REVISION

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Documents
SHEET 2



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