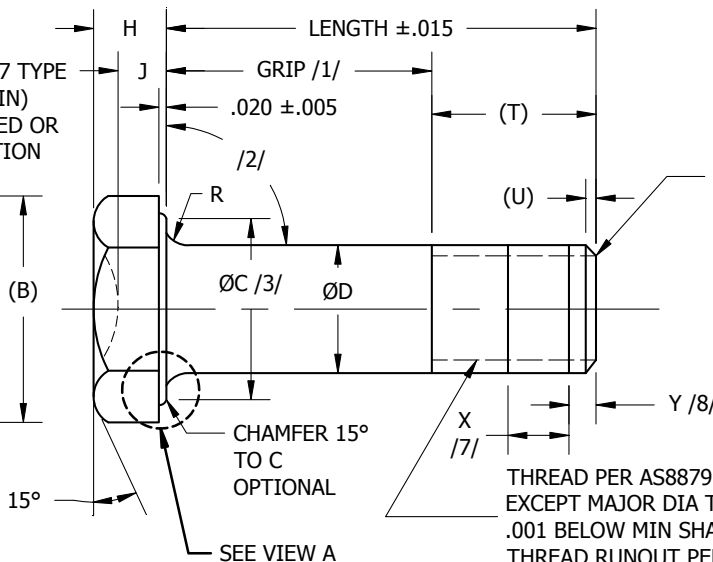
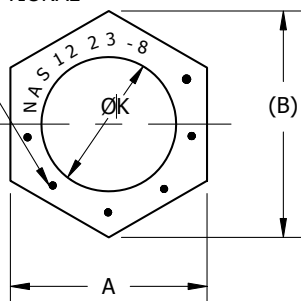
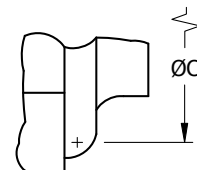


⑤ COMPLETELY REVISED

HEAD MARKING PER NAS1347 TYPE IV PLUS A CIRCLE OF SIX (MIN) DOTS WHEN POSSIBLE RAISED OR DEPRESSED .010 MAX LOCATION OPTIONAL

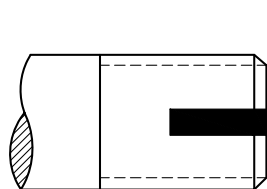


POINT SHALL BE FLAT AND CHAMFERED. CHAMFER U. CHAMFER PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES

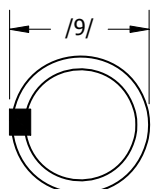


THREAD PER AS8879 EXCEPT MAJOR DIA TO BE .001 BELOW MIN SHANK DIA. THREAD RUNOUT PER NASM7838

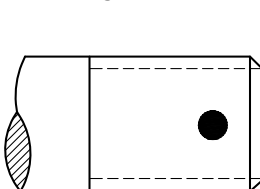
VIEW A



L TYPE (STRIP)



N TYPE (BUTTON)

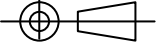


P TYPE (PATCH)

TABLE I - DIMENSIONS

BASIC NUMBER	THREAD UNJF-3A /13/	A	(B) /4/	ØC MIN /3/	ØD		H +.015 - .000	J +.015 - .000	ØK ±.01	R RAD	(T) /4/	(U) /4/	INSPECTION DATA		
					AFTER PLATE	WITHOUT PLATE							E /5/	F /5/	Z /6/
NAS1223	.1900-32	.376 .367	.43	.335	.1895 .1885	.1895 .1890	.110	.073	.19	.020 .010	.338	.016	.005		.0040
NAS1224	.2500-28	.439 .430	.51	.398	.2495 .2485	.2495 .2490	.125	.083	.25	.020 .010	.425	.018	.006	.0045	.0030
NAS1225	.3125-24	.502 .492	.58	.460	.3120 .3110	.3120 .3115	.156	.104	.31	.020 .010	.469	.021	.008		.0030
NAS1226	.3750-24	.564 .553	.65	.523	.3745 .3735	.3745 .3740	.188	.125	.38	.025 .015	.578	.021	.009		.0025
NAS1227	.4375-20	.690 .679	.79	.648	.4370 .4360	.4370 .4365	.219	.146	.44	.025 .015	.594	.025	.010	.006	.0025
NAS1228	.5000-20	.752 .741	.87	.710	.4995 .4985	.4995 .4990	.250	.167	.50	.030 .020	.735	.025	.011		.0020
NAS1229	.5625-18	.877 .865	1.01	.835	.5615 .5605	.5615 .5610	.281	.188	.56	.035 .020	.840	.028	.012	.006	
NAS1230	.6250-18	.940 .928	1.09	.898	.6240 .6230	.6240 .6235	.312	.208	.62	.040 .025	.902	.028	.015	.006	.0020
NAS1231	.7500-16	1.064 1.052	1.23	1.023	.7490 .7480	.7490 .7485	.375	.250	.75	.045 .030	1.041	.031	.018	.009	
NAS1232	.8750-14	1.252 1.239	1.44	1.210	.8740 .8730	.8740 .8735	.438	.292	.88	.050 .035	1.184	.036	.020		
NAS1233	1.0000-12	1.440 1.427	1.66	1.398	.9990 .9980	.9990 .9985	.500	.333	1.00	.060 .045	1.309	.042	.022	.009	.0020
NAS1234	1.1250-12	1.627 1.614	1.88	1.585	1.1240 1.1225	1.1240 1.1230	.562	.375	1.12	.070 .055	1.458	.042	.025		
NAS1235	1.2500-12	1.815 1.801	2.10	1.772	1.2490 1.2475	1.2490 1.2480	.625	.417	1.25	.075 .060	1.646	.042	.028	.012	.0020

THIRD ANGLE PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
5

PROCUREMENT SPECIFICATION

TITLE

⑤

CLASSIFICATION
PART STANDARD

NOTED

BOLT, SHEAR, HEXAGON HEAD, SELF-LOCKING

NAS1223 THRU NAS1235
SHEET 1 OF 5



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MATERIAL:

ALLOY STEEL PER ~~MIL-B-7838~~ NASM7838. SEE PROCUREMENT SPECIFICATION.
CRES: A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF ~~AMS5735~~ AMS5731, AMS5732,
AMS5737 OR AMS5853, EXCEPT FOR HEAT TREATMENT.
LOCKING ELEMENT: NYLON OR EQUIVALENT.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759:
ALLOY STEEL: 160-180 KSI UTS, 36-40 HRC.
CRES: 140 KSI UTS MIN AT ROOM TEMPERATURE.

FINISH:

ALLOY STEEL: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. TYPE I PLATING DESIGNATED
BY "W", SEE CODE.
CRES: NONE.
PARTS WITH CLASS 3 PLATING MAY BE SUPPLIED UNTIL 31 MAY 1976.

CODE:

ADD "W" FOLLOWING GRIP DASH NUMBER FOR TYPE I PLATING.
"C" IN LIEU OF FIRST DASH DESIGNATES CRES.
SPECIFY TYPE OF LOCKING ELEMENT BY CODE FOLLOWING LAST DASH NUMBER:
"L" INDICATES STRIP TYPE ELEMENT.
"N" INDICATES BUTTON TYPE.
"P" INDICATES PATCH TYPE.
OMIT IF TYPE OF ELEMENT IS OPTIONAL.

EXAMPLE OF PART NUMBER:

NAS1228-10L = BOLT, SELF-LOCKING, .5000-20 THREAD, ALLOY STEEL, .625 GRIP, STRIP TYPE
LOCKING ELEMENT.
NAS1228C10N = BOLT, SELF-LOCKING, .5000-20 THREAD, CRES, .625 GRIP, BUTTON TYPE LOCKING
ELEMENT.
NAS1228C10P = BOLT, SELF-LOCKING, .5000-20 THREAD, CRES, .625 GRIP, PATCH TYPE LOCKING
ELEMENT.
NAS1228-10W = BOLT, SELF-LOCKING, .5000-20 THREAD, ALLOY STEEL, .625 GRIP, OPTIONAL
LOCKING ELEMENT, TYPE I PLATING.

NOTES:

- /1/ GRIP LENGTH: FROM UNDER SIDE OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
- /2/ BEARING SURFACE SQUARENESS: WITHIN .003 FIM WITH SHANK.
- /3/ WASHER FACE DIAMETER: MAX NOT TO EXCEED ACTUAL WIDTH ACROSS FLATS; MINIMUM AS
TABULATED ABOVE.
- /4/ REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT AN INSPECTION
REQUIREMENT.

REVISION

5

NAS1223 TURN
NAS1235
SHEET 2

⑤ COMPLETELY REVISED



Documents

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