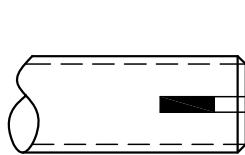
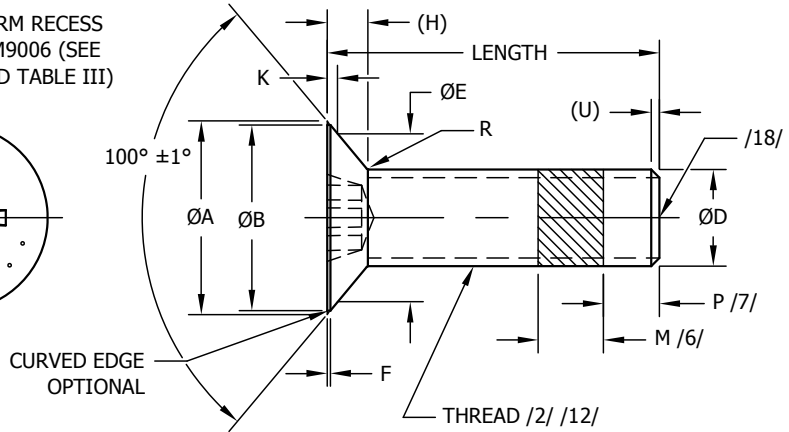
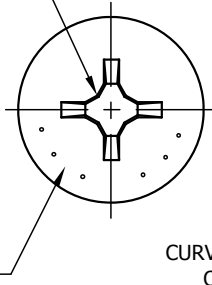
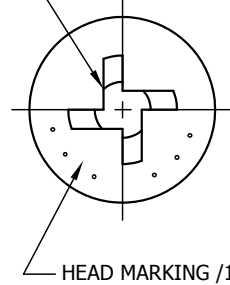


FED.SUPPLY CLASS

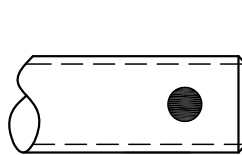
5305

OFFSET CRUCIFORM
RECESS PER NASM33781
OR NASM14191 (SEE
CODE AND TABLE III)

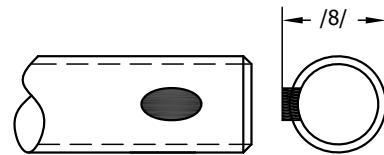
CRUCIFORM RECESS
PER NASM9006 (SEE
CODE AND TABLE III)



"L" TYPE
(STRIP)



"N" TYPE
(PELLET)



"B" TYPE
(PATCH)

TABLE I – DIMENSIONS AND STRENGTH VALUES

DIA DASH NO.	THREAD /12/	ØA	ØB MIN	ØD MAX	F	(H)	R RAD	(U)	K DIM	ØE DIM	TENSILE STRENGTH LBF MIN	
											CRES (140 KSI)	ALLOY STEEL CRES, TI 160 KSI /10/ /22/
02	.0860-56 UNJC-3A	.176 .162	.126	.086	.015 .005	.036	.015 .005	.010	--	--	390	435
04	.1120-40 UNJC-3A	.225 .213	.177	.112	.015 .005	.045	.015 .005	.013	--	--	655	765
06	.1380-32 UNJC-3A	.279 .267	.231	.138	.015 .005	.057	.020 .010	.016	--	--	990	1,200
08	.1640-32 UNJC-3A	.332 .319	.270	.164	.020 .010	.068	.020 .010	.016	.0268 .0240	.2671 .2667	1,530	1,950
3	.1900-32 UNJF-3A	.385 .371	.322	.190	.020 .010	.080	.020 .010	.016	.0290 .0263	.3147 .3143	2,180	2,860
4	.2500-28 UNJF-3A	.507 .491	.442	.250	.020 .010	.106	.020 .010	.018	.0342 .0316	.4245 .4241	3,980	5,520
5	.3125-24 UNJF-3A	.635 .617	.568	.312	.020 .010	.133	.020 .010	.021	.0395 .0370	.5389 .5385	6,330	9,200
6	.3750-24 UNJF-3A	.762 .742	.694	.375	.020 .010	.160	.020 .010	.021	.0450 .0426	.6532 .6528	9,580	14,000

⑭ COMPLETELY REVISED

THIRD
ANGLE
PROJECTION

PROCUREMENT
SPECIFICATION

NOTED

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

**SCREW, SELF-LOCKING, FLAT 100 DEG. HEAD,
CRUCIFORM AND OFFSET CRUCIFORM RECESS,
FULL THREAD**

⑭

REVISION

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CLASSIFICATION
PART STANDARD

NAS1189
SHEET 1 OF 5



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MATERIAL: ALLOY STEEL – 4140 (UNS G41400) PER MIL-S-5626, AMS6349 OR AMS6382, 4340 (UNS G43406) PER MIL-S-5000, AMS6415 OR AMS6484, 6150 (UNS G61500) PER MIL-S-8503, 8735 (UNS G87350) PER MIL-S-6098 OR 8740 (UNS G87400) PER MIL-S-6049 OR AMS6322 OR AMS6325 OR AMS6327

CRES – A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853 DESIGNATED BY "E" CODE. CRES PER AMS5735 (A286) EXCEPT FOR HEAT TREATMENT, DESIGNATED BY "C" PER CODE.

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

LOCKING ELEMENT: NYLON OR EQUIVALENT, COLOR PER MIL-DTL-18240, 250 DEGREE F MAX. POLYCHLOROTRIFLUOROETHYLENE UNPLASTICIZED (PCTFE) PER AMS3650, COLOR OPTIONAL, 390 DEGREE F MAX. POLYETHYLENE TEREPHTHALATE (POLYESTER) PER AMS3612, OR POLYAMIDE-IMIDE PER AMS3670, 400 DEGREES F MAX, COLOR OPTIONAL.

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: 140 KSI UTS MIN. AT ROOM TEMPERATURE: /11/
CRES: 160-190 KSI Ft_u /22/
TITANIUM (6AL-4V): 160 KSI Ft_u MIN

FINISH: ALLOY STEEL – CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. OPTIONAL TYPE I PLATING DESIGNATED BY "W", SEE CODE.
CRES – CLEAN AND PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4. OPTIONAL CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, DESIGNATED BY "H" PER CODE.
TITANIUM – NONE OR ALUMINUM COAT PER NAS4006

CODE: DIA DASH NUMBER DESIGNATES DIAMETER AND THREAD.
USE "P" FOR CRUCIFORM RECESS PER NASM9006 OR "T" FOR OFFSET CRUCIFORM RECESS PER NASM33781 OR "R" FOR RIBBED OFFSET CRUCIFORM RECESS PER NASM14191 BETWEEN DIA AND LENGTH DASH NUMBERS; "R" CODE, APPLIES TO SIZES 06 THRU 5 INCLUSIVE ONLY.
LENGTH DASH NUMBER INDICATES LENGTH IN .0625 INCREMENTS (CONVERTED TO THREE DECIMAL PLACES PER ANSI/ASME Y14.5M). INTERMEDIATE OR LONGER LENGTHS MAY BE SPECIFIED BY USE OF WHOLE DASH NUMBER ONLY. USE OF .25 INCH INCREMENTS IS RECOMMENDED FOR SCREWS OVER 3 INCHES LONG.

"-" AFTER BASIC PART NUMBER DESIGNATES ALLOY STEEL WITH TYPE II CADMIUM PLATING.
"C" IN LIEU OF FIRST DASH DESIGNATES CRES (140 KSI).
"E" IN LIEU OF FIRST DASH DESIGNATES CRES (160 KSI).
"V" IN LIEU OF FIRST DASH DESIGNATES TITANIUM ALLOY.

"A" AFTER LENGTH DASH NUMBER DESIGNATES ALUMINUM COATING (APPLICABLE TO CRES AND TI ONLY).
"H" AFTER LENGTH DASH NUMBER DESIGNATES TYPE II PLATING. (APPLICABLE TO CRES ONLY).
"W" FOLLOWING LENGTH DASH NUMBER DESIGNATES TYPE I PLATING. (APPLICABLE TO ALLOY STEEL ONLY).

SPECIFY TYPE OF LOCKING ELEMENT BY "L" FOLLOWING LENGTH 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) OR POLYAMIDE-IMIDE AVAILABLE ONLY AS PATCH TYPE ELEMENT. LOCKING TORQUE APPLICABLE FOR ± 5 TORQUE CYCLES.

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SHEET 2



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