

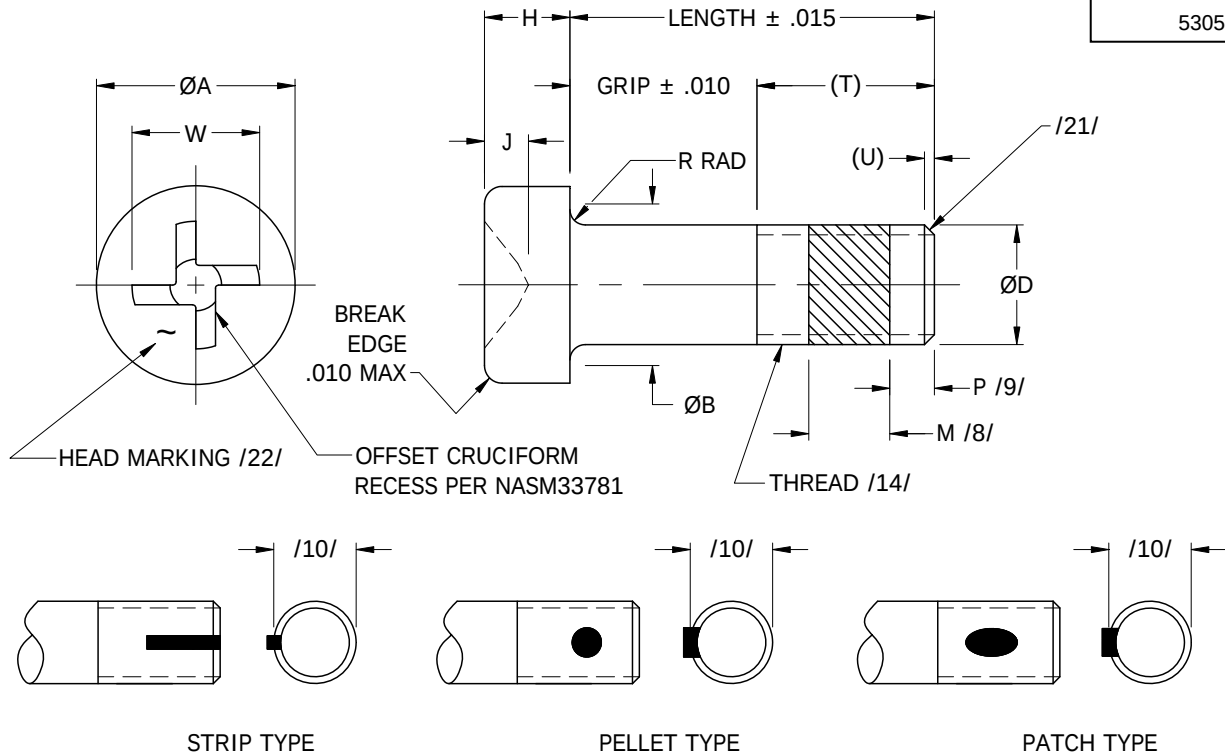


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /14/	ØD		ØA	ØB MIN	H	J MAX	R RAD	(T)	(U)
		PLATED	UNPLATED							
NAS1181	.1380-32 UNJC-3A	.1375 .1365	.1375 .1370	.226 .221	.211	.086 .074	.072	.010 .005	.338	.016
NAS1182	.1640-32 UNJC-3A	.1635 .1625	.1635 .1630	.270 .265	.255	.102 .088	.085	.020 .010	.338	.016
NAS1183	.1900-32 UNJF-3A	.1895 .1885	.1895 .1890	.313 .306	.296	.118 .103	.098	.020 .010	.338	.016
NAS1184	.2500-28 UNJF-3A	.2495 .2485	.2495 .2490	.375 .367	.357	.150 .133	.128	.020 .010	.425	.018
NAS1185	.3125-24 UNJF-3A	.3120 .3110	.3120 .3115	.438 .429	.413	.183 .162	.134	.020 .010	.469	.021
NAS1186	.3750-24 UNJF-3A	.3745 .3735	.3745 .3740	.563 .552	.536	.215 .191	.161	.025 .015	.578	.021
NAS1187	.4375-20 UNJF-3A	.4370 .4360	.4370 .4365	.625 .615	.595	.248 .221	.169	.025 .015	.594	.025
NAS1188	.5000-20 UNJF-3A	.4995 .4985	.4995 .4990	.750 .739	.719	.280 .250	.193	.030 .020	.735	.025

⑩ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 10
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, SELF-LOCKING, FLAT FILLISTER HEAD, CLOSE TOLERANCE, OFFSET CRUCIFORM	CLASSIFICATION PART STANDARD
		NAS1181 THRU NAS1188 SHEET 1 OF 5

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	W MAX	INSPECTION DATA							
		FIM VALUES			RECESS GAGE PENETRATION /11/		TEST VALUES		
		X /1/	Y /1/	Z /2/	MAX	MIN	TORQUE IN-LBF	RAISED METAL	TENSILE STRENGTH LBF MIN ALLOY STEEL, CRES 160 KSI /19/
							MIN	MAX	
NAS1181	.193	.005	.0045	.0040	.0555	.0450	30	.005	1,450
NAS1182	.228	.005	.0045	.0040	.0660	.0545	50	.005	2,240
NAS1183	.263	.005	.0045	.0040	.0760	.0635	60	.005	3,180
NAS1184	.345	.006	.0045	.0030	.0990	.0850	140	.005	5,820
NAS1185	.382	.008	.0060	.0030	.0985	.0825	220	.005	9,200
NAS1186	.457	.009	.0060	.0025	.1180	.1000	520	.006	14,000
NAS1187	.498	.010	.0060	.0025	.1205	.1005	750	.007	18,900
NAS1188	.568	.010	.0060	.0020	.1375	.1155	900	.008	25,600

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. POLYCHLOROTRIFLUOROETHYLENE UNPLASTICIZED (PCTFE) PER AMS3650, COLOR OPTIONAL, 390 °F MAX. POLYETHYLENE TEREPHTHALATE (POLYESTER) PER AMS3612, COLOR OPTIONAL, 400 °F MAX. SEE CODE.

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. /19/

FINISH:

- ALLOY STEEL NO CODE - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
"A" CODE - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 WITH DULL BLACK CHROMATE TREATMENT.
~~"W" CODE - TYPE I CADMIUM PLATE. SEE CODE.~~
- 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.

CODE:

- DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE II).
"E" IN LIEU OF DASH DESIGNATES A286 CRES (160 KSI).
"A" AFTER DASH NUMBER DESIGNATES BLACKENED TYPE II PLATING.
"P" AFTER DASH NUMBER DESIGNATES TYPE II PLATING.
~~"W" AFTER DASH NUMBER DESIGNATES TYPE I PLATING.~~

SPECIFY TYPE OF LOCKING ELEMENT BY

- "L" FOLLOWING LAST DASH NUMBER FOR NYLON STRIP TYPE.
"N" FOR NYLON PELLET TYPE.
"B" FOR NYLON PATCH TYPE.

REVISION

10

NAS1181 THRU
NAS1188

SHEET 2

10 COMPLETELY REVISED