

FED. SUPPLY CLASS

5305

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 12-02

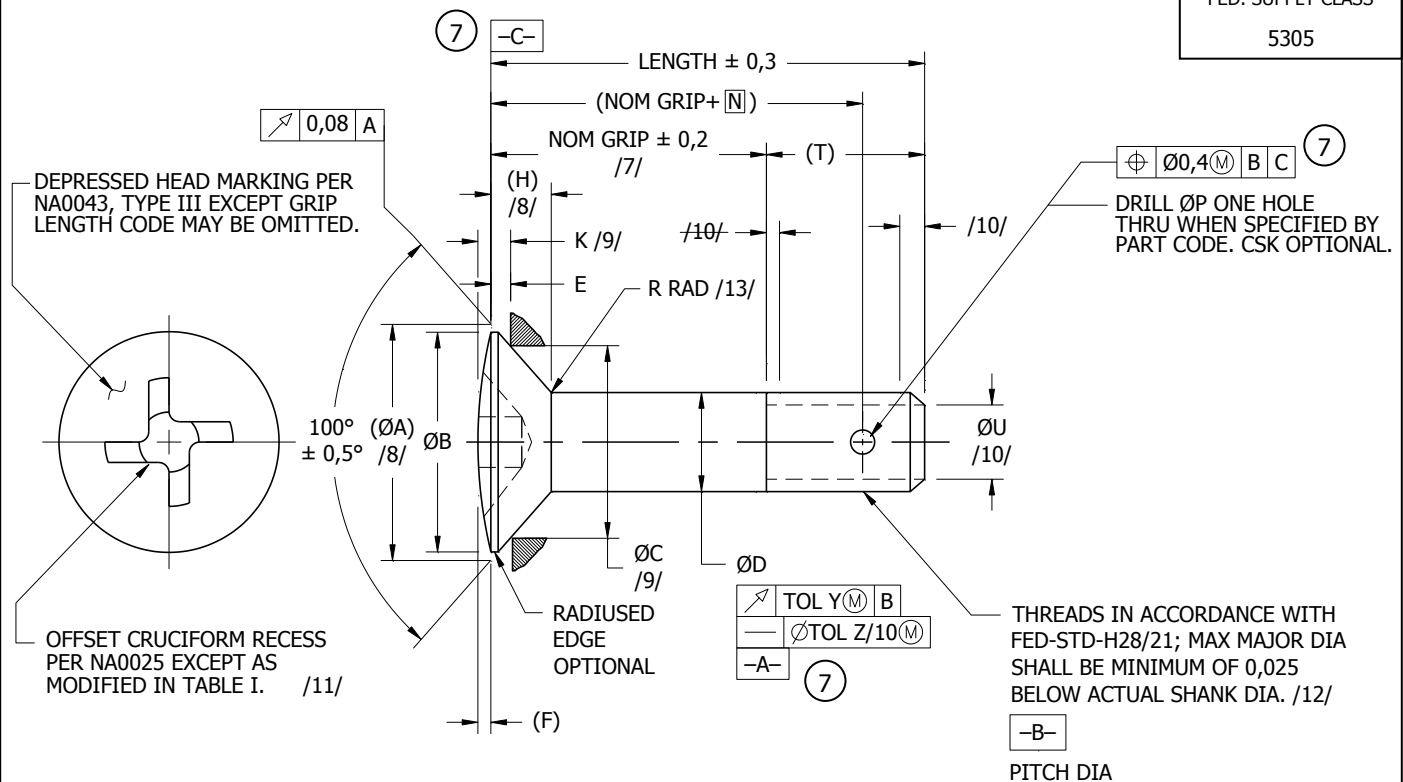


TABLE I – DIMENSIONS

DIA CODE /4/	THREAD 4h6h	(ØA) /8/	ØB MIN	ØC GAGE /9/	ØD	E GAGE PROT /9/	(F)	(H) /8/	K ±0,04 /9/	N BASIC	ØP	R RAD	(T)	ØU	Y	Z
~~050~~ A050	MJ5 x 0,8	7,80	6,80	5,785 5,780	4,990 4,978	0,85 0,77	0,16	1,19	1,01	6,0	1,64 1,50	0,5 0,3	9,0	4,0 3,5	0,12	0,02
~~060~~ A060	MJ6 x 1	9,36	8,16	7,713 7,708	5,990 5,978	0,70 0,62	0,17	1,42	0,87	7,0	1,64 1,50	0,7 0,5	10,0	4,7 4,2	0,12	0,02
~~080~~ A080	MJ8 X 1	12,48	11,28	10,285 10,280	7,987 7,972	0,93 0,85	0,18	1,90	1,11	7,5	2,04 1,90	0,7 0,5	11,5	6,7 6,2	0,15	0,02
~~100~~ A100	MJ10 x 1,25	15,60	14,40	12,856 12,851	9,987 9,972	1,16 1,08	0,20	2,37	1,36	9,0	2,54 2,40	0,8 0,6	14,5	8,4 7,9	0,15	0,015
~~120~~ A120	MJ12 x 1,25	18,72	17,52	15,427 15,422	11,984 11,966	1,39 1,31	0,22	2,84	1,61	10,0	2,54 2,40	0,9 0,6	16,0	10,4 9,9	0,18	0,015

REVISION DATE: OCTOBER 31, 2016

ISSUE DATE: JULY 1980

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 7
PROCUREMENT SPECIFICATION	TITLE SCREW, CLOSE TOLERANCE, 100° REDUCED CROWN HEAD, OFFSET CRUCIFORM RECESS, A286 CRES, 660 MPa SHEAR, METRIC	CLASSIFICATION PART STANDARD
NOTED		NA0124 SHEET 1 OF 5

TABLE I – DIMENSIONS (CONTINUED)

DIA CODE /4/	OFFSET CRUCIFORM RECESS DIMENSIONS					INSPECTION TORQUE Nm /11/	MINIMUM TENSILE FORCE N /5/	FATIGUE TEST TENSILE FORCE N	
	RECESS NO.	RECESS DEPTH	WING DIA	GAGE PENETRATION				HIGH	LOW
				MIN	MAX				
050 A050	8	2,13 1,88	5,61 5,36	1,308	1,613	3,4	9 000 7 600	2 850	285
060 A060	10	2,46 2,21	6,50 6,25	1,549	1,867	5,6	13 000 11 300	4 240	424
080 A080	1/4	3,18 2,92	8,51 8,26	2,045	2,413	11	22 200 19 100	7 160	716
100 A100	5/16	3,30 3,05	9,37 9,12	1,930	2,350	23	32 000 30 200	11 320	1 132
120 A120	3/8	3,91 3,66	11,15 10,90	2,311	2,781	34	45 000 44 900	16 840	1 684

MATERIAL:

A286 CRES PER PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

- ⑦ DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROL PER AMS2759:
660 MPa MINIMUM ULTIMATE SHEAR.

FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

CODE:

FIRST THREE NUMBERS INDICATE NOMINAL SHANK DIAMETER IN MILLIMETERS AND TENTHS AS TABULATED.

SECOND THREE NUMBERS DESIGNATE NOMINAL GRIP LENGTH IN MILLIMETERS AS TABULATED.
CODE LETTER "D" FOLLOWING BASIC PART NUMBER INDICATES DRILLED THREAD. /6/

EXAMPLES OF PART NUMBER:

NA0124 080016 = SCREW; MJ8 X 1 THREAD; 16 mm GRIP
NA0124A080016 = SCREW; MJ8 X 1 THREAD; 16 mm GRIP
~~NA0124D080016 = SCREW; MJ8 X 1 THREAD; 16 mm GRIP; DRILLED THREAD~~
NA0124DA080016 = SCREW; MJ8 X 1 THREAD; 16 mm GRIP; DRILLED THREAD
~~NA0124 090016 = SCREW; MJ8 X 1 THREAD; 16 mm GRIP; 1 mm OVERSIZE SHANK~~
NA0124A090016 = SCREW; MJ8 X 1 THREAD; 16 mm GRIP; 1 mm OVERSIZE SHANK

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET 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 = 16 kA/m USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, TEST METHOD 3. (1 Oe = 1000/4 π A/m)
- (3) REMOVE ALL BURRS AND BREAK SHARP EDGES 0,1 TO 0,4.

REVISION

7

NA0124
SHEET 2



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