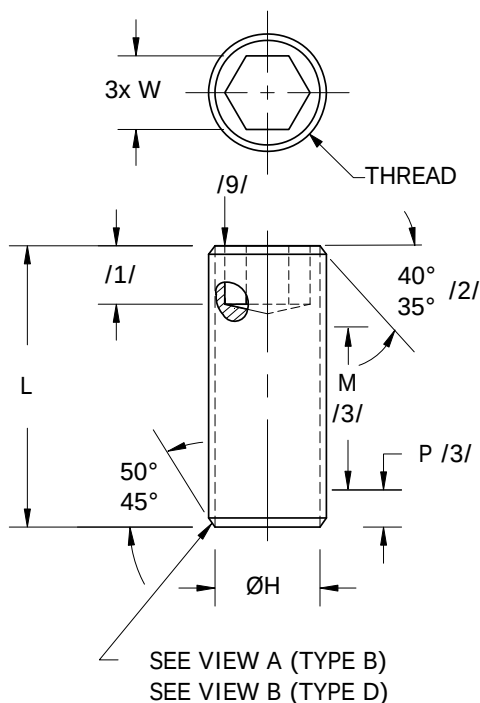


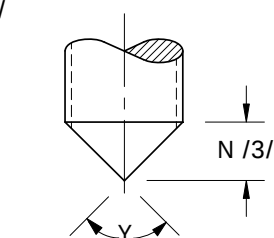
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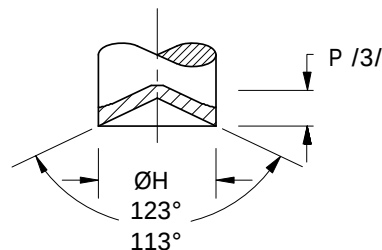
FORM 12-01



(TYPE A)



SEE VIEW A (TYPE B)



SEE VIEW B (TYPE D)

FED. SUPPLY CLASS

5305

TABLE I – DIMENSIONS

THREAD PER AS8879	W		ØH		Y		SELF-LOCKING DESIGN DATA			MATING THREAD AREA
	MAX	MIN	MAX	MIN	118°±2° FOR LENGTHS AND UNDER	90°±2° FOR LENGTHS AND OVER	P MAX /3/	N MAX /3/		M MIN /3/
								118°	90°	
.0860-56 UNJC-3A	.0355	.0350	.047	.039	.094	.109	.041	.044	.061	.089
.1120-40 UNJC-3A	.0510	.0500	.061	.051	.125	.156	.056	.059	.081	.125
.1380-32 UNJC-3A	.0635	.0625	.074	.064	.125	.188	.068	.073	.100	.156
.1640-32 UNJC-3A	.0791	.0781	.087	.076	.188	.250	.075	.081	.113	.156
.1900-32 UNJF-3A	.0947	.0937	.102	.088	.188	.250	.082	.088	.126	.156
.2500-28 UNJF-3A	.1270	.1250	.132	.118	.250	.312	.102	.111	.161	.178
.3125-24 UNJF-3A	.1582	.1562	.172	.156	.312	.375	.120	.136	.199	.208
.3750-24 UNJF-3A	.1895	.1875	.212	.194	.375	.438	.132	.149	.230	.208
.5000-20 UNJF-3A	.2520	.2500	.291	.270	.500	.562	.165	.201	.300	.250

17

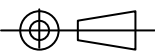
MATERIAL: STEEL, ALLOY 40L37, 4037 (UNS G40370), 4137 (UNS G41370), 4140 (UNS G41400), 41L40, 8630 (UNS G86300), OR 8740 (UNS G87400). HARDENED BY QUENCHING IN OIL FROM THE HARDENING TEMPERATURE AND TEMPERED TO 45-53 HRC.

CORROSION RESISTANT STEEL PER AMS5640, TYPE 1 OR 2.

FINISH: STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
CRES - PASSIVATE PER AMS2700, METHOD 1, CLASS 4. (7)

17

THIRD
ANGLE
PROJECTION



PROCUREMENT SPECIFICATION

NOTED

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

SETSCREW, SELF-LOCKING

REVISION

17

CLASSIFICATION
PART STANDARD

NAS1081 Document

SHEET 1 OF 3

Document 9

PLIERS OR CERTIFY

THE SUITABILITY OF

REVISION DATE: SEPTEMBER 19, 2014

ISSUE DATE: FEBRUARY 1, 1958

EXAMPLE OF PART NUMBER:

NAS1081C4B12LT = SELF-LOCKING CRES SET SCREW, .2500-28 x .750, CONE POINT WITH STRIP TYPE LOCKING ELEMENT, LEFT HAND THREAD.

NAS1081 C 4 B 12 L T

— THREAD: T = LEFT HAND THREAD /9/
(17) NO CODE = RIGHT HAND THREAD

-LOCKING ELEMENT /6/: L = STRIP TYPE
N = BUTTON TYPE
P = PATCH TYPE

-LENGTH AS TABULATED, SEE TABLE II

-POINT TYPE: A = FLAT POINT
B = CONE POINT
D = CUP POINT

- THREAD SIZE AS TABULATED, SEE TABLE II

-MATERIAL: C = CRES
 "-" (NO CODE) = STEEL (17)

-BASIC PART NUMBER (17)

NOTES:

- /1/ SOCKET DEPTH: THE DEPTH OF SOCKET SHALL BE AS GREAT AS PRACTICABLE BUT VARYING CONDITIONS RENDER IT INADVISABLE TO SPECIFY DEFINITE VALUES FOR THIS DIMENSION.
- /2/ SOCKET END OF SCREW SHALL BE FLAT AND CHAMFERED. THE CHAMFER SHALL EXTEND TO THE MINOR DIAMETER OF THE THREAD AND THE EDGE BETWEEN FLAT AND CHAMFER SHALL BE SLIGHTLY ROUNDED.
- /3/ "M" DIMENSION SHALL CONFORM TO THE REQUIREMENTS OF NASM15981 EXCEPT AS NOTED. "N" AND "P" DIMENSIONS ARE THE MAXIMUM POINT PLUS ONE THREAD PITCH.
- (4) SEE NASM565 FOR SET SCREWS WITHOUT SELF-LOCKING FEATURE.
- /5/ FOR LENGTHS ABOVE HEAVY LINE, MIL-DTL-18240 DOES NOT ESTABLISH REQUIREMENTS FOR SIZE .0860-56 SCREWS AND LENGTH OF THREADS LESS THAN "M". ONLY POSITIVE INDICATION OF TORQUE IS REQUIRED FOR ITEMS ABOVE THE HEAVY LINE.
- /6/ OMIT ELEMENT TYPE CODE WHENEVER POSSIBLE TO ALLOW AN OPTION.
- (7) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED. TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm .010$
- (8) ~~PARTS THREADED PER MIL-S-7742 MAY BE FURNISHED FROM SUPPLIER'S STOCK UNTIL DECEMBER 15, 1974.~~
- /9/ LEFT HAND THREADED PARTS SHALL BE MARKED WITH YELLOW PAINT OR DYE, ON THE RECESS END OF PART. OVERSPRAY ON THREADS IS ACCEPTABLE.

REVISION

17

NAS1081
Documents
SHEET 2

SHEET 2



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Full document details: AIA NAS1081 2014

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FORM 12-01