

FED. SUPPLY CLASS

5305

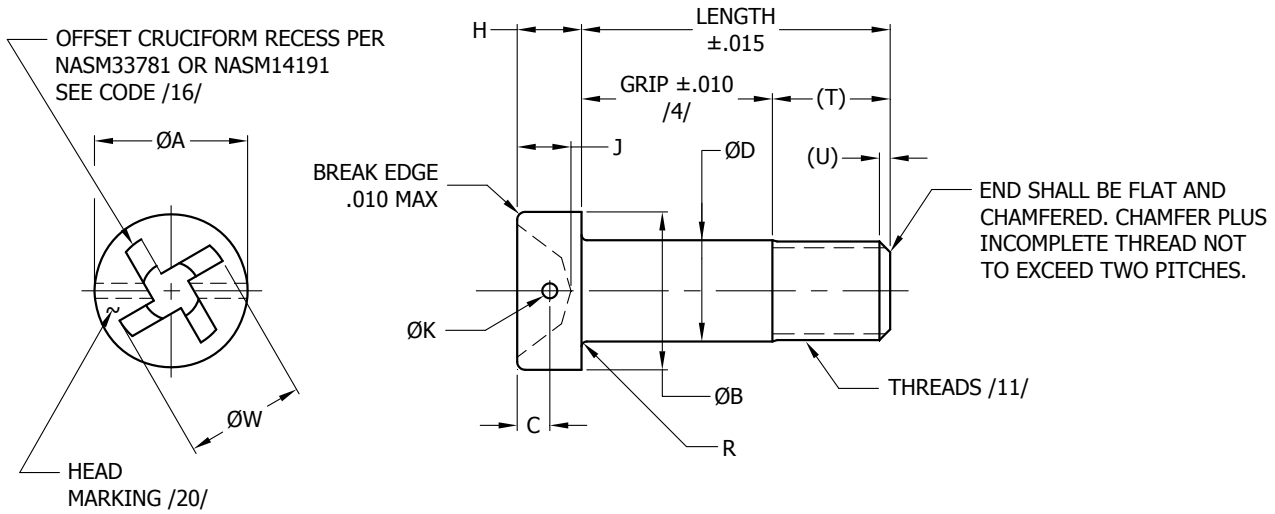


FIGURE 1 – SCREW CONFIGURATION

TABLE I – DIMENSIONS

BASIC PART NUMBER	THREADS /11/	ØA	ØB MIN	C +.000 -.010	ØD	H	J MAX	ØK	R RAD	(T)	(U)	ØW MAX
NAS1121	.1380-32 UNJC-3A	.226 .221	.211	.044	.1375 .1365	.086 .074	.072	.042 .034	.010 .005	.276	.016	.193
NAS1122	.1640-32 UNJC-3A	.270 .265	.255	.049	.1635 .1625	.102 .088	.085	.042 .034	.020 .010	.276	.016	.228
NAS1123	.1900-32 UNJF-3A	.313 .306	.296	.056	.1895 .1885	.118 .103	.098	.042 .034	.020 .010	.276	.016	.263
NAS1124	.2500-28 UNJF-3A	.375 .365	.357	.075	.2495 .2485	.150 .133	.128	.068 .060	.020 .010	.316	.018	.345
NAS1125	.3125-24 UNJF-3A	.438 .429	.413	.094	.3120 .3110	.183 .162	.134	.068 .060	.020 .010	.375	.021	.382
NAS1126	.3750-24 UNJF-3A	.563 .552	.536	.113	.3745 .3735	.215 .191	.161	.068 .060	.025 .015	.391	.021	.457
NAS1127	.4370-20 UNJF-3A	.625 .615	.595	.131	.4370 .4360	.248 .221	.169	.068 .060	.025 .015	.453	.025	.498
NAS1128	.5000-20 UNJF-3A	.750 .739	.719	.150	.4995 .4985	.280 .250	.193	.068 .060	.030 .020	.453	.025	.568

⑭ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 14
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, MACHINE, FLAT FILLISTER HEAD, CLOSE TOLERANCE, SHORT THREAD, OFFSET CRUCIFORM, 160 KSI FTU	CLASSIFICATION PART STANDARD
		NAS1121 THRU NAS1128 SHEET 1 OF 5

TABLE II – INSPECTION DATA

BASIC PART NUMBER	FIM VALUES					TEST VALUES	
	X	Y	Z	RECESS GAGE PENETRATION /3/		RECESS MIN TORQUE IN-LBF	MIN TENSILE STRENGTH LBF
	/1/	/1/	/2/	MAX	MIN	/6/	/24/
NAS1121	.005	.0045	.0040	.0555	.0450	24	1,450
NAS1122	.005	.0045	.0040	.0660	.0545	37	2,240
NAS1123	.005	.0045	.0040	.0760	.0635	50	3,180
NAS1124	.006	.0045	.0030	.0990	.0850	125	5,820
NAS1125	.008	.0060	.0030	.0985	.0825	250	9,200
NAS1126	.009	.0060	.0025	.1180	.1000	430	14,000
NAS1127	.010	.0060	.0025	.1205	.1005	925	18,900
NAS1128	.011	.0060	.0020	.1375	.1155	1,210	25,600

MATERIAL:

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.

~~A286 (UNS S66286) PER AMS5735, EXCEPT FOR HEAT TREATMENT. /22/~~

TITANIUM - 6AL-4V (UNS R56400) PER AMS4928 OR AMS4967.

~~4AL-4MN (UNS R56440) PER NAS621. /23/~~

HEAT TREATMENT:

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

ALLOY STEEL: 160-180 KSI FTU

A286 CRES: 160-190 KSI FTU /24/
140 KSI MIN AT ROOM TEMPERATURE.

TITANIUM (6AL-4V): 160 KSI FTU MIN

~~TITANIUM (4AL-4MN): 150 KSI FTU MIN~~

FINISH:

ALLOY STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 WITH DULL BLACK CHROMATE TREATMENT. CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 2. /15/

CRES - PASSIVATED PER AMS2700, METHOD 1, CLASS 4 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

TITANIUM ALLOY - NONE OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. /18/

CODE:

BASIC NUMBER = SCREW, ALLOY STEEL, CADMIUM PLATED, NASM33781 RECESS GRIP DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE IV). IF MORE THAN ONE CODE LETTER IS USED IN SEQUENCE, ARRANGE THE LETTERS ALPHABETICALLY.

~~"C" IN LIEU OF DASH DESIGNATES A286 CRES (140 KSI). /22/~~

~~"E" IN LIEU OF DASH DESIGNATES A286 CRES.~~

~~"T" IN LIEU OF DASH DESIGNATES 4AL-4MN TITANIUM ALLOY (150 KSI). /23/~~

~~"V" IN LIEU OF DASH DESIGNATES 6AL-4V TITANIUM ALLOY.~~

~~"H" AFTER GRIP DASH NUMBER DESIGNATES DRILLED HEAD.~~

~~"P" AFTER GRIP DASH NUMBER DESIGNATES AMS-QQ-P-416, TYPE II, CLASS 2 PLATING (CRES ONLY) /18/~~

~~"B" AFTER GRIP DASH NUMBER DESIGNATES AMS-QQ-P-416, TYPE II, CLASS 2 WITH DULL BLACK CHROMATE TREATMENT.~~

~~"R" AFTER GRIP DASH NUMBER DESIGNATES RECESS PER NASM14191. /16/~~

~~"W" AFTER GRIP DASH NUMBER DESIGNATES QQ-P-416, TYPE I, CLASS 2 PLATING. /15/~~

①4 COMPLETELY REVISED

REVISION

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NAS1121 THRU
NAS1128
SHEET 2



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