

FED. SUPPLY CLASS

5305

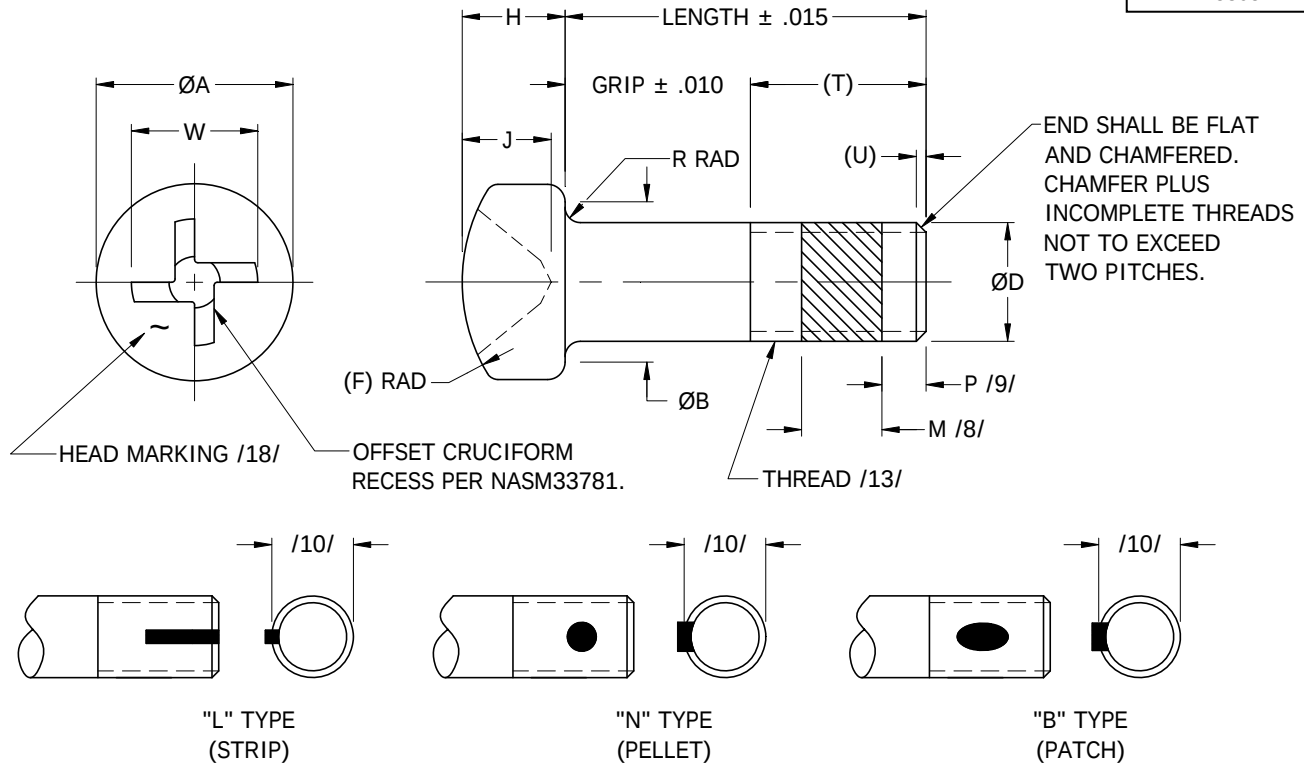


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /14/	ØD	ØA	ØB MIN	H	R RAD	(T)	(U)	(F) RAD	J MAX	W MAX
NAS1171	.1380-32 UNJC-3A	.1375 .1365	.270 .256	.242	.097 .087	.010 .005	.338	.016	.20	.055	.160
NAS1172	.1640-32 UNJC-3A	.1635 .1625	.322 .306	.289	.115 .105	.020 .010	.338	.016	.24	.065	.190
NAS1173	.1900-32 UNJF-3A	.1895 .1885	.373 .357	.331	.132 .122	.020 .010	.338	.016	.28	.075	.219
NAS1174	.2500-28 UNJF-3A	.2495 .2485	.492 .473	.424	.175 .162	.020 .010	.425	.018	.37	.098	.286
NAS1175	.3125-24 UNJF-3A	.3120 .3110	.615 .594	.518	.218 .203	.020 .010	.469	.021	.53	.122	.357
NAS1176	.3750-24 UNJF-3A	.3745 .3735	.740 .716	.611	.261 .244	.025 .015	.578	.021	.65	.145	.427
NAS1177	.4375-20 UNJF-3A	.4370 .4360	.863 .838	.706	.304 .286	.025 .015	.594	.025	.80	.169	.498
NAS1178	.5000-20 UNJF-3A	.4995 .4985	.987 .958	.801	.348 .327	.030 .020	.735	.025	.90	.193	.568

11 COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 11
PROCUREMENT SPECIFICATION	TITLE SCREW, SELF-LOCKING, PAN HEAD, SHEAR, OFFSET CRUCIFORM	CLASSIFICATION PART STANDARD
NOTED		NAS1171 THRU NAS1178 SHEET 1 OF 5

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	INSPECTION DATA							RAISED METAL INCH
	FIM VALUES			RECESS GAGE PENETRATION		TORQUE IN-LBF	TENSILE STRENGTH, LBF	
	X /1/	Y /1/	Z /2/	/3/			ALLOY STEEL AND CRES /17/	
				MAX	MIN	MIN	MAX	
NAS1171	.005	.0045	.0040	.0390	.0285	30	1,450	.005
NAS1172	.005	.0045	.0040	.0470	.0355	50	2,240	.005
NAS1173	.005	.0045	.0040	.0540	.0415	60	3,180	.005
NAS1174	.006	.0045	.0030	.0695	.0555	140	5,820	.005
NAS1175	.008	.006	.0030	.0860	.0700	220	9,200	.005
NAS1176	.009	.006	.0025	.1030	.0850	520	14,000	.006
NAS1177	.010	.006	.0025	.1205	.1005	750	18,900	.007
NAS1178	.010	.006	.0020	.1375	.1155	900	25,600	.008

MATERIAL:

- ALLOY STEEL - 4140 (UNS G41400) PER MIL-S-5626 AMS6382, 4340 (UNS G43406) PER AMS6415 OR AMS6484, ~~E4340 (UNS G43406) PER MIL-S-5000~~, 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.
- LOCKING ELEMENT - NYLON OR EQUIVALENT, COLOR PER MIL-DTL-18240, 250 °F MAX. POLYTRIFLUOROCHLOROETHYLENE UNPLASTICIZED (PCTFE) PER AMS3650, COLOR OPTIONAL, 390 °F MAX. POLYETHYLENE TEREPHTHALATE (POLYESTER) PER AMS3612, COLOR OPTIONAL, 400 °F MAX.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759.

ALLOY STEEL: 160-180 KSI Ft_u.

CRES: 160-190 KSI Ft_u. PRECIPITATION HARDENING PER AMS5853. /17/

FINISH:

- ALLOY STEEL NO CODE - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
"C" CODE - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 WITH DULL BLACK CHROMATE TREATMENT.
- CRES NO CODE - CLEAN AND PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.
"P" CODE - OPTIONAL CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- ~~PLATING THICKNESS MINIMUM TO BE .0003 INCH PER QQ-P-416, CLASS 2.~~

CODE:

DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE II).

"E" IN LIEU OF DASH DESIGNATES CRES.

"P" AFTER DASH NUMBER DESIGNATES TYPE II PLATING.

"C" AFTER DASH NUMBER DESIGNATES BLACKENED TYPE II PLATING.

SPECIFY TYPE OF LOCKING ELEMENT BY "L" FOLLOWING LAST DASH NUMBER FOR NYLON STRIP TYPE ELEMENT, BY "N" FOR NYLON PELLET TYPE, BY "B" FOR NYLON PATCH TYPE. OMIT IF TYPE OF ELEMENT FOR NYLON IS OPTIONAL.

SPECIFY "LK" FOR PCTFE STRIP TYPE ELEMENT, BY "NK" FOR PCTFE PELLET TYPE, BY "K" FOR PCTFE WITH OPTIONAL ELEMENT (PCTFE PATCH TYPE IS NOT AVAILABLE). NOTE THAT PCTFE LOCKING PERFORMANCE APPLICABLE FOR ONE TORQUE CYCLE.

SPECIFY "J" FOR POLYETHYLENE TEREPHTHALATE (POLYESTER) AVAILABLE ONLY AS PATCH TYPE ELEMENT.

LOCKING PERFORMANCE APPLICABLE FOR 15 TORQUE CYCLES.

REVISION

11

NAS1171 THRU
NAS1178
SHEET 2

11 COMPLETELY REVISED