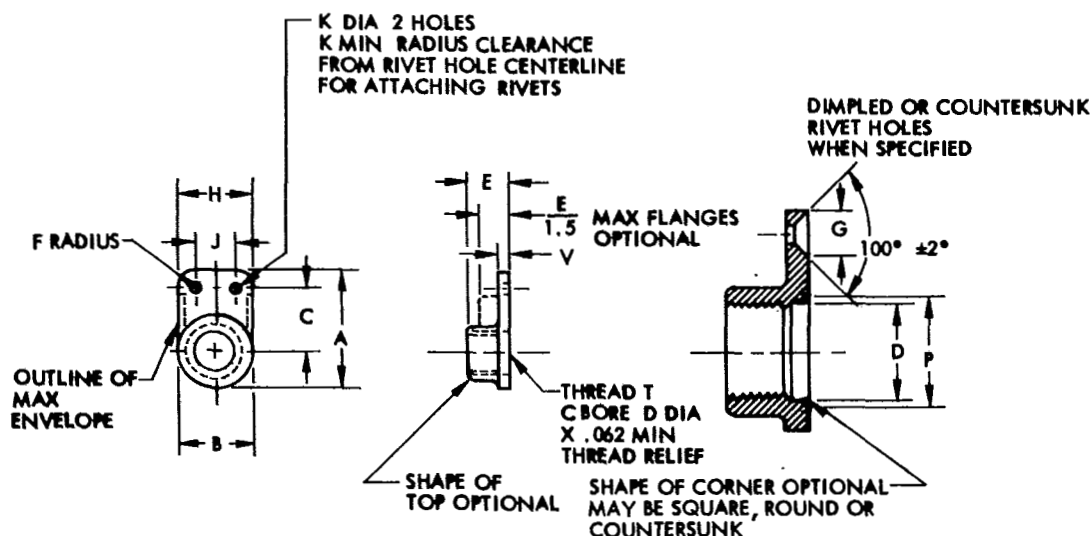




THREAD T (f)	DASH NUMBER			A MAX	B DIA MAX	C ±.005	D DIA MIN
	450°F STEEL	450°F (e) CRES	800°F (e) CRES				
.1640-32 UNJC-3B	A08	C08M	C08	.486	.297	.234	.168
.1900-32 UNJF-3B	A3	C3M	C3	.521	.328	.250	.194
.2500-28 UNJF-3B	A4	C4M	C4	.591	.414	.281	.254
.3125-24 UNJF-3B	A5	C5M	C5	.747	.505	.359	.317
.3750-24 UNJF-3B	A6	C6M	C6	.856	.614	.414	.379

THREAD T(f)	E(a) MAX	F(c) MIN	G DIA ±.010	H MAX	J ±.002	K(b) DIA +.005 -.000	P DIA MAX	V MAX	MAX WT.
.1640-32 UNJC-3B	.250	.100	.200	.437	.219	.098	.248	.047	
.1900-32 UNJF-3B	.250	.100	.200	.437	.219	.098	.274	.047	
.2500-28 UNJF-3B	.281	.100	.200	.437	.219	.098	.344	.055	
.3125-24 UNJF-3B	.328	.125	.230	.537	.269	.130	.417	.065	
.3750-24 UNJF-3B	.344	.125	.230	.537	.269	.130	.505	.075	

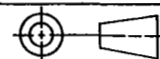
- (a) MINIMUM "E" NOT SPECIFIED. LIMITED ONLY BY STRENGTH REQUIREMENTS OF SPECIFICATION.
- (b) FOR DIMPLED RIVET TYPE, "K" TOLERANCE MAY BE +.015, -.000 AFTER FORMING.
- (c) THE CENTER OF THE TAPPED HOLE SHALL NOT DEVIATE FROM THE LONGITUDINAL CENTER LINE OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES BY MORE THAN .005.
- (e) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT.
- (f) THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.

⑨ INACTIVE FOR NEW DESIGN AFTER 1 JANUARY 1989 USE MS21086 AND MS21087 FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

LIST OF CURRENT SHEETS

NO.	REV.
1	9
2	9

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE

THIRD
ANGLE
PROJECTIONPROCUREMENT
SPECIFICATIONMIL-N-25027
EXCEPT AS NOTED

TITLE

⑨ NUT, SELF-LOCKING, PLATE-ONE LUG,
LOW HEIGHT, SIDE-BY-SIDECLASSIFICATION
STANDARD PART

NAS 1067

Documents

SHEET 1 OF 2

CODE: DASH NUMBERS SUFFIXED BY K = BACK COUNTERSUNK OR DIMPLED RIVET HOLES. THE CRES DASH NUMBER SUFFIXED BY M DESIGNATES AN APPROVED DRY FILM LUBRICANT FINISH. INSERT "X" IN LIEU OF "A" IN THE 450°F STEEL CODE FOR CADMIUM PLATED STEEL NUTS WITHOUT MOLYBDENUM DISULFIDE COATING OR ANY OTHER LUBRICANT.

EXAMPLE OF PART NUMBERS:

NAS1067A4 = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION PLAIN RIVET HOLES.
 NAS1067A4K = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION COUNTERSUNK OR DIMPLED RIVET HOLES.
 NAS1067C4 = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION OF A286 CRES, SILVER PLATED FOR 800°F USE.
 NAS1067C4M = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION OF A286 CRES WITH AN APPROVED DRY FILM LUBRICANT FOR 450°F USE.
 NAS1067X4 = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION PLAIN RIVET HOLES WITHOUT LUBRICANT.

MATERIAL: STEEL - SEE PROCUREMENT SPECIFICATION.
 CRES - A286 PER AMS 5525.

FINISH: STEEL: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, PLUS AN APPROVED DRY FILM LUBRICANT. 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.

CRES: SILVER PLATE, FOR 800°F USE, PER MIL-N-25027 TO A .0002 MINIMUM THICK. PLATE ON NUT SURFACES WHICH CAN BE TOUCHED BY A .7500 INCH BALL. THREADS SHALL SHOW COMPLETE COVERAGE BUT THICKNESS REQUIREMENT ON THREADS IS WAIVED. PLATING ON RETAINING CAGE IS OPTIONAL.

CRES: APPROVED DRY FILM LUBRICANT FOR 450°F USE.

PROCUREMENT SPECIFICATION:

MIL-N-25027, EXCEPT AS NOTED. ALL NUTS SHALL MEET QUALIFICATION AND INSPECTION REQUIREMENTS. MANUFACTURER 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.

NOTES: 1. AXIAL STRENGTH REQUIREMENTS PER MIL-N-25027 TABLE I VALUES FOR REGULAR STEEL NUTS.
 2. DIMENSIONS IN INCHES.

⑨ INACTIVE FOR NEW DESIGN AFTER 1 JANUARY 1989 USE MS21086 AND MS21087 FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

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.

APPROVAL DATE MARCH 1957 REVISION ⑥ 15 APRIL 1968 ⑦ 31 DEC. 1968 ⑧ 16 DEC. 1974 ⑨ 6 NOV. 1987

NAS 1067 Documents

Document Sharing Hub

SHEET 2