

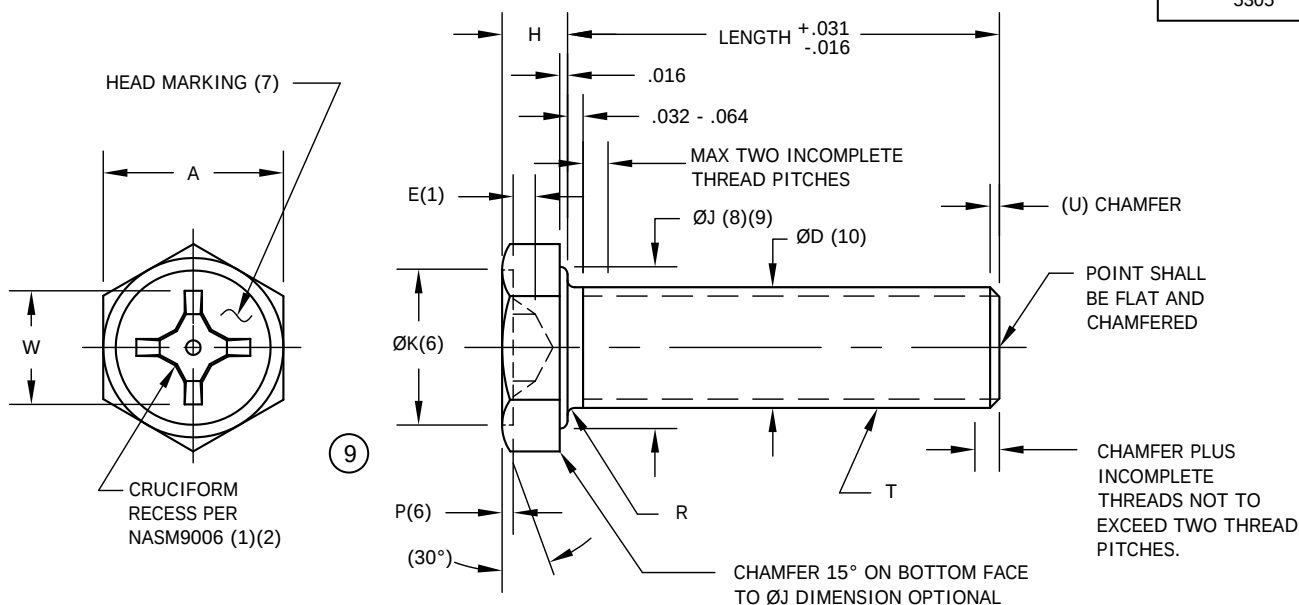


FIGURE 1 – CONFIGURATION

**INACTIVE FOR NEW DESIGN AFTER APRIL 30, 1990, USE NAS1801.
FOR DESCRIPTION OF STATUS NOTES SEE NAS380.**

TABLE I – DIMENSIONS

FIRST DASH NO.	T THREAD PER MIL-S-7742	A HEX	ØD (10)	E PENETRATION (1)	H	ØJ MIN (8)(9)	ØK (6)	(P) (6)	R	(U)	W	RECESS SIZE
1	.1380-32 UNC-3A	.250 .241	.115 .138	.067 .087	.080 .095	.210	.210	.012	.015 .005	.016	.166 .141	2
2	.1640-32 UNC-3A	.250 .241	.141 .164	.067 .087	.096 .110	.210	.210	.018	.015 .005	.016	.169 .156	2
3	.1900-32 UNF-3A	.313 .302	.167 .189	.082 .102	.105 .120	.272	.270	.020	.015 .005	.016	.188 .171	2

MATERIAL: ALLOY STEEL - 4037 (UNS G40370) PER AMS6300, 4130 (UNS G41300) PER MIL-S-6758 AMS6348 OR AMS6370, 4340 (UNS G43406) PER MIL-S-5000 OR AMS6415 OR AMS6484, 8630 (UNS G86300) PER MIL-S-6050, 8735 (UNS G87350) PER MIL-S-6098 OR 8740 (UNS G87400) PER MIL-S-6049 AMS6322 OR AMS6327. SEE NOTE 5.

HEAT TREATMENT: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 OR AMS2759. 125 - 145 KSI FTU.

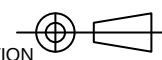
FINISH: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2

LIST OF CURRENT SHEETS	
SHT	REV
1	9
2	NEW

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

THIRD ANGLE PROJECTION



PROCUREMENT SPECIFICATION

TITLE

CLASSIFICATION PART STANDARD

NOTED

**SCREW, HEX HEAD, RECESSED, FULL THREAD,
ALLOY STEEL, 125 KSI FtU**

081096
SHEET 1 OF 2



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- CODE: FIRST DASH NUMBER INDICATES DIAMETER.
SECOND DASH NUMBER INDICATES LENGTH IN .0625 INCREMENTS.
- EXAMPLES: NAS1096-2-12 = SCREW, .1640-32 THREAD, .750 LONG
NAS1096-3-16 = SCREW, .1900-32 THREAD, 1.00 LONG
- NOTES:
1. GAGING OF THE CRUCIFORM RECESS SHALL BE IN ACCORDANCE WITH NASM9006 GAGE PENETRATION FOR A COUNTERSUNK 100° HEAD MACHINE SCREW EXCEPT AS NOTED AND SHALL BE WITHIN THE VALUES AS TABULATED IN TABLE I, E AND W COLUMNS AS MEASURED FROM THE HEAD SURFACES OF H OR P (SEE NOTE 6).
 2. ORIENTATION OF RECESS SLOTS TO HEX IS OPTIONAL.
 3. SCREWS SHALL BE FREE OF BURRS AND SLIVERS.
 4. DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED. TOLERANCES: DECIMALS $\pm .010$, ANGLES $\pm 5^\circ$
 5. ~~ALLOY STEELS 4037, 8630 AND 8735 ARE INACTIVE FOR NEW DESIGN AFTER JUNE 1993. PARTS MANUFACTURED FROM THESE ALLOY STEELS MAY BE FURNISHED FROM SUPPLIERS STOCK UNTIL JUNE 1995.~~
 6. CIRCULAR INDENTATION DEFINED BY DIMENSIONS "ØK" AND "P" IS OPTIONAL.
 7. PARTS MANUFACTURED AFTER JUNE 1993 SHALL INCLUDE HEAD MARKING PER NAS1347, TYPE I.
~~PARTS MARKED TO PREVIOUS REVISIONS MAY BE DELIVERED FROM SUPPLIERS STOCK UNTIL JUNE 1995.~~
 8. THE WASHER PAD ØJ MAX SHALL NOT TO EXCEED THE ACTUAL ACROSS FLATS HEAD MEASUREMENT.
 9. THE CONCENTRICITY OF THE WASHER PAD TO ØD THREAD MAJOR DIAMETER SHALL BE WITHIN .005 INCH WHEN THE THREAD MAJOR DIAMETER IS GRIPPED WITHIN A DISTANCE FROM THE WASHER PAD SURFACE EQUAL TO THE THREAD MAXIMUM MAJOR DIAMETER, PLUS OR MINUS TWO THREAD PITCHES.
 10. THE ØD MAXIMUM AND MINIMUM VALUES TABULATED IN TABLE I ARE APPLICABLE TO THE .032 TO .064 UNTHREADED PORTION OF THE FASTENER SHANK. THE THREAD MAJOR, PITCH AND MINOR DIAMETERS IN THE THREADED PORTION OF THE FASTENER SHANK SHALL BE IN ACCORDANCE WITH THE MIL-S-7742 THREAD SPECIFICATION EXCEPT THAT THE -3 SIZE MAJOR DIAMETER SHALL BE LIMITED TO A MAXIMUM VALUE OF .189.
 11. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
 12. REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
 13. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.
 14. UNLESS OTHERWISE SPECIFICIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THIS PART STANDARD MAY BE PROCURRED AND USED UNTIL STOCK IS DEPLETED.

PROCUREMENT SPECIFICATION: NASM7839 EXCEPT MATERIAL AS SPECIFIED HEREIN.