

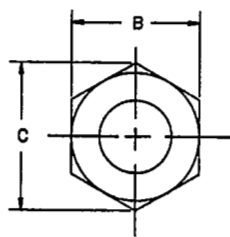


**Aerospace
Industries
Association**

NATIONAL AEROSPACE STANDARD

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FED. SUP CLASS
5310



SHAPE OF TOP
OPTIONAL
SEE NOTE 2



IDENTIFICATION - SEE NOTE 3

COUNTERSINK 120°
MAX. X D DIA
(RADIUS OPTIONAL)
THREAD T

MARK WITH "C" TO
DESIGNATE 800°F NUTS.
POSITION OPTIONAL. NO
MARKING NEED BE APPLIED
TO 250°F OR 450°F NUTS.

.016±.010 WASHER
FACE OR CHAMFER
30°±5° OR RADIUS
TO B OPTIONAL

THREAD T	DASH NUMBERS						
	NYLON INSERT			ALL METAL			
	AL ALLOY	STEEL	COPPER BASE ALLOY	AL ALLOY	COPPER BASE ALLOY	STEEL	CORR RESIS STEEL
	250°F	250°F	250°F	250°F	250°F	450°F	800°F
.1380-32 UNJC-3B	D06	N06	B06	H06	E06	A06	C06
.1640-32 UNJC-3B	D08	N08	B08	H08	E08	A08	C08
.1900-32 UNJF-3B	D3	N3	B3	H3	E3	A3	C3
.2500-28 UNJF-3B	D4	N4	B4	H4	E4	A4	C4
.3125-24 UNJF-3B	D5	N5	B5	H5	E5	A5	C5
.3750-24 UNJF-3B	D6	N6	B6	H6	E6	A6	C6
.4375-20 UNJF-3B	D7	N7	B7	H7	E7	A7	C7
.5000-20 UNJF-3B	D8	N8	B8	H8	E8	A8	C8
.5625-18 UNJF-3B	D9	N9	B9	H9	E9	A9	C9
.6250-18 UNJF-3B	D10	N10	B10	H10	E10	A10	C10
.7500-16 UNJF-3B	D12	N12	B12	H12	E12	A12	C12
.8750-14 UNJF-3B	D14	N14	B14	H14	E14	A14	C14
1.0000-12 UNJF-3B	D16	N16	B16	H16	E16	A16	C16
1.1250-12 UNJF-3B	D18	N18	B18	H18	E18	A18	C18
1.2500-12 UNJF-3B	D20	N20	B20	H20	E20	A20	C20
1.0000-14 UNJS-3B	D17	N17	B17	H17	E17	A17	C17

THREAD T	A (a) MAX	B		C (REF)	D +.020 -.010
		MAX	MIN		
.1380-32 UNJC-3B	.141	.314	.302	.360	.156
.1640-32 UNJC-3B	.188	.346	.334	.390	.183
.1900-32 UNJF-3B	.188	.377	.365	.430	.210
.2500-28 UNJF-3B	.219	.439	.430	.506	.273
.3125-24 UNJF-3B	.266	.502	.492	.580	.336
.3750-24 UNJF-3B	.282	.564	.553	.650	.398
.4375-20 UNJF-3B	.328	.690	.679	.790	.458
.5000-20 UNJF-3B	.328	.752	.741	.870	.531
.5625-18 UNJF-3B	.375	.877	.865	1.010	.594
.6250-18 UNJF-3B	.407	.940	.928	1.080	.656
.7500-16 UNJF-3B	.422	1.064	1.052	1.230	.787
.8750-14 UNJF-3B	.485	1.252	1.239	1.440	.913
1.0000-12 UNJF-3B	.578	1.440	1.427	1.660	1.039
1.1250-12 UNJF-3B	.672	1.627	1.614	1.880	1.166
1.2500-12 UNJF-3B	.766	1.815	1.801	2.090	1.290
1.0000-14 UNJS-3B	.578	1.440	1.427	1.660	1.039

⑧ INACTIVE FOR DESIGN AFTER 1 SEPT 1985.
SEE MS21042, MS21043, MS21245, AND
MS21083.

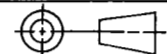
LIST OF CURRENT SHEETS

NO.	REV.
1	8
2	8

⑧

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE

THIRD
ANGLE
PROJECTION



PROCUREMENT
SPECIFICATION

TITLE

CLASSIFICATION
STANDARD PART

MIL-N-25027
EXCEPT AS NOTED

**NUT, SELF-LOCKING, HEXAGON-
LOW HEIGHT, LOW STRENGTH**

Documents
NAS 1022

SHEET 1 OF 2



**Aerospace
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NATIONAL AEROSPACE STANDARD

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AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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WASHINGTON, D.C. 20005

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE
SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS
FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

(a) MINIMUM "A" LIMITED ONLY BY STRENGTH REQUIREMENT OF SPECIFICATION.

THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.

CODE: APPLICABLE TO STEEL NUTS, BASIC CODES "A" AND "N", ONLY. INSERT "X" IN ADDITION TO "A" FOR PLATED STEEL NUTS WITHOUT LUBRICANT. INSERT "M" IN ADDITION TO "A" FOR PLATED STEEL NUTS WITH DRY FILM LUBRICANT.

EXAMPLE OF PART NUMBER:

NAS1022A3 = NUT - STEEL WITH .1900-32 UNJF-3B THREAD FOR USE UP TO 450°F - ALL METAL WITH A LUBRICANT.

NAS1022N3 = NUT - STEEL WITH .1900-32 UNJF-3B THREAD FOR USE UP TO 250°F - NYLON INSERT.

NAS1022AX3 = NUT - STEEL WITH .1900-32 UNJF-3B THREAD FOR USE UP TO 450°F - ALL METAL WITHOUT LUBRICANT.

MATERIAL: SEE SPECIFICATION MIL-N-25027.

FINISH: STEEL: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. IN APPLICATIONS FOR DRY FILM LUBRICATED NUTS, THE TYPE OF CADMIUM PLATING IS OPTIONAL PROVIDED THE NUTS MEET THE SALT SPRAY REQUIREMENTS OF
(8) QQ-P-416, TYPE II.

CRES: SILVER PLATE FOR 800°F USE PER MIL-N-25027 TO A .0002 MINIMUM THICKNESS ON SURFACES WHICH CAN BE TOUCHED BY A .7500 (3/4-INCH) BALL. THREADS SHALL SHOW COMPLETE COVERAGE, BUT THICKNESS REQUIREMENT ON THREADS IS WAIVED. NO LUBRICANT SHALL BE USED.

ALUMINUM ALLOY: ANODIZE OR CHEMICAL FILM PER MIL-N-25027, EXCEPT ANODIZE SHALL BE LIMITED TO TYPE I OR TYPE II.

PROCUREMENT SPECIFICATION: MIL-N-25027 EXCEPT AS NOTED. ALL NUTS SHALL MEET QUALIFICATION AND INSPECTION REQUIREMENTS. MANUFACTURERS SHALL PROVIDE EVIDENCE OF QUALIFICATION WHEN REQUIRED. TESTING SHALL BE PERFORMED BY MANUFACTURER OR INDEPENDENT LABORATORY. PROCURING AGENCY MAY CONDUCT CONFIRMING QUALIFICATION TESTS. NO QPL SHALL BE ESTABLISHED.

DIMENSIONS IN INCHES:

NOTE 1 - "NX" CODE INACTIVE FOR NEW DESIGN AFTER 1 JUL 72.

NOTE 2 - SEGMENTED BEAM LOCK MAY BE SUPPLIED AT MANUFACTURER'S OPTION.

(8) NOTE 3 - NUTS WITH A THREAD DIAMETER OF .250 OR LARGER MANUFACTURED AFTER DECEMBER 1990 SHALL BE MARKED WITH THE MANUFACTURER'S IDENTIFICATION IN ACCORDANCE WITH AS478, CLASS D (SEE MIL-HDBK-57(1S)). UNMARKED NUTS MAY BE SUPPLIED UNTIL DECEMBER 1992.

APPROVAL DATE JULY 1956 REVISION ① 1 OCT 1962 ② 15 APRIL 1968 ③ 31 DEC 1968 ④ 16 DEC 1974 ⑤ 1 NOV 1977 ⑥ 19 OCT 1983 ⑦ 3 JUNE 1986 ⑧ 9 OCTOBER 1991