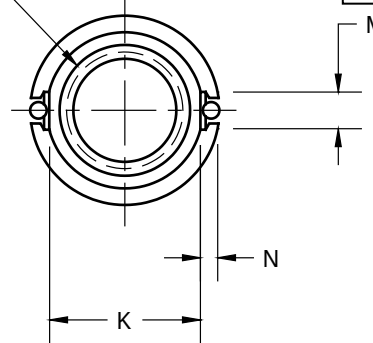


FED. SUPPLY CLASS

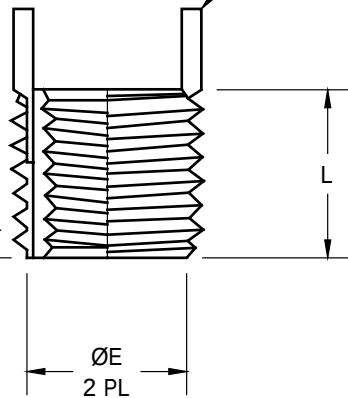
5340

ØC CSK x 90°

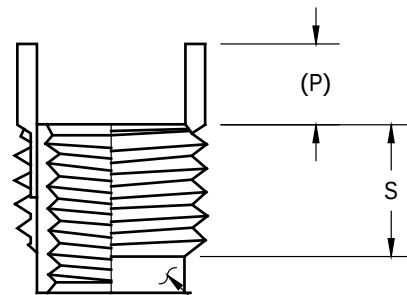


LOCKING KEYS
2 REQUIRED

45°
APPROX



NON SELF-LOCKING



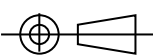
THREAD
LOCK AREA /7/

SELF-LOCKING

TABLE I – DIMENSIONS

DASH NO.	INTERNAL THREAD /5/	EXTERNAL THREAD /6/	(MIN. SHEAR ENGAGEMENT AREA) mm ² /9/	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

THIRD
ANGLE
PROJECTION



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

3

PROCUREMENT
SPECIFICATION

NONE

TITLE

**INSERT, SCREW THREAD, KEY LOCKED,
A286 CRES, MINIATURE, METRIC**

CLASSIFICATION
PART STANDARD

DA00147

SHEET 1 OF 3

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MATERIAL:

INSERT – CRES A286 (UNS S66286) PER AMS5734 OR AMS5737.
LOCKING KEYS – CRES 302 (UNS S30200) PER ASTM A580/A580M, CHEMISTRY ONLY.

HEAT TREATMENT:

- ③ INSERTS MADE FROM AMS5734 SHALL BE HEAT TREATED TO 965 MPa MINIMUM PER AMS2759.

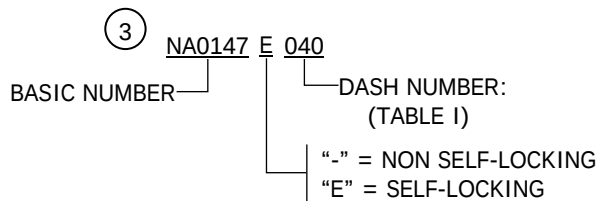
FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

LUBRICATION:

- ③ FOR SELF-LOCKING INSERTS ONLY, SOLID FILM LUBRICANT PER AS5272, TYPE I OR TYPE III.
LOCKING KEYS MAY OR MAY NOT BE LUBRICATED.

CODE:



EXAMPLE OF PART NUMBER:

- ③ NA0147-040 = INSERT, A286 CRES, PASSIVATED, NO LUBRICATION, INTERNAL THREAD SIZE MJ4 x 0,7 – 4H6H, NON SELF-LOCKING.
- NA0147E040 = INSERT, A286 CRES, PASSIVATED, LUBRICATED, INTERNAL THREAD SIZE MJ4 x 0,7 – 4H6H, SELF-LOCKING.

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 MICROMETERS Ra PER ASME B46.1.
- (4) REMOVE ALL BURRS AND BREAK SHARP EDGES 0,08 – 0,38.
- ③ /5/ INTERNAL THREADS IN ACCORDANCE WITH FED-STD-H28/21 MJ FORM BEFORE THREAD LOCK AND LUBRICATION.
- ③ /6/ EXTERNAL THREADS IN ACCORDANCE WITH FED-STD-H28/21 AND BS 3643-1.

REVISION

3

Documents

SHEET 2



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