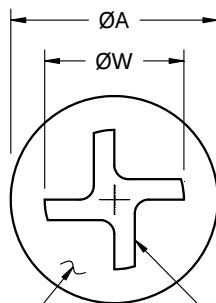


FED. SUPPLY CLASS

5305



OFFSET CRUCIFORM RECESS
PER MS33781

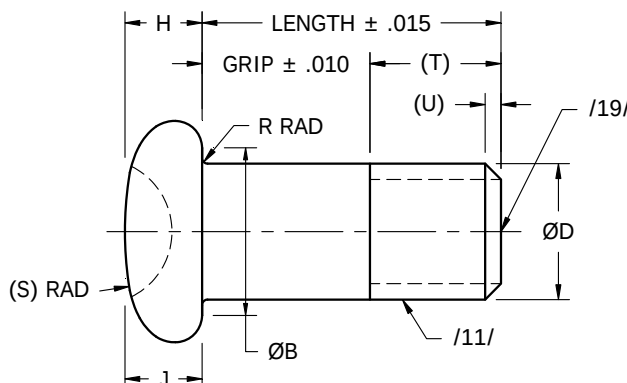


TABLE I – DIMENSIONS

BASIC PART NUMBER	THREAD /11/	ØD PLATED SHANK TYPE	ØA	ØB MIN	H	J MAX	R RAD	(S) RAD	(T)	(U)	ØW MAX
NAS1141	.1380-32 UNJC-3A	.1375 .1365	.276 .258	.242	.086 .074	.055	.010 .005	.190	.276	.016	.160
NAS1142	.1640-32 UNJC-3A	.1635 .1625	.331 .309	.289	.102 .088	.065	.020 .010	.230	.276	.016	.190
NAS1143	.1900-32 UNJF-3A	.1895 .1885	.385 .361	.331	.118 .103	.075	.020 .010	.264	.276	.016	.219
NAS1144	.2500-28 UNJF-3A	.2495 .2485	.493 .464	.424	.150 .133	.098	.020 .010	.320	.316	.018	.286
NAS1145	.3125-24 UNJF-3A	.3120 .3110	.601 .568	.518	.183 .162	.122	.020 .010	.390	.375	.021	.357
NAS1146	.3750-24 UNJF-3A	.3745 .3735	.709 .671	.611	.215 .191	.145	.025 .015	.460	.391	.021	.427
NAS1147	.4375-20 UNJF-3A	.4370 .4360	.817 .774	.706	.248 .221	.169	.025 .015	.530	.453	.025	.498
NAS1148	.5000-20 UNJF-3A	.4995 .4985	.924 .877	.801	.280 .250	.193	.030 .020	.600	.453	.025	.568

10 COMPLETELY REVISED

THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
10

PROCUREMENT
SPECIFICATION

NOTED

TITLE
**SCREW, MACHINE, PAN HEAD,
MODIFIED, CLOSE TOLERANCE,
SHORT THREAD, OFFSET CRUCIFORM**

CLASSIFICATION
PART STANDARD

**NAS1141
THRU NAS1148**

SHEET 1 OF 5

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

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.

FORM 09-01

REVISION DATE: OCTOBER 31, 2012

ISSUE DATE: JUNE 1958

TABLE I – DIMENSIONS (CONTINUED)

BASIC PART NUMBER	INSPECTION DATA						
	FIM VALUES			RECESS GAGE PENETRATION		TEST VALUES	
	X /1/	Y /1/	Z /2/	/3/		MIN TORQUE LBF-IN	MIN TENSILE STRENGTH LBF ALLOY STEEL, TITANIUM, CRES 160 KSI /17/
				MAX	MIN		
NAS1141	.005	.0045	.0040	.0390	.0285	30	1,450
NAS1142	.005	.0045	.0040	.0470	.0355	50	2,240
NAS1143	.005	.0045	.0040	.0540	.0415	60	3,180
NAS1144	.006	.0045	.0030	.0695	.0555	140	5,820
NAS1145	.008	.0060	.0030	.0860	.0700	220	9,200
NAS1146	.009	.0060	.0025	.1030	.0850	520	14,000
NAS1147	.010	.0060	.0025	.1205	.1005	750	18,900
NAS1148	.010	.0060	.0020	.1375	.1155	900	25,600

MATERIAL:

ALLOY STEEL – 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6349 OR AMS6382; 4340 (UNS G43400) PER AMS6415 OR AMS6484; E4340 (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) PER AMS5731, AMS5732, AMS5737 OR AMS5853.
TITANIUM – 6Al-4V (UNS R56400) PER AMS4928 OR AMS4967.

HEAT TREATMENT:

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 PRECIPITATION HARDENING PER AMS5853. /17/
TITANIUM (6Al-4V): 160 KSI Ft_u 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 CHROMATIC TREATMENT.
CRES – CLEAN AND PASSIVATE PER AMS2700, METHOD 1, CLASS 4; OR
CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
TITANIUM – NONE.

CODE:

DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE II)

MATERIAL CODE:

DASH DESIGNATES ALLOY STEEL
“E” IN LIEU OF DASH DESIGNATES A286 CRES
“V” IN LIEU OF DASH DESIGNATES 6Al-4V TITANIUM

FINISH CODE: FOLLOWS LENGTH DASH NUMBER

ALLOY STEEL:

NO CODE DESIGNATES TYPE II PLATING
“B” DESIGNATES TYPE II PLATING WITH DULL BLACK CHROMATE

CRES:

NO CODE DESIGNATES CLEAN AND PASSIVATE
“P” DESIGNATES TYPE II PLATING
~~“W” DESIGNATES TYPE I PLATING.~~

REVISION

10

NAS1141

THRU NAS1148

SHEET 2

⑩ COMPLETELY REVISED