

FED. SUPPLY CLASS

5305

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

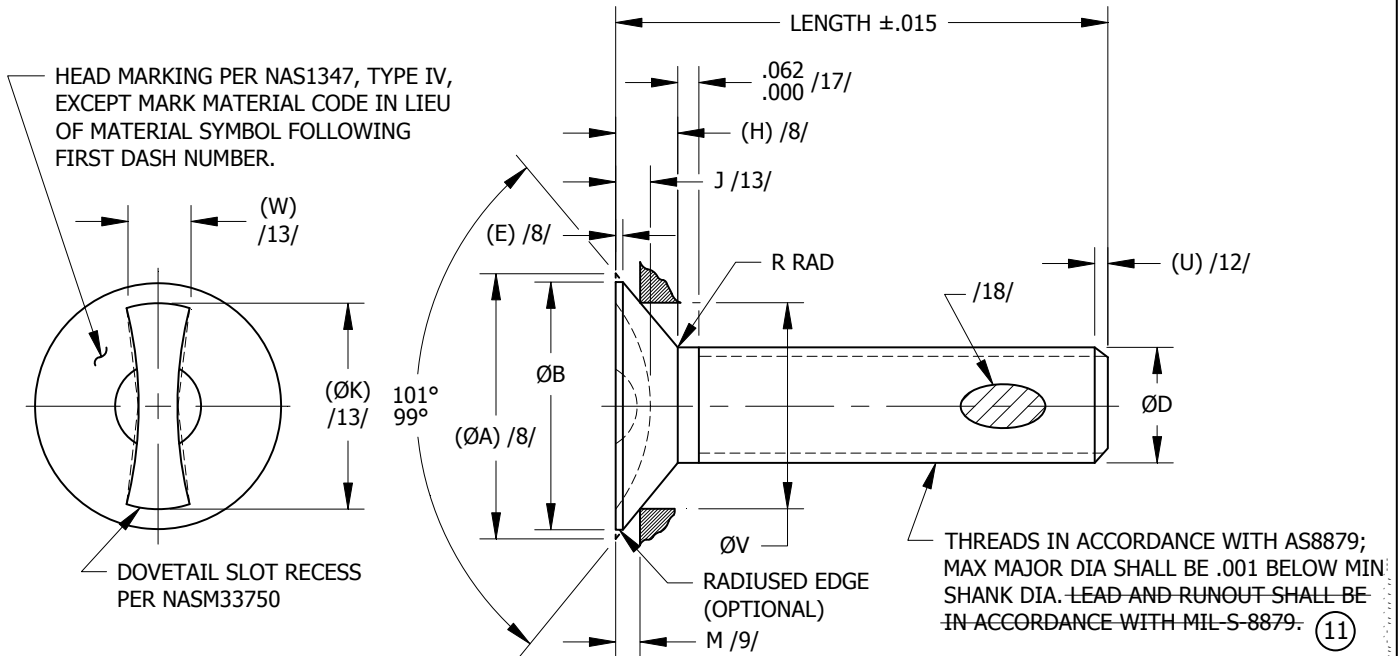


TABLE I – DIMENSIONS

11

FIRST DASH NO	THREAD	(ØA) /8/	ØB MIN	ØD MAX	(E) /8/	(H) /8/	M GAGE PROT /9/	R RAD	(U) /12/	ØV GAGE	Y FIM /10/	Z FIM /11/	RECESS NO	J /13/	(ØK) /13/	(W) /13/
04	.1120-40 UNJC-3A	.225	.194	.1120	.012	.049	.0227 .0193	.012 .005	.050	.1720 .1718	.005	.0040	1	.030 .026	.190	.084
06	.1380-32 UNJC-3A	.279	.244	.1380	.014	.060	.0255 .0195	.012 .005	.050	.2195 .2193	.005	.0040	1	.043 .039	.225	.088
08	.1640-32 UNJC-3A	.332	.294	.1640	.015	.072	.0278 .0195	.015 .005	.050	.2671 .2669	.005	.0040	2	.053 .050	.265	.100
3	.1900-32 UNJF-3A	.385	.344	.1900	.016	.083	.0302 .0232	.015 .005	.050	.3147 .3145	.005	.0040	3	.045 .042	.305	.110
4	.2500-28 UNJF-3A	.507	.461	.2500	.018	.110	.0343 .0273	.015 .005	.060	.4245 .4243	.006	.0030	4	.054 .051	.422	.134
5	.3125-24 UNJF-3A	.635	.583	.3120	.020	.139	.0412 .0322	.020 .010	.060	.5389 .5387	.008	.0030	5	.064 .061	.490	.160
6	.3750-24 UNJF-3A	.762	.703	.3750	.023	.166	.0466 .0366	.020 .010	.080	.6532 .6530	.009	.0025	6	.088 .084	.639	.198

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: APRIL 30, 2014

ISSUE DATE: SEPTEMBER 1958

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 11
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, 100° FLUSH HEAD, DOVETAIL SLOT RECESS, FULL THREAD, SELF-LOCKING OPTIONAL	CLASSIFICATION PART STANDARD



NAS1219
SHEET 1 OF 4
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MATERIAL:	(11)	ALLOY STEEL - 4140 (UNS G41400) PER ~~AMS6349~~ OR AMS6382, 4340 (UNS G43406) PER AMS6415 OR AMS6484, ~~E4340 (UNS G43406) PER AMS6415 OR AMS6484,~~ OR 8740 (UNS G87400) PER AMS6322, AMS6325 OR AMS6327.
	(11)	CRES - A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853 /19/ ~~302 CRES, CONDITION B OR 305 CRES PER QQ-S-763 /16/~~
	(11)	TITANIUM ALLOY - 6AL-4V (UNS R56400) PER AMS4928 OR AMS4967. LOCKING ELEMENT, NYLON OR EQUIVALENT PER MIL-DTL-18240.
HEAT TREAT:		DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER ~~AMS-H-6875~~ AMS2759 FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM:
		ALLOY STEEL: 160 - 180 KSI Ft _u .
		A286 CRES: 160 - 190 KSI Ft _u . PRECIPITATION HARDENING PER AMS5853 /19/ ~~302 OR 305 CRES: 125,000 PSI MINIMUM TENSILE STRENGTH.~~
		6AL-4V TI: 160 KSI Ft _u MIN
FINISH:		ALLOY STEEL: CADMIUM PLATE PER AMS-QQ-P-416, ~~TYPE I, CLASS 3, TYPE II, CLASS 2, TYPE II, CLASS 3, OR TYPE II, CLASS 2 WITH BLACK FINISH PER UNICHROME DIP BULLETIN 65-B Cd (SEE "CODE").~~ OR TYPE II, CLASS 2 WITH DULL BLACK CHROMATE TREATMENT (SEE CODE).
	(11)	CRES: PASSIVATE PER AMS2700, METHOD 1, CLASS 4 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. (SEE "CODE").
		~~302 OR 305 CRES: PASSIVATE PER QQ-P-35.~~
	(11)	TITANIUM (6AL-4V): NO FINISH
CODE:		SECOND DIGIT OF FIRST DASH NUMBER FOR -04, -06 & -08 SIZES INDICATE THREAD NUMBER SIZE. FOR SIZES ABOVE -08, FIRST DASH NUMBER INDICATES NOMINAL DIAMETER IN 16THS. SECOND DASH NUMBER INDICATES OVERALL LENGTH IN .0625 INCREMENTS. ~~(CONVERTED TO THREE DECIMAL PLACES PER ANSI Y14.5M).~~ IF MORE THAN ONE CODE LETTER IS USED IN SEQUENCE, ARRANGE THE LETTERS ALPHABETICALLY.
MATERIAL:	(11)	NO CODE LETTER FOLLOWING FIRST DASH NUMBER INDICATES ALLOY STEEL. ~~CODE LETTER "CR" FOLLOWING FIRST DASH NUMBER INDICATES 302 OR 305 CRES. /16/~~ CODE LETTER "E" FOLLOWING FIRST DASH NUMBER INDICATES 160 KSI A286 CRES. CODE LETTER "V" FOLLOWING FIRST DASH NUMBER INDICATES 6AL-4V TITANIUM.
FINISH:		ALLOY STEEL: CODE LETTER "B" FOLLOWING SECOND DASH NUMBER INDICATES TYPE II, CLASS 2 CADMIUM PLATE WITH DULL BLACK CHROMATE FINISH. NO CODE LETTER FOLLOWING DASH NUMBER INDICATES TYPE II, CLASS 2 CADMIUM PLATE WITH STANDARD CHROMATE TREATMENT.
	(11)	CRES: NO CODE LETTER FOLLOWING DASH NUMBER INDICATES PASSIVATE PER AMS2700, METHOD 1, CLASS 4. CODE LETTER "P" FOLLOWING SECOND DASH NUMBER INDICATES TYPE II, CLASS 2 CADMIUM PLATE.
		SELF-LOCKING: CODE LETTER "L" FOLLOWING SECOND DASH NUMBER DESIGNATES A SELF-LOCKING BOLT.

REVISION

11



NAS1219
SHEET 2

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