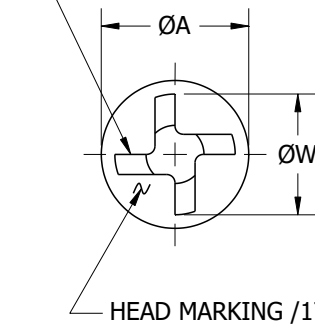


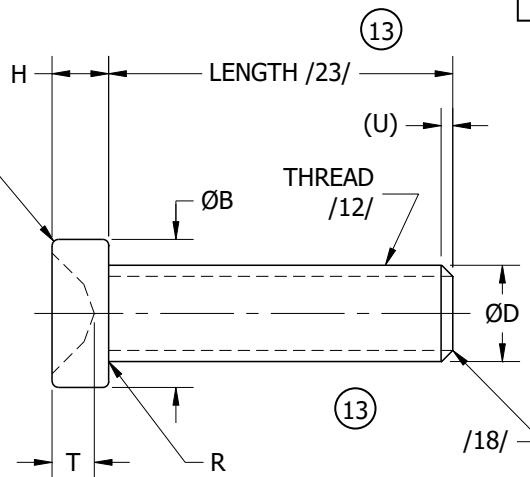
FED. SUPPLY CLASS

5305

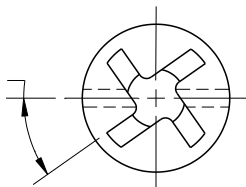
OFFSET CRUCIFORM RECESS
PER NASM14191 OR NASM33781
(SEE CODE) /13/



BREAK EDGE
.010 MAX

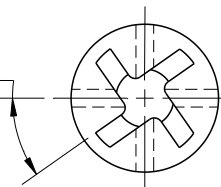


35°±5°



DRILLED HEAD (CODE H)

35°±5° 2 PL

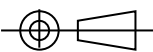


CROSS-DRILLED HEAD (CODE D)

TABLE I – DIMENSIONS

PART NUMBER	THREAD /12/	ØA	ØB MIN	(C)	ØD MAX	E	H	ØK	R RAD	T MAX	(U)	ØW MAX	RECESS GAGE PENETRATION /3/		TENSILE STRENGTH MIN LBF /16/
													MAX	MIN	
NAS1101-00	.0600-80 UNJF-3A	.096 .092	.082	—	.060	—	.037 .029	—	.010 .005	.033	.010	.087	.0250	.0170	288
NAS1101-01	.0730-64 UNJC-3A	.118 .114	.104	—	.073	—	.045 .037	—	.010 .005	.039	.010	.104	.0300	.0215	420
NAS1101-02	.0860-56 UNJC-3A	.140 .136	.126	—	.086	—	.053 .044	—	.010 .005	.046	.010	.122	.0350	.0260	591
NAS1101-04	.1120-40 UNJC-3A	.183 .178	.168	.034	.112	.035 .030	.069 .059	/15/	.010 .005	.059	.013	.157	.0450	.0350	966
NAS1101-06	.1380-32 UNJC-3A	.226 .221	.211	.044	.138	.045 .035	.086 .074	.042 .034	.010 .005	.072	.016	.193	.0555	.0450	1,450
NAS1101-08	.1640-32 UNJC-3A	.270 .265	.255	.049	.164	.050 .040	.102 .088	.042 .034	.020 .010	.085	.016	.228	.0660	.0545	2,240
NAS1101-3	.1900-32 UNJF-3A	.313 .306	.296	.056	.190	.060 .050	.118 .103	.042 .034	.020 .010	.098	.016	.263	.0760	.0635	3,180
NAS1101-4	.2500-28 UNJF-3A	.375 .367	.357	.075	.250	.080 .070	.150 .133	.068 .060	.020 .010	.128	.018	.345	.0990	.0850	5,820
NAS1101-5	.3125-24 UNJF-3A	.438 .429	.413	.094	.312	.090 .080	.183 .162	.068 .060	.020 .010	.134	.021	.382	.0985	.0825	9,200
NAS1101-6	.3750-24 UNJF-3A	.563 .552	.536	.113	.375	.100 .090	.215 .191	.068 .060	.025 .015	.161	.021	.457	.1180	.1000	14,000

THIRD ANGLE PROJECTION



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PROCUREMENT SPECIFICATION

TITLE

CLASSIFICATION
PART STANDARD

NOTED

**SCREW, MACHINE, FLAT FILLISTER HEAD,
FULL THREAD, OFFSET CRUCIFORM**



NAS1101

SHEET 1 OF 5

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MATERIAL: (13) ALLOY STEEL: 4140 (UNS G41400) PER MIL-S-5626 AMS6382, 4340 (UNS G43406) PER MIL-S-5000
AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER MIL-S-6049 AMS6322, AMS6325 OR
AMS6327.
CRES: A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR
AMS5853.
TITANIUM ALLOY: 6Al-4V (UNS R56400) PER AMS4928 OR AMS4967.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 AMS2759
FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM:

ALLOY STEEL: 160-180 KSI FTU.
CRES: 160-190 KSI FTU. /16/
TITANIUM (6Al-4V): 160 KSI FTU MIN.

FINISH:

(13) ALLOY STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 (NO CODE).
- CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 WITH DULL BLACK
CHROMATE TREATMENT (B CODE).
~~- CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2 (W CODE). /14/~~
CRES - PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, TYPE 2 OR TYPE 8, CLASS 4 (NO
CODE).
- PASSIVATE PER AMS2700, METHOD 2 - NO POST TREATMENT (G CODE).
- PASSIVATE PER AMS2700, METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT (M CODE).
- CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 (P CODE).
TITANIUM ALLOY - NONE (NO CODE).
- ALUMINUM COAT PER NAS4006, NO CLASS, CONTAINING CHROMATES (A CODE).
- ALUMINUM COAT PER NAS4006, CLASS NC, NON-CHROMATED (F CODE).
- ALUMINUM COAT PER MIL-DTL-83488, TYPE II, CLASS 3 (C CODE).
~~- CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 (P CODE). /24/~~

CODE:

(13) NAS1101 V 5 - 10 C
BASIC MS NUMBER: _____
MATERIAL: _____
"_" = ALLOY STEEL
"E" = CRES
"C" = CRES (140 KSI)
"V" = TITANIUM ALLOY
SIZE DASH NUMBER: _____
(SEE TABLE I)
HEAD: _____
"_" = RECESS PER NASM33781 /13/
"D" = CROSS-DRILLED HEAD
"H" = DRILLED HEAD
"R" = RECESS PER NASM14191
FOR SIZES 06 THRU 5
INCLUSIVE /13/
LENGTH DASH NUMBER: _____
(SEE TABLE II) /23/
FINISH:
- ALLOY STEEL:
NO CODE = CADMIUM PLATE
"B" = CAD PLATE WITH DULL BLACK CHROMATE TREATMENT
"W" FOLLOWING LAST DASH NUMBER DESIGNATES
TYPE I PLATING /14/
- CRES:
NO CODE = PASSIVATION PER AMS2700, METHOD 1,
TYPE 2 OR TYPE 8, CLASS 4
"G" = PASSIVATION PER AMS2700, METHOD 2, NO POST
TREATMENT
"M" = PASSIVATION PER AMS2700, METHOD 1, TYPE 8,
CLASS 4, NO POST TREATMENT
"P" = CADMIUM PLATE
- TITANIUM ALLOY:
NO CODE = NONE
"A" = ALUMINUM COAT PER NAS4006, NO CLASS
"C" = ALUMINUM COAT PER MIL-DTL-83488
"F" = ALUMINUM COAT PER NAS4006, CLASS NC
"P" = CADMIUM PLATE /24/

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