

FED. SUPPLY CLASS

5340

ØC BORE x D DEEP

MATERIAL  
IDENTIFICATION  
/8/

1,85  
1,75

1,12  
0,92

K

LOCKING KEYS

L

45°  
APPROX

(P)

T

THREAD  
LOCK  
/6/

ØE  
BOTH ENDS

NON SELF-LOCKING

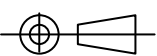
SELF-LOCKING

TABLE I – DIMENSIONS

| DASH NO. | INTERNAL THREAD /4/ | EXTERNAL THREAD /5/ | (MIN. SHEAR ENGAGEMENT AREA) mm <sup>2</sup> /9/ | ØC ±0,13 | D    | ØE    | K              | L     | KEY DIMENSIONS |      | T ±0,76 |
|----------|---------------------|---------------------|--------------------------------------------------|----------|------|-------|----------------|-------|----------------|------|---------|
|          |                     |                     |                                                  |          |      |       |                |       | QTY.           | (P)  |         |
| 050      | MJ5 x 0,8 - 4H6H    | M8 x 1,25 - 4h      | 96,7<br>71,8                                     | 5,15     | 1,27 | 6,25  | 5,69<br>5,51   | 8,00  | 2              | 3,96 | 3,73    |
| 060      | MJ6 x 1 - 4H5H      | M10 x 1,25 - 4h     | 164,2<br>132,8                                   | 6,23     | 1,78 | 8,21  | 7,70<br>7,52   | 10,00 | 2              | 4,75 | 6,02    |
| 070      | MJ7 x 1 - 4H5H      | M11 x 1 - 4h        | 186,5<br>155,7                                   | 7,23     | 1,78 | 9,50  | 8,69<br>8,48   | 11,00 | 4              | 4,75 | 6,02    |
| 080      | MJ8 x 1 - 4H5H      | M12 x 1,25 - 4h     | 221,1<br>186,7                                   | 8,23     | 1,78 | 10,15 | 9,55<br>9,35   | 12,00 | 4              | 4,75 | 6,28    |
| 100      | MJ10 x 1,25 - 4H5H  | M14 x 1,5 - 4h      | 288,0<br>245,8                                   | 10,25    | 2,29 | 11,81 | 11,71<br>11,51 | 14,00 | 4              | 4,75 | 6,46    |
| 120      | MJ12 x 1,25 - 4H5H  | M16 x 1,5 - 4h      | 435,4<br>386,1                                   | 12,25    | 2,29 | 13,81 | 13,72<br>13,51 | 16,00 | 4              | 4,75 | 6,46    |

② COMPLETELY REVISED

THIRD  
ANGLE  
PROJECTION



CUSTODIAN  
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION  
**2**

PROCUREMENT  
SPECIFICATION

NONE

TITLE  
**INSERT, SCREW THREAD KEY LOCKED,  
A286 CRES,  
LIGHTWEIGHT, METRIC**

②

CLASSIFICATION  
PART STANDARD

**DA0149**  
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 A 580/A 580M, CHEMISTRY ONLY.

**HEAT TREATMENT:**

INSERTS (MADE FROM AMS5734) SHALL BE HEAT TREATED TO 965 MPa MINIMUM WITH CONTROLS PER AMS2759.

**FINISH:**

PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

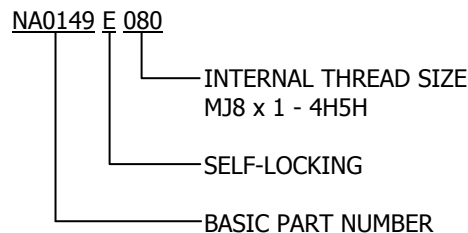
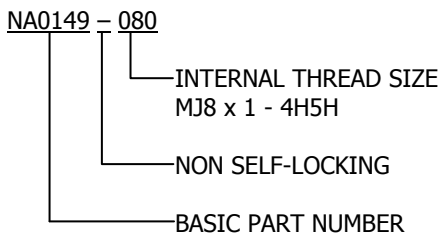
**LUBRICANT:**

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

**CODE:**

SUFFIX AFTER DASH NUMBER INDICATES SELF-LOCKING INSERTS.  
"–" DESIGNATES NON SELF-LOCKING INSERTS.  
"E" DESIGNATES SELF-LOCKING INSERTS.

**EXAMPLES OF PART NUMBER:**



**NOTES:**

- (1) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (2) SURFACE ROUGHNESS: 3,2 MICROMETERS Ra PER ASME B46.1.
- (3) REMOVE ALL BURRS AND BREAK ALL SHARP EDGES 0,08 - 0,38 mm UNLESS OTHERWISE SPECIFIED.
- /4/ INTERNAL THREADS IN ACCORDANCE WITH FED-STD-H28/21 MJ FORM BEFORE THREAD LOCK AND LUBRICATION.
- /5/ EXTERNAL THREADS IN ACCORDANCE WITH FED-STD-H28/21 AND BS 3643. (ISO) M FORM.
- /6/ LOCKING TORQUE SHALL BE IN ACCORDANCE WITH NA0009 (CLASS 1 NUTS).

② COMPLETELY REVISED

|          |
|----------|
| REVISION |
| 2        |
| NA0149   |
| SHEET 2  |



Documents  
SHEET 2

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