

FED. SUPPLY CLASS

5340

ØC BORE x D DEEP

MATERIAL
IDENTIFICATION
/8/

LOCKING KEYS

45°
APPROX

THREAD
LOCK
/6/

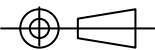
NON SELF-LOCKING

SELF-LOCKING

TABLE I – DIMENSIONS

DASH NO.	INTERNAL THREAD /4/	EXTERNAL THREAD /5/	(MIN. SHEAR ENGAGEMENT AREA) mm ² /9/	ØC ±0,13	D	ØE	K	L ±0,25	KEY DIMENSIONS				T ±0,76
									M ±0,05	N ±0,10	QTY	(P)	
040	MJ4 x 0,7-4H6H	M8 x 1,25-4h	96,7 71,8	4,15	1,27	6,25	5,69 5,51	8,0	1,80	1,02	2	3,96	5,00
050	MJ5 x 0,8-4H6H	M10 x 1,25-4h	164,2 132,8	5,15	1,27	8,21	7,70 7,52	10,0	1,80	1,02	2	4,75	5,50
060	MJ6 x 1-4H5H	M12 x 1,25-4h	221,2 186,7	6,23	1,78	10,15	9,55 9,35	12,0	1,80	1,02	2	4,75	6,46
070	MJ7 x 1-4H5H	M12 x 1-4h	218,6 184,7	7,23	1,78	10,23	9,70 9,50	12,0	1,80	1,02	4	4,75	6,46
080	MJ8 x 1-4H5H	M14 x 1,5-4h	288,0 245,8	8,23	1,78	11,81	11,71 11,51	14,0	1,80	1,02	4	4,75	6,46
100	MJ10 x 1,25-4H5H	M16 x 1,5-4h	435,4 386,1	10,25	2,29	13,81	13,72 13,51	16,0	1,80	1,02	4	4,75	6,46
120	MJ12 x 1,25-4H5H	M18 x 1,5-4h	571,9 515,5	12,25	2,29	15,82	15,67 15,47	18,0	1,80	1,02	4	4,75	7,23
140	MJ14 x 1,5-4H5H	M20 x 1,5-4h	728,0 627,4	14,27	2,79	17,83	17,70 17,50	20,0	1,80	1,02	4	4,75	7,73
160	MJ16 x 1,5-4H5H	M22 x 1,5-4h	846,0 741,2	16,29	2,79	19,83	18,14 17,93	22,0	2,69	1,78	4	6,35	8,50
180	MJ18 x 1,5-4H5H	M24 x 2-4h	960,7 849,6	18,26	2,79	21,05	20,24 20,04	24,0	2,69	1,78	4	6,35	9,25
200	MJ20 x 1,5-4H5H	M30 x 2-4h	1696,1 1543,1	20,24	2,79	27,17	26,15 25,93	30,0	2,69	1,78	4	6,35	12,51
220	MJ22 x 1,5-4H5H	M32 x 2-4h	1962,3 1798,0	22,23	2,79	29,16	28,17 27,91	32,0	2,69	1,78	4	6,35	12,51
240	MJ24 x 2-4H5H	M33 x 2-4h	2100,3 1930,7	24,23	3,81	30,17	29,15 28,90	33,0	2,69	1,78	4	6,35	13,97

THIRD
ANGLE
PROJECTION



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

4

PROCUREMENT
SPECIFICATION

TITLE

**INSERT, SCREW THREAD, KEY LOCKED,
A286 CRES, HEAVY DUTY, METRIC**

CLASSIFICATION
PART STANDARD

NONE

Documents
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:

INSERTS (MADE FROM AMS5734) SHALL BE HEAT TREATED TO 965 MPa MINIMUM.

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:

NA0151 - 080
INTERNAL THREAD SIZE
MJ8 x 1 - 4H5H
NON SELF-LOCKING
BASIC PART NUMBER
CRES A286 MATERIAL

NA0151 E 080
INTERNAL THREAD SIZE
MJ8 x 1 - 4H5H
SELF-LOCKING
BASIC PART NUMBER
CRES A286 MATERIAL

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 SHARP EDGES 0,08 – 0,38.
- /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).
- (7) 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.
- /8/ IDENTIFYING DASH MARKS ARE PLACED APPROXIMATELY MIDWAY BETWEEN KEYS ON TOP OF INSERT, 0,38 MAX. DEPTH.

REVISION

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NA0151
SHEET 2



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