

FED. SUPPLY CLASS

5305

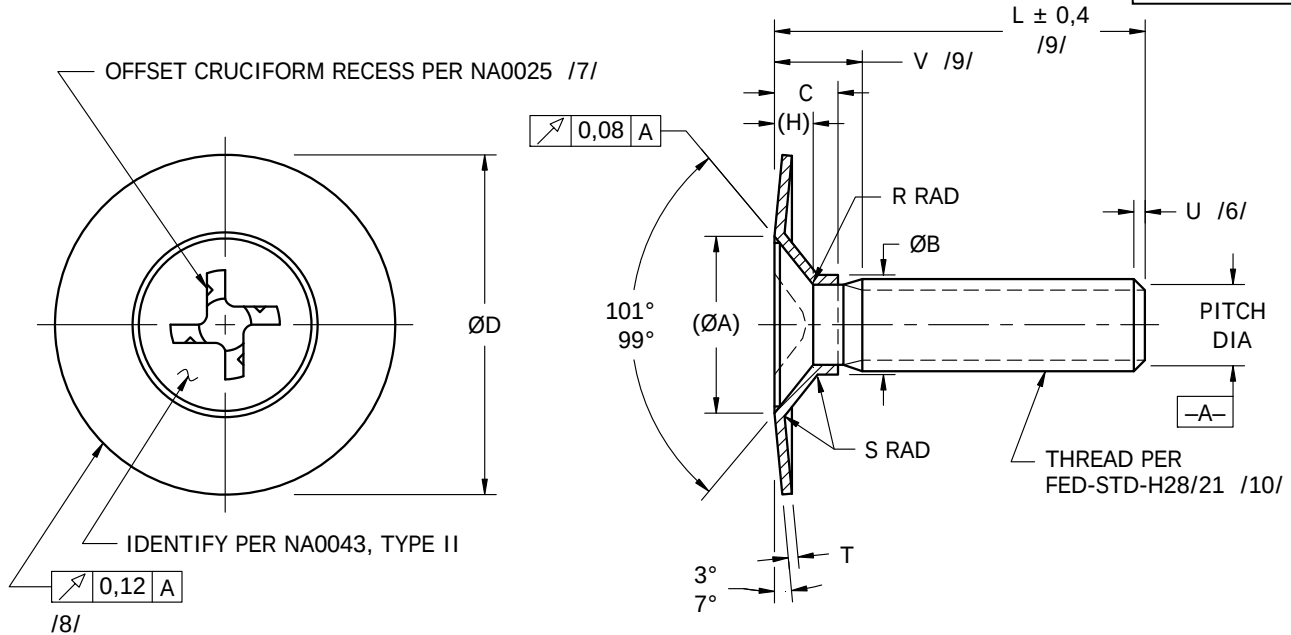


TABLE I – DIMENSIONS

DIA CODE	THREAD 4h6h	(ØA) MAX	ØB MAX	C MAX	ØD	(H)	R RAD MIN	S RAD	T	U MAX	V MAX /9/	OFFSET CRUCIFORM RECESS	
												RECESS NO.	INSPECTION TORQUE-MIN Nm /7/
040	MJ4 x 0,7	8	4,6	2,9	15,0 14,5	1,87	0,2	0,5 0,2	0,45 0,35	0,88	4,8	8	4,2
050	MJ5 x 0,8	10	5,7	3,6	19,0 18,5	2,32	0,3	0,6 0,2	0,56 0,44	1,00	5,7	10	5,6
060	MJ6 x 1	12	6,8	4,3	23,0 22,5	2,79	0,4	0,7 0,2	0,68 0,52	1,25	6,8	1/4	14

MATERIAL:

SCREW: TITANIUM – 6Al-4V (UNS R56400) ALLOY PER PROCUREMENT SPECIFICATION.
WASHER: TITANIUM – COMMERCIALLY PURE (UNS R50700) PER MIL-T-9046, CP-1 AMS4901.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-81200 OR AMS2801.
SCREW: 1100 MPa MINIMUM ULTIMATE TENSILE.
WASHER: NONE.

FINISH:

NONE OR ALUMINUM COAT PER NAS4006, EXCEPT FAYING SURFACE BETWEEN SCREW AND WASHER
MAY BE BARE.

③ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 3
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, FAIRING WASHER, ASSEMBLY, 6Al-4V TITANIUM ALLOY, OFFSET CRUCIFORM RECESS, FULL THREAD, 1100 MPa TENSILE, METRIC	CLASSIFICATION PART STANDARD
		DA0160 SHEET 1 OF 3

CODE:

FIRST THREE NUMBERS INDICATE THREAD SIZE IN MILLIMETERS AND TENTHS AS TABULATED.
SECOND THREE NUMBERS INDICATE LENGTH L IN MILLIMETERS.
CODE LETTER "A" IN LIEU OF DASH INDICATES ALUMINUM COAT.

EXAMPLES OF PART NUMBER:

NA0160-050016 = SCREW, MJ5 x 0,8 THREAD, 16 mm LENGTH, NO FINISH.
NA0160A050016 = SCREW, MJ5 x 0,8 THREAD, 16 mm LENGTH, ALUMINUM COATED.

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF SCREW HEAD, HEAD TO SHANK FILLET RADIUS, THREAD ROOT AND THREAD FLANKS, WASHER SURFACES (EXCEPT EDGES): 0,8 MICROMETERS Ra; ALL OTHER SURFACES: 3,2 MICROMETERS Ra PER ASME B46.1.
- (2) REMOVE ALL BURRS AND BREAK SHARP EDGES 0,1 TO 0,4.
- (3) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (4) WASHER SHALL ROTATE FREELY ON SCREW AND SHALL FLOAT AXIALLY 0,1 MINIMUM.
- (5) HYDROGEN CONTENT OF THE FINISHED ASSEMBLY SHALL NOT EXCEED 0,0125% (125 ppm).
- /6/ POINT SHALL BE FLAT AND CHAMFERED 45°. CHAMFER AND INCOMPLETE THREADS SHALL NOT EXCEED DIMENSION "U".
- /7/ SCREW RECESS SHALL BE TORQUE TESTED IN BOTH THE INSTALLATION AND REMOVAL DIRECTION. THE APPROPRIATE SIZE DRIVER IN ACCORDANCE WITH NA0025 SHOULD BE USED WITH AXIAL END FORCE NOT EXCEEDING 66N. SCREWS ARE REJECTABLE IF MINIMUM TORQUE VALUES LISTED CAUSE FRACTURE OF SCREW OR DISTORTION WHICH RESULTS IN RAISE OF METAL AT EDGE OF RECESS EXCEEDING 0,15 ABOVE SURROUNDING AREA. SAMPLING FOR LOT INSPECTION OF RECESS TORQUE SHALL BE IN ACCORDANCE WITH ANSI/ASQ Z1.4, 4% AQL, LEVEL S-1.
- /8/ RUNOUT SHALL BE DETERMINED WITH WASHER SEATED AGAINST SCREW HEAD.
- /9/ FOR SCREWS 40 mm OR LESS IN LENGTH, THE COMPLETE THREAD SHALL EXTEND TO WITHIN "V" OF THE TOP OF THE HEAD. SCREWS OVER 40 mm IN LENGTH SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH (INCLUDING THE CHAMFER "U") OF 35 mm. THE UNTHREADED SHANK DIAMETER SHALL NOT BE LESS THAN THE THREAD MINIMUM PITCH DIAMETER.
- /10/ ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22.
- (11) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (12) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (13) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (14) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION
3
NA0160
SHEET 2



Documents
Document Sharing Hub

③ COMPLETELY REVISED

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America Inc. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS. Licensee= www.sepana.ir/5991803002, User=sam, albert
No reproduction or networking permitted without license from IHS. Not for Resale, 01/04/2016 09:48:01 MST TRADEMARKS RIGHTS.

Full document details: AIA NA0160 2012