

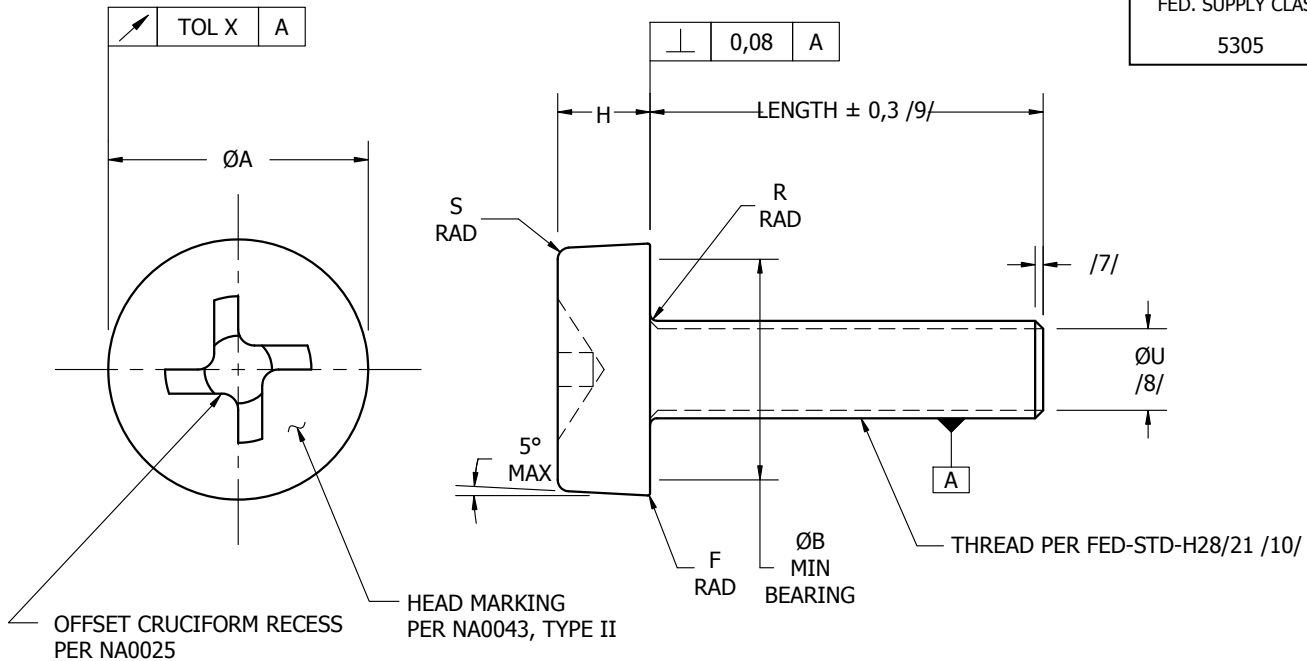


TABLE I – DIMENSIONS

DIA CODE	THREAD	ØA	ØB BEARING MIN	F RAD	H	R RAD	S RAD MIN	ØU	X FIM	OFFSET CRUCIFORM RECESS		TENSILE FORCE MIN (N)
										RECESS NO.	INSPECTION TORQUE (Nm)	
030	MJ3 X 0,5 - 4h6h	6,0 5,7	5,1	0,3 0,1	1,8 1,6	0,4 0,2	1,2 0,3	2,3 1,8	0,11	4	0,8	2 800
040	MJ4 X 0,7 - 4h6h	8,0 7,7	7,1	0,3 0,1	2,4 2,2	0,4 0,2	1,6 0,4	3,0 2,5	0,14	8	1,9	4 950
050	MJ5 X 0,8 - 4h6h	10,0 9,7	9,1	0,3 0,1	3,0 2,8	0,5 0,3	2,0 0,5	4,0 3,5	0,18	10	2,5	7 900
060	MJ6 X 1 - 4h6h	12,0 11,7	11,1	0,3 0,1	3,6 3,3	0,7 0,5	2,4 0,6	4,7 4,2	0,21	1/4	6,4	11 200
080	MJ8 X 1 - 4h6h	16,0 15,7	14,7	0,5 0,2	4,8 4,5	0,7 0,5	3,2 0,8	6,7 6,2	0,28	5/16	13,7	21 200
100	MJ10 X 1,25 - 4h6h	20,0 19,7	18,7	0,5 0,2	6,0 5,7	0,8 0,6	4,0 1,0	8,4 7,9	0,35	3/8	21,8	33 100

MATERIAL:

CRES – 321 (UNS S30321), 347 (UNS S30347), OR 316 (UNS S30316) IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

NONE.

① COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN		REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE		1
	TITLE		CLASSIFICATION PART STANDARD
PROCUREMENT SPECIFICATION	SCREW, PAN HEAD, OFFSET CRUCIFORM RECESS DRIVE, FULL THREAD, CRES, 500 MPa Ft _u , METRIC		NA0271

FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4, TYPE II.

CODE:

BASIC PART NUMBER FOLLOWED BY A DASH AND THREE DIGITS TO INDICATE NOMINAL DIAMETER AS TABULATED, AND A SECOND THREE DIGITS TO DESIGNATE NOMINAL LENGTH. SEE TABLE II FOR LIMITS.

EXAMPLE OF PART NUMBER:

NA0273 - 060 012 = SCREW, PAN HEAD, OFFSET CRUCIFORM RECESS, FULL THREAD, CRES, 500 MPa
Ftu, METRIC

LENGTH CODE 012 = 12 mm LONG. SEE TABLE II.
DIAMETER CODE 060 = Ø6 mm, MJ6 x 1 THREAD
BASIC PART NUMBER

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET, AND ALL THREAD ELEMENTS: 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) RECESS SHALL BE TORQUE TESTED IN BOTH INSTALLATION AND REMOVAL DIRECTIONS WITH DRIVER PER NA0025 AND AXIAL END PRESSURE NOT EXCEEDING 66 N. SCREWS ARE REJECTABLE IF MINIMUM TORQUE VALUES SPECIFIED CAUSE FRACTURE OF FASTENER OR DISTORTION WHICH RESULTS IN RAISE OF METAL AT EDGE OF RECESS EXCEEDING 0,15 ABOVE SURROUNDING AREA. SAMPLING SHALL BE PER ANSI/ASQ Z1.4, 4% AQL, LEVEL S-1.
- (5) DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994 AND NA0156.
- (6) 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.
- /7/ INCOMPLETE THREADS 1,5 MAX.
- /8/ POINT SHALL BE FLAT AND CHAMFERED 45° APPROXIMATELY FROM ØU.
- /9/ SCREWS 40 mm OR LESS IN LENGTH SHALL HAVE COMPLETE THREADS TO WITHIN TWO THREAD PITCHES OF THE MAX HEAD FILLET RADIUS. LONGER SCREWS SHALL HAVE A MINIMUM COMPLETE THREAD OF 35 mm. DIAMETER OF UNTHREADED PORTION OF SCREW SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.
- /10/ ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22.

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REVISION

1

Documents
SHEET 2



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