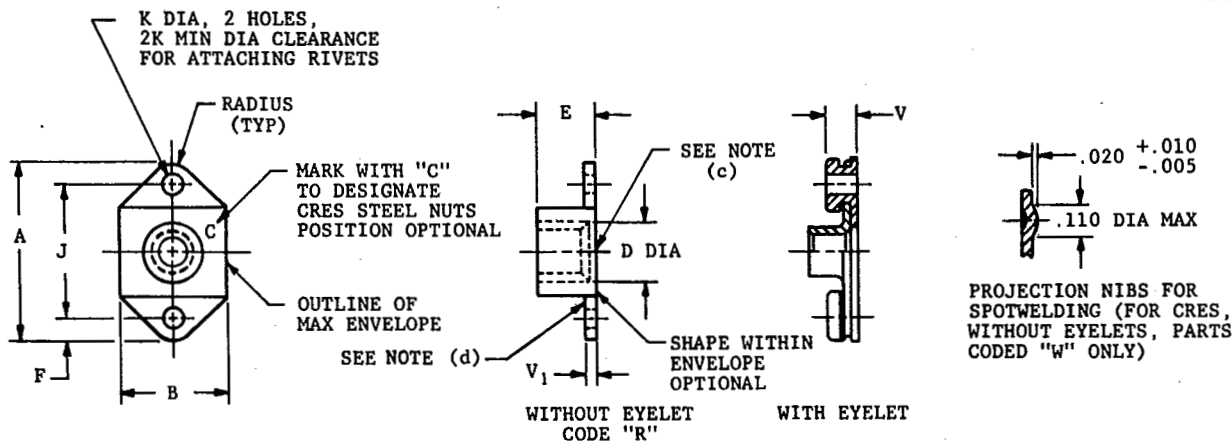




DASH NUMBER			THREAD T (e)	A MAX	B MAX	D DIA MIN	E (a) MAX	F MIN	J (b) ±.002	K DIA +.005 -.000	V MAX	V1 MAX
450 F	450 F	800 F										
STEEL	CRES	CRES										
A04	C04M	C04	.1120-40UNJC-3B	.498	.315	.116	.153	.075	.296	.066	.140	.032
A04L	C04LM	C04L	.1120-40UNJC-3B	.651	.315	.116	.153	.089	.406	.098	.140	.032
A06	C06M	C06	.1380-32UNJC-3B	.545	.357	.142	.171	.075	.343	.066	.140	.032
A06L	C06LM	C06L	.1380-32UNJC-3B	.682	.357	.142	.171	.089	.437	.098	.140	.032
A08	C08M	C08	.1640-32UNJC-3B	.707	.367	.168	.250	.100	.468	.098	.140	.032
A3	C3M	C3	.1900-32UNJF-3B	.739	.416	.194	.250	.100	.500	.098	.140	.032
A4	C4M	C4	.2500-28UNJF-3B	.801	.500	.254	.281	.100	.562	.098	.140	.032
A5	C5M	C5	.3125-24UNJF-3B	1.010	.581	.317	.328	.117	.718	.130	.140	.045

- (a) MINIMUM "E" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS OF SPECIFICATION.
- (b) FLOAT OF NUT PORTION OF ASSEMBLY SHALL NOT BE LESS THAN .020 INCH Laterally and Longitudinally FROM CENTERED POSITION. NUT BODY SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNED POSITION.
- (c) ON SIZE .1640 AND LARGER, COUNTERBORE THREAD D DIA X .062 DEEP MIN THREAD RELIEF; ON SIZE .1380 AND SMALLER, COUNTERSINK TO D DIA.
- (d) THE ASSEMBLY SHALL PROVIDE A BEARING SURFACE FOR THE NUT WITHIN THE HOUSING AND THE NUT AND BASE PORTION OF THE ASSEMBLY SHALL FORM ONE INTEGRAL UNIT.
- (e) THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.

- 13 INACTIVE FOR NEW DESIGN AFTER JUNE 1, 1991. USE MS21075, MS21076.
FOR DESCRIPTION OF STATUS NOTES SEE NAS 380.

LIST OF CURRENT SHEETS	
NO.	REV.
1	13
2	12

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE

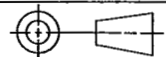
PROCUREMENT
SPECIFICATION

MIL-N-25027
EXCEPT AS NOTED

TITLE

NUT, SELF-LOCKING PLATE, TWO LUG,
LOW HEIGHT, CBORED, FLOATING,
REDUCED RIVET SPACING

THIRD
ANGLE
PROJECTION



CLASSIFICATION
STANDARD PART

1068

Document Sharing Hub
SHEET 1 OF 2

MATERIAL: STEEL - CARBON OR ALLOY STEEL, HEAT TREATED - SEE PROCUREMENT SPECIFICATION.
 CRES - A286 PER AMS5525, AMS5732, OR AMS5737.
 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.

FINISH: STEEL - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, PLUS AN APPROVED DRY FILM LUBRICANT.
 CRES - SILVER PLATE FOR 800F USE PER AMS2410 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. PLATING ON RETAINING CAGE IS OPTIONAL.
 CRES - APPROVED DRY FILM LUBRICANT FOR 450F USE.

LUBRICANT: MOLYBDENUM DISULFIDE DRY FILM LUBRICANT IN ACCORDANCE WITH MIL-N-25027. THE INCLUSION OF A LUBRICANT ON THE RETAINING CAGES OF DRY FILM LUBRICATED NUTS IS OPTIONAL.

CODE: "A" BEFORE DASH NUMBER INDICATES CADMIUM PLATED STEEL, WITH DRY FILM LUBRICANT, WITH OR WITHOUT EYELETS.
 "C" BEFORE DASH NUMBER INDICATES SILVER PLATED CRES, WITH OR WITHOUT EYELETS.
 "L" SUFFIXED TO DASH NUMBER INDICATES LONGER VERSIONS OF 04 AND 06 SIZES ONLY.
 (12) "M" SUFFIXED TO DASH NUMBER INDICATES CRES NUTS, WITHOUT SILVER PLATE, WITH OR WITHOUT EYELETS, WITH DRY FILM LUBRICANT.
 "R" BEFORE "A", "C" OR "X" INDICATES NUT TYPES WITH RIVET HOLES WITHOUT EYELETS ONLY.
 "W" SUFFIXED TO DASH NUMBER INDICATES WELD NIBS FOR CRES SILVER PLATED NUTS WITHOUT EYELETS ONLY (NO SILVER PLATE ON WELD NIBS).
 "X" IN PLACE OF "A" INDICATES CADMIUM PLATED STEEL PARTS WITHOUT DRY FILM LUBRICANT.

EXAMPLES OF PART NUMBERS:

STEEL

NAS1068A3 = .1900-32UNJF-3B THREAD, CADMIUM PLATED, WITH DRY FILM LUBRICANT, WITH OR WITHOUT EYELETS.
 NAS1068RA3 = .1900-32UNJF-3B THREAD, CADMIUM PLATED, WITH DRY FILM LUBRICANT, WITHOUT EYELETS.
 NAS1068X4 = .2500-28UNJF-3B THREAD, CADMIUM PLATED, WITHOUT DRY FILM LUBRICANT, WITH OR WITHOUT EYELETS.
 NAS1068RX4 = .2500-28UNJF-3B THREAD, CADMIUM PLATED, WITHOUT DRY FILM LUBRICANT, WITHOUT EYELETS.

CRES

NAS1068C3 = .1900-32UNJF-3B THREAD, SILVER PLATED, WITH OR WITHOUT EYELETS.
 NAS1068RC3 = .1900-32UNJF-3B THREAD, SILVER PLATED, WITHOUT EYELETS.
 (12) NAS1068RC4W = .2500-28UNJF-3B THREAD, WELD NIBS, SILVER PLATED, WITHOUT EYELETS.
 (12) NAS1068C4M = .2500-28UNJF-3B THREAD, WITH DRY FILM LUBRICANT ONLY, WITH OR WITHOUT EYELETS.
 (12) NAS1068RC4M = .2500-28UNJF-3B THREAD, WITH DRY FILM LUBRICANT ONLY, WITHOUT EYELETS

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.

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 MAR 1957 REVISION 7 15 APR 1968 8 31 DEC 1968 9 16 DEC 1974 10 31 JUL 1976 11 11 DEC 1978 12 31 JANUARY 1985