

FED. SUPPLY CLASS

5325

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

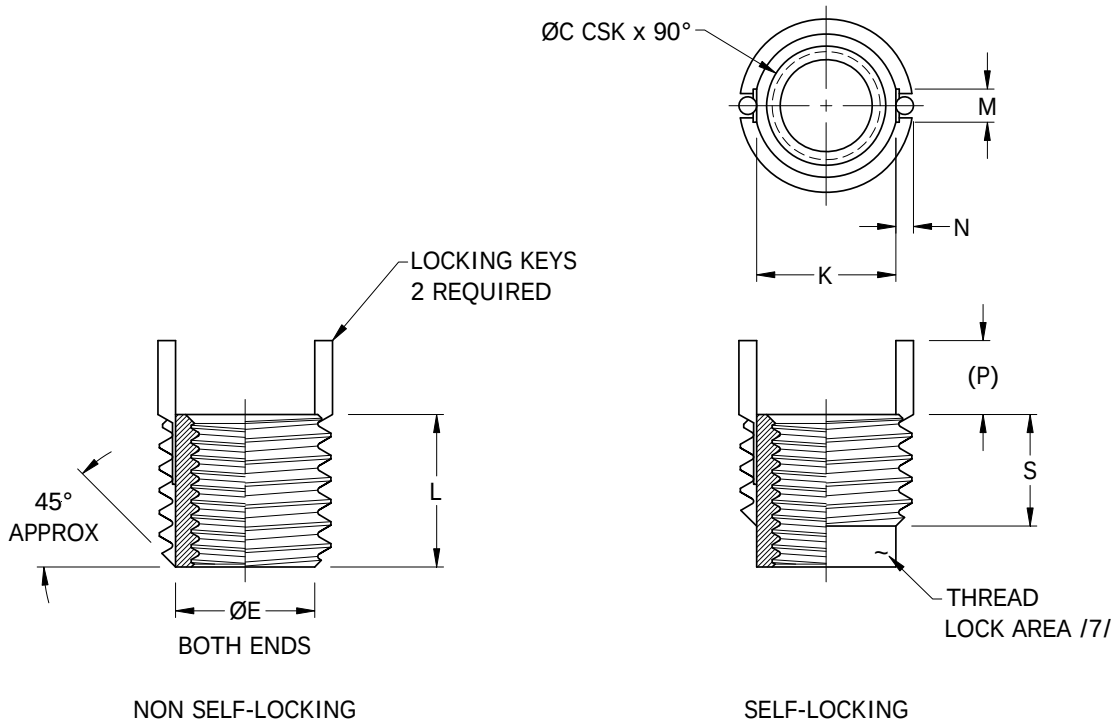


TABLE I – DIMENSIONS

DASH NO.	INTERNAL THREAD /5/	EXTERNAL THREAD /6/	MIN. SHEAR ENGAGEMENT AREA mm ² REF. /8/	ØC ±0,125	S	ØE	K	L	KEY DIMENSIONS		
									M	N ±0,10	(P)
016	MJ1,6 x 0,35 - 4H6H	M3,5 x 0,35 - 4h	8,64	1,830	N/A	2,87	2,59 2,44	2,54	0,58	0,30	1,52
020	MJ2 x 0,4 - 4H6H	M4 x 0,7 - 4h	11,67	2,130	N/A	2,99	2,67 2,51	3,00	0,89	0,56	1,52
025	MJ2,5 x 0,45 - 4H6H	M4,5 x 0,75 - 4h	20,10	2,610	N/A	3,43	3,15 3,00	3,81	0,89	0,56	1,52
030	MJ3 x 0,5 - 4H6H	M5 x 0,8 - 4h	26,50 15,30	3,170	3,10	3,88	3,68 3,53	4,25	0,89	0,56	2,03
035	MJ3,5 x 0,6 - 4H6H	M6 x 0,75 - 4h	34,10 21,00	3,625	3,15	5,08	4,80 4,65	4,30	1,14	0,61	2,54
040	MJ4 x 0,7 - 4H6H	M6 x 0,75 - 4h	45,30 32,10	4,110	4,11	5,08	4,80 4,65	5,25	1,14	0,61	2,54

② COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NONE	TITLE INSERT, SCREW THREAD, KEY LOCKED, ALLOY STEEL, MINIATURE, METRIC	CLASSIFICATION PART STANDARD
		DA00146 SHEET 1 OF 3

MATERIAL:

INSERT - ALLOY STEEL 4130 (UNS G41300) PER MIL-S-6758 AMS-S-6758, 4140 (UNS G41400) PER MIL-S-5626 AMS6382 OR AMS6349, OR 8740 (UNS G87400) PER AMS6322.
LOCKING KEYS - CRES 302 (UNS S30200) PER ASTM A580/A580M, CHEMISTRY ONLY.

HEAT TREAT:

INSERTS SHALL BE HEAT TREATED TO 1100-1250 MPa IN ACCORDANCE WITH AMS2759.

FINISH:

INSERT - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
LOCKING KEYS - PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

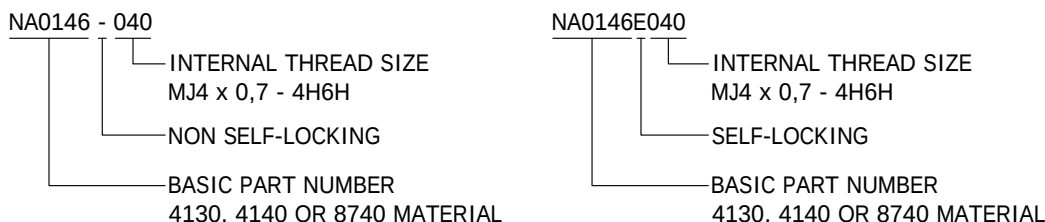
LUBRICANT:

SOLID FILM LUBRICANT PER AS5272, TYPE I. (SELF-LOCKING INSERTS ONLY)

CODE:

"-" DESIGNATES NON SELF-LOCKING INSERTS.
"E" DESIGNATES SELF-LOCKING INSERTS.

EXAMPLE OF PART NUMBER:



NOTES:

- (1) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (2) TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm 0,25$; ANGLES $\pm 2^\circ$.
- (3) SURFACE ROUGHNESS: 3,2 μm Ra PER ASME B46.1.
- (4) REMOVE ALL BURRS AND BREAK SHARP EDGES 0,08 – 0,38 UNLESS OTHERWISE SPECIFIED.
- /5/ INTERNAL THREADS IN ACCORDANCE WITH FED-STD-H28/21 MJ FORM BEFORE THREAD LOCK AND LUBRICATION AND AFTER PLATING.
- /6/ EXTERNAL THREADS IN ACCORDANCE WITH FED-STD-H28/21 AND BS 3643 M FORM.
- /7/ LOCKING TORQUE SHALL BE IN ACCORDANCE WITH NA0009 (CLASS 1 NUTS).
DASH 016, 020 AND 025 ARE NOT AVAILABLE WITH SELF-LOCK.

② COMPLETELY REVISED

REVISION

2

NA0146
SHEET 2



Document Sharing Hub