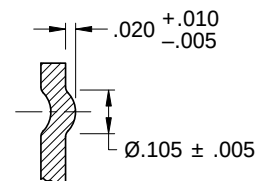
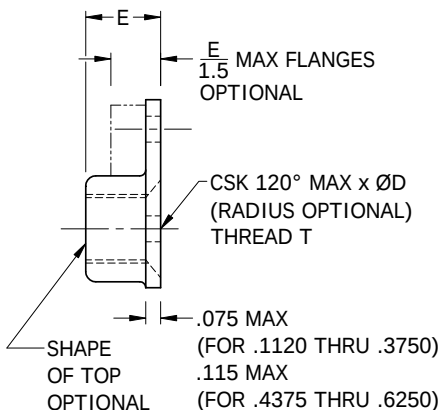
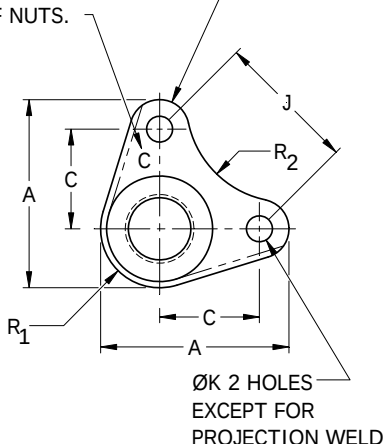


FED. SUPPLY CLASS

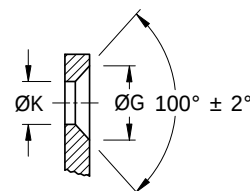
5310

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

R .145 (FOR .1120 THRU .3750)
R .115 (R.125 MIN FOR AL ALLOY)
R .176 (FOR .4375 THRU .6250)
R .146



PROJECTION NIBS
FOR SPOTWELDING



/2/ COUNTERSUNK RIVET HOLES
(OR MAY BE DIMPLED)

TABLE I – DIMENSIONS

T THREAD /4/	DASH NUMBERS					A	R ₁ RAD	R ₂ RAD	C ±.005	E /3/	ØD +.020 -.010	J ±.002	ØK +.005 -.000	ØG ±.010
	NYLON INSERT		ALL METAL											
	AL ALLOY 250 °F	STEEL 250 °F	AL ALLOY 250 °F	STEEL 450 °F	GRES 800 °F									
.1120-40 UNJC-3B	D04	N04	H04	A04	G04	.650	.172	.240	.344	.218	.131	.486	.098	.200
.1380-32 UNJC-3B	D06	N06	H06	A06	G06	.703	.203	.215	.344	.234	.156	.486	.098	.200
.1640-32 UNJC-3B	D08	N08	H08	A08	G08	.703	.203	.215	.344	.297	.183	.486	.098	.200
.1900-32 UNJF-3B	D3	N3	H3	A3	G3	.703	.203	.215	.344	.312	.210	.486	.098	.200
.2500-28 UNJF-3B	D4	N4	H4	A4	G4	.906	.257	.257	.500	.375	.273	.707	.098	.200
.3125-24 UNJF-3B	D5	N5	H5	A5	G5	.937	.281	.296	.500	.375	.336	.707	.130	.230
.3750-24 UNJF-3B	D6	N6	H6	A6	G6	1.008	.359	.375	.500	.453	.398	.707	.130	.230
.4375-20 UNJF-3B	D7	N7	H7	A7	G7	1.125	.391	.406	.562	.469	.458	.795	.161	—
.5000-20 UNJF-3B	D8	N8	H8	A8	G8	1.234	.437	.500	.625	.609	.531	.885	.161	—
.6250-18 UNJF-3B	D10	N10	H10	A10	G10	1.437	.505	.500	.750	.765	.656	1.060	.161	—

MATERIAL: SEE SPECIFICATION MIL-N-25027 NASM25027.

FINISH: STEEL — CODES CONTAINING "X" OR "N" CADMIUM PLATE. "A" CODE: CADMIUM PLATE PLUS AN APPROVED DRY FILM LUBRICANT. PLATING SHALL BE QQ-P-416, TYPE II, CLASS 2. EXISTING NUTS WITH AN OPTIONAL TYPE AND CLASS OF CADMIUM PLATE PER QQ-P-416, AS PREVIOUSLY PERMITTED, MAY BE FURNISHED UNTIL 16 DEC 1976.

GRES — 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.

AL ALLOY - ANODIZE OR CHEMICAL FILM PER NASM25027, EXCEPT ANODIZE SHALL BE LIMITED TO TYPE I OR TYPE II.

⑥ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 6
PROCUREMENT SPECIFICATION NASM25027 EXCEPT AS NOTED	TITLE NUT, SELF-LOCKING, PLATE, CORNER, REGULAR HEIGHT, NON-CSK	CLASSIFICATION PART STANDARD



Documents
SHEET 1 OF 2

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CODE: INSERT "X" IN ADDITION TO "A" OR "N" FOR PLATED STEEL NUTS WITHOUT LUBRICANT.
ADD "W" TO END OF PART NUMBER TO OBTAIN NUTS WITH WELDING PROJECTION ("C" CODE ONLY).
ADD "K" TO END OF PART NUMBER TO OBTAIN NUTS WITH COUNTERSUNK RIVET HOLES.

EXAMPLE OF PART NUMBER:

~~NAS1027A3 = NUT, STEEL WITH .1900-32 THREAD FOR USE UP TO 450 °F, ALL METAL.~~
~~NAS1027N3 = NUT, STEEL WITH .1900-32 THREAD FOR USE UP TO 250 °F, NYLON INSERT.~~
~~NAS1027D3 = NUT, AL ALLOY WITH .1900-32 THREAD FOR USE UP TO 250 °F, NYLON INSERT.~~
~~NAS1027H3 = NUT, AL ALLOY WITH .1900-32 THREAD FOR USE UP TO 250 °F, ALL METAL.~~
~~NAS1027C3W = NUT, CRES WITH .1900-32 THREAD FOR USE UP TO 800 °F, ALL METAL WITH WELDING PROJECTIONS.~~
~~NAS1027N3K = NUT, STEEL WITH .1900-32 THREAD FOR USE UP TO 250 °F, NYLON INSERT AND COUNTERSUNK RIVET HOLES.~~
~~NAS1027AX3 = NUT, STEEL WITH .1900-32 THREAD FOR USE UP TO 450 °F, ALL METAL WITHOUT LUBRICANT.~~
~~NAS1027NX3 = NUT, STEEL WITH .1900-32 THREAD FOR USE UP TO 250 °F, NYLON INSERT WITHOUT LUBRICANT.~~
~~NAS1027NX3K = NUT, STEEL WITH .1900-32 THREAD FOR USE UP TO 250 °F, NYLON INSERT AND COUNTERSUNK RIVET HOLES WITHOUT LUBRICANT.~~

- NOTES: ~~/1/ NUTS FOR USE BY WELDING TO HAVE WELDING PROJECTIONS WITH NOMINAL SPACING EQUAL TO DIMENSION J ± .005.~~
- ~~/2/ FOR DIMPLED RIVET TYPE ONLY, "ØK" TOLERANCE +.015 - .000 AFTER FORMING.~~
- ~~/3/ MINIMUM BASE AREA AND HEIGHT LIMITED ONLY BY STRENGTH REQUIREMENT OF SPECIFICATION.~~
- ~~/4/ THREADS IN ACCORDANCE WITH AS8879 BEFORE LUBRICATION.~~
- (5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (6) "NX" CODE INACTIVE FOR NEW DESIGN AFTER 1 JULY 1972.
- (7) "N", "A" AND "C" CODES INACTIVE FOR NEW DESIGN AFTER 1 JANUARY 1989. USE MS21081, MS21055, AND MS21056 RESPECTIVELY. FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.
- (8) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (9) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (10) 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.
- (11) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

PROCUREMENT SPECIFICATION:

NASM25027 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.

REVISION

6

⑥ COMPLETELY REVISED



NAS1027

SHEET 2

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