

FED. SUPPLY CLASS

5305

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

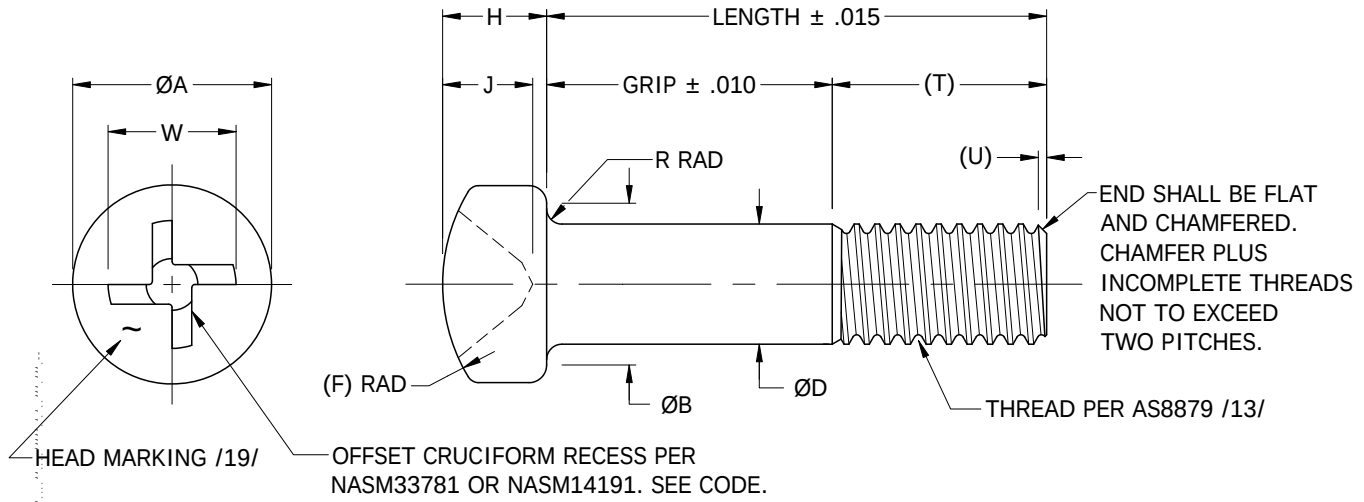


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NO.	THREAD /13/	ØD	ØA	ØB MIN	H	R RAD	(T)	(U)	(F) RAD	J MAX	W MAX
NAS1131	.1380-32 UNJC-3A	.1375 .1365	.270 .256	.242	.097 .087	.010 .005	.276	.016	.20	.055	.160
NAS1132	.1640-32 UNJC-3A	.1635 .1625	.322 .306	.289	.115 .105	.020 .010	.276	.016	.24	.065	.190
NAS1133	.1900-32 UNJF-3A	.1895 .1885	.373 .357	.331	.133 .122	.020 .010	.276	.016	.28	.075	.219
NAS1134	.2500-28 UNJF-3A	.2495 .2485	.492 .473	.424	.175 .162	.020 .010	.316	.018	.37	.098	.286
NAS1135	.3125-24 UNJF-3A	.3120 .3110	.615 .594	.518	.218 .203	.020 .010	.375	.021	.53	.122	.357
NAS1136	.3750-24 UNJF-3A	.3745 .3735	.740 .716	.611	.261 .244	.025 .015	.391	.021	.65	.145	.427
NAS1137	.4375-20 UNJF-3A	.4370 .4360	.863 .838	.706	.304 .286	.025 .015	.453	.025	.80	.169	.498
NAS1138	.5000-20 UNJF-3A	.4995 .4985	.987 .958	.801	.348 .327	.030 .020	.453	.025	.90	.193	.568

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

REVISION DATE: OCTOBER 31, 2014

ISSUE DATE: JUNE 1958

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 13
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, MACHINE, PAN HEAD, CLOSE TOLERANCE, SHORT THREAD, OFFSET CRUCIFORM	CLASSIFICATION PART STANDARD NAS1131 THRU NAS1138 SHEET 1 OF 5

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NO.	INSPECTION DATA						
	FIM VALUES			RECESS GAGE PENETRATION /3/		TORQUE IN-LBF MIN	TEST VALUES
	X /1/	Y /1/	Z /2/				MIN TENSILE STRENGTH, LBF
				MAX	MIN		ALLOY STEEL, TITANIUM, & CRES
NAS1131	.005	.0045	.0040	.0390	.0285	24	1,450
NAS1132	.005	.0045	.0040	.0470	.0355	37	2,240
NAS1133	.005	.0045	.0040	.0540	.0415	50	3,180
NAS1134	.006	.0045	.0030	.0695	.0555	125	5,820
NAS1135	.008	.006	.0030	.0860	.0700	250	9,200
NAS1136	.009	.006	.0025	.1030	.0850	430	14,000
NAS1137	.010	.006	.0025	.1205	.1005	925	18,900
NAS1138	.010	.006	.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.
- TITANIUM ALLOY - 6AL-4V (UNS R56400) PER AMS4928 OR AMS4967.

HEAT TREAT:

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

ALLOY STEEL: 160-180 KSI Ft_u
 CRES: 160-190 KSI Ft_u /24/
 TITANIUM ALLOY: 160 KSI Ft_u MIN

FINISH:

13

ALLOY STEEL CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 (NO CODE)
 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 WITH DULL BLACK CHROMATE TREATMENT ("B" CODE)

CRES PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4 (NO CODE)
 OR PASSIVATE IN ACCORDANCE WITH AMS2700 METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT ("M" CODE)
 OR PASSIVATE IN ACCORDANCE WITH AMS2700 METHOD 2 - NO POST TREATMENT ("G" CODE)
 OR CADMIUM PLATING PER AMS-QQ-P-416, TYPE II, CLASS 2 ("P" CODE) /18/

TITANIUM ALLOY NONE (NO CODE)
 OR ALUMINUM COAT PER NAS4006 ("A" CODE)
 OR ALUMINUM COAT PER MIL-DTL-83488, TYPE II, CLASS 3 ("C" CODE)
 OR ALUMINUM COAT PER NAS4006 - CLASS NC ("F" CODE)
 OR CADMIUM PLATING PER QQ-P-416, TYPE II, CLASS 2 (P CODE). /18/

13

REVISION

13

NAS1131 THRU
 NAS1138
 SHEET 2



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America Inc. THIS DOCUMENT IS PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
 Provided by IHS under license with AIA/NAS. Licensee= www.sepana.ir/5991803002, User=sam, albert
 No reproduction or networking permitted without license from IHS. Not for Resale, 01/04/2016 02:48:23 MST. TRADEMARKS RIGHTS.

Full document details: AIA NAS1131-1138 2014