

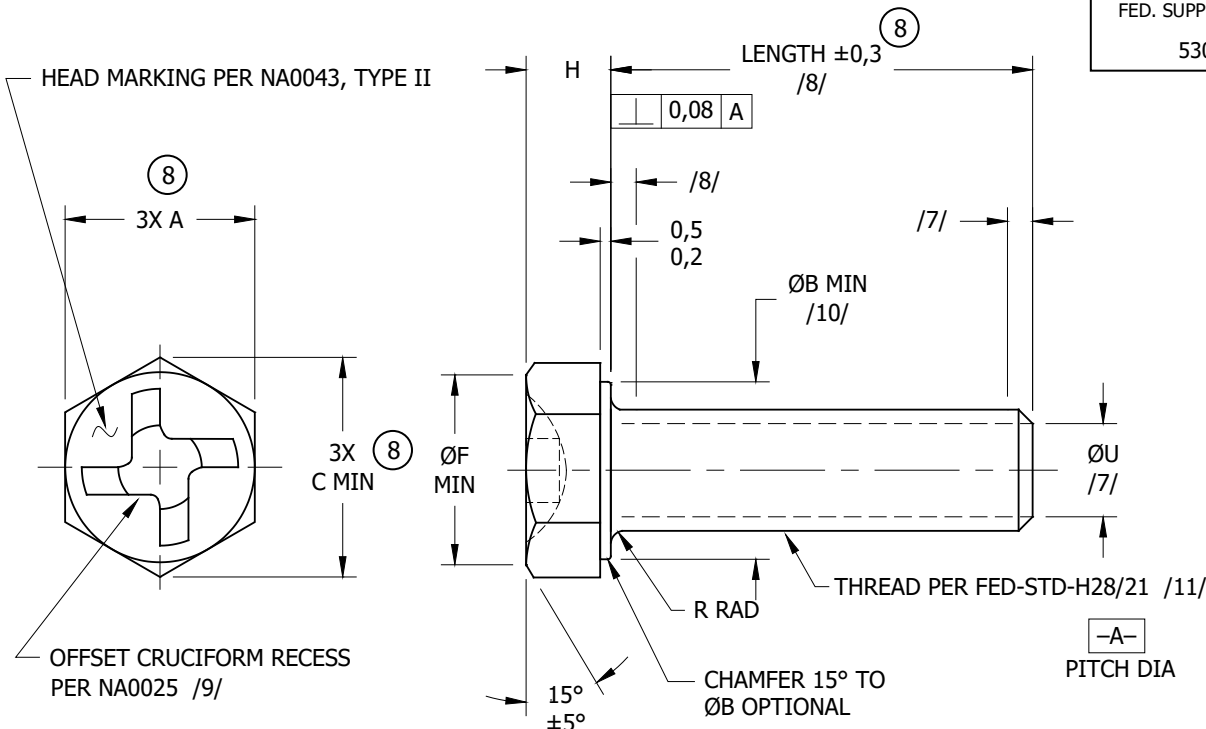


TABLE I - DIMENSIONS

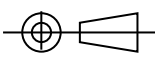
| DIA<br>CODE<br>/4/ | THREAD<br>4h6h | A             | ØB<br>MIN | C<br>MIN | ØF<br>MIN | H          | R<br>RAD   | ØU         | OFFSET CRUCIFORM<br>RECESS |                                | TENSILE<br>FORCE<br>N<br>MIN |
|--------------------|----------------|---------------|-----------|----------|-----------|------------|------------|------------|----------------------------|--------------------------------|------------------------------|
|                    |                |               |           |          |           |            |            |            | RECESS<br>NO.              | INSPECTION<br>TORQUE Nm<br>/9/ |                              |
| A030               | MJ3 x 0,5      | 6,00<br>5,88  | 5,4       | 6,5      | 5,5       | 2,0<br>1,7 | 0,4<br>0,2 | 2,3<br>1,8 | 4                          | 1,8                            | 4 930                        |
| A040               | MJ4 x 0,7      | 7,00<br>6,85  | 6,4       | 7,6      | 6,5       | 2,5<br>2,2 | 0,4<br>0,2 | 3,0<br>2,5 | 8                          | 4,2                            | 8 720                        |
| A050               | MJ5 x 0,8      | 8,00<br>7,85  | 7,4       | 8,7      | 7,5       | 3,0<br>2,7 | 0,5<br>0,3 | 3,9<br>3,4 | 10                         | 5,6                            | 13 900                       |
| A060               | MJ6 x 1        | 10,00<br>9,78 | 9,3       | 10,9     | 9,4       | 3,5<br>3,2 | 0,7<br>0,5 | 4,7<br>4,2 | 1/4                        | 14                             | 19 800                       |

MATERIAL:

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:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759:  
1100 MPa MINIMUM ULTIMATE TENSILE STRENGTH (36-40 HRC).

|                                                                                                                     |                                                                                                   |  |                                                                  |
|---------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------|
| THIRD<br>ANGLE<br>PROJECTION<br> | CUSTODIAN<br>NATIONAL AEROSPACE STANDARDS COMMITTEE                                               |  | REVISION<br><b>8</b>                                             |
|                                                                                                                     | TITLE<br><b>SCREW, HEX HEAD, OFFSET CRUCIFORM, ALLOY<br/>STEEL, FULL THREAD, 1100 MPa, METRIC</b> |  | CLASSIFICATION<br>PART STANDARD<br><b>NA0114</b><br>SHEET 1 OF 3 |
| PROCUREMENT<br>SPECIFICATION<br><br>NOTED                                                                           |                                                                                                   |  | Document Sharing Hub                                             |

FINISH:

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

CODE:

(8) NA0114 A030 016  
 BASIC NUMBER ——— NOMINAL LENGTH IN EVEN NUMBER  
 DIA CODE (TABLE I) /4/ ——— INCREMENTS. SEE TABLE II FOR  
 RECOMMENDED LIMITS.

EXAMPLE OF PART NUMBER:

(8) NA0114A030016 = SCREW, HEX HEAD, OFFSET CRUCIFORM, ALLOY STEEL, FULL THREAD, 1100 MPa, MJ3 x 0,5, 16 mm LONG, CADMIUM PLATED.

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 AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /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/ CODE NUMBERS REPRESENT LENGTH IN WHOLE MILLIMETERS. SPECIFY LENGTHS IN 2 mm INCREMENTS.
- /7/ POINT SHALL BE FLAT AND CHAMFERED TO 45° APPROXIMATELY FROM "ØU".
- /8/ 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.
- /9/ 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.
- /10/ WASHER FACE DIAMETER SHALL NOT EXCEED ACTUAL WIDTH ACROSS HEX FLATS; MINIMUM AS TABULATED.
- /11/ ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22.
- (12) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

REVISION

8

NA0114  
SHEET 2



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