

FED. SUPPLY CLASS

5315

HEAD MARKING: MANUFACTURER'S TRADEMARK AND BASIC PART NUMBER. MARK "J" TO INDICATE H-11 STEEL, "R" TO INDICATE NICKEL BASE ALLOY WITH OVERSIZE DESIGNATION AND FINISH CODE WHERE APPLICABLE. DEPRESSED DEPTH .010 MAX. "NAS" MAY BE OMITTED.

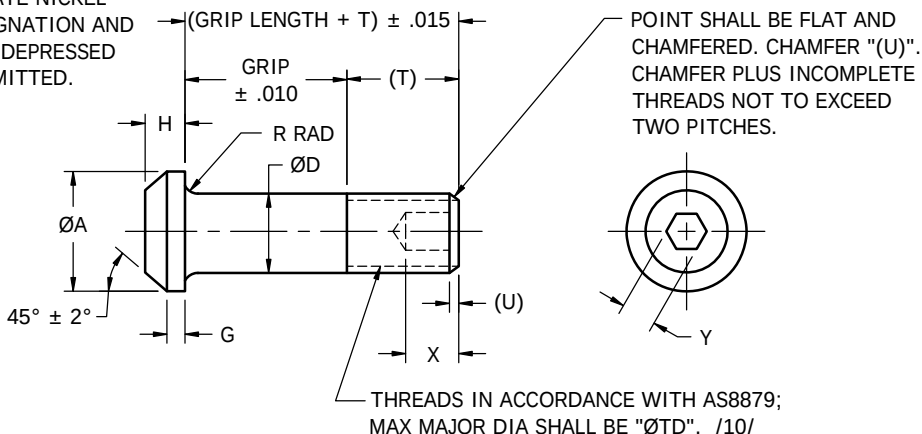


TABLE I – DIMENSIONS

BASIC PART NO.	THREAD	ØD		ØA	G ±.010	H	R RAD	(T) /12/	(U) /12/	X ±.010	Y	ØTD	Z STRAIGHT- NESS /11/	DOUBLE SHEAR STRENGTH (LBF)	
		PLATED SHANK TYPE	WITHOUT PLATE											H-11	NICKEL BASE ALLOY
NAS1322	.1640-32 UNJC-3A	.1635 .1625	.1635 .1630	.262 .242	.020	.047 .037	.020 .010	.308	.016	.094	.0635 .0625	.1595 .1570	.0040	6,400	4,100
NAS1323	.1900-32 UNJF-3A	.1895 .1885	.1895 .1890	.315 .295	.025	.055 .045	.020 .010	.328	.016	.109	.0791 .0781	.1840 .1810	.0040	8,700	5,600
NAS1324	.2500-28 UNJF-3A	.2495 .2485	.2495 .2490	.412 .387	.030	.069 .059	.020 .010	.377	.018	.125	.1270 .1250	.2440 .2410	.0030	15,300	9,800
NAS1325	.3125-24 UNJF-3A	.3120 .3110	.3120 .3115	.505 .475	.035	.078 .068	.020 .010	.429	.021	.156	.1582 .1562	.3060 .3020	.0030	23,900	15,300
NAS1326	.3750-24 UNJF-3A	.3745 .3735	.3745 .3740	.600 .565	.040	.088 .078	.025 .015	.469	.021	.156	.1895 .1875	.3680 .3640	.0025	34,500	22,000

MATERIAL:

H-11 ALLOY STEEL – (UNS T20811) PER AMS6485 AMS6487

NICKEL BASE ALLOY – (UNS N07041) PER AMS5712

HEAT TREATMENT:

H-11: 156 KSI MINIMUM SHEAR, 260-280 KSI TENSILE PER NAS1511

NICKEL BASE ALLOY: 100 KSI MINIMUM SHEAR, 170 KSI MIN TENSILE PER AMS5712

④ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION NOTED	TITLE PIN, THREADED, SHEAR, PROTRUDING HEAD	CLASSIFICATION PART STANDARD
		NAS1322 THRU NAS1326 SHEET 1 OF 3

FINISH:

H-11, NO CODE – NICKEL-ZINC ALLOY PLATE AND HYDROGEN EMBRITTLEMENT RELIEF PER AMS2417. THE INTERIOR OF HEX TO BE PAINTED WITH ALUMINUM SILICONE PAINT AND THE PIN BAKED ONE HOUR AT 375 °F TO 400 °F.

H-11, "P" CODE – DIFFUSED NICKEL-CADMIUM PLATE PER AMS2416
NICKEL BASE ALLOY, NO CODE – NO PROTECTIVE FINISH REQUIRED

CODE:

PINS WITH OVERSIZE SHANKS WILL BE IDENTIFIED BY NUMBERS "1" OR "2", SIGNIFYING .0156 OR .0312 .OVERSIZE RESPECTIVELY, FOLLOWING A DASH AFTER THE BASIC PART NUMBER.

"J" AFTER THE BASIC NUMBER (OR AFTER THE OVERSIZE DASH NUMBER) DESIGNATES H-11 ALLOY STEEL.

"R" AFTER THE BASIC NUMBER (OR AFTER THE OVERSIZE DASH NUMBER) DESIGNATES NICKEL BASE ALLOY.

THE DASH NUMBER FOLLOWING THE MATERIAL CODE "J" OR "R" INDICATES GRIP IN .0625 INCREMENTS.

"P" SUFFIX TO THE LAST DASH NUMBER DESIGNATES DIFFUSED NICKEL-CADMIUM PLATING.

EXAMPLE OF PART NUMBER:

NAS1323J2 = Ø.1900 PIN, .1250 GRIP, H-11 ALLOY STEEL, NICKEL-ZINC PLATING

NAS1324R3 = Ø.2500 PIN, .1875 GRIP, NICKEL BASE ALLOY

NAS1325-1R6 = Ø.3125 PIN, .0156 OVERSIZE SHANK, .3750 GRIP NICKEL BASE ALLOY (NOT TO BE SPECIFIED ON ENGINEERING DRAWING).

NAS1326J8P = Ø.3750 PIN, .5000 GRIP, H-11 ALLOY STEEL, DIFFUSED NICKEL-CADMIUM PLATING

NOTES:

- (1) CONCENTRICITY: "ØA" AND "ØD" DIAMETERS WITHIN .008 FIM; "ØD" AND THREAD PITCH WITHIN .005 FIM.
- (2) SURFACE ROUGHNESS: "ØD", UNDERSIDE OF HEAD, SIDES AND ROOT OF THREADS: 32 MICROINCHES Ra; ALL OTHER SURFACES: 125 MICROINCHES Ra PER ASME B46.1.
- (3) GRIP LENGTH: FROM UNDERSIDE OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (5) TEMPERATURE LIMITATION: H-11: 800 °F MAX.
NICKEL BASE ALLOY: 1,400 °F MAX.
- (6) RECOMMENDED MATING NUT: H-11: NAS1287 OR NAS1288 WITH NAS1288W WASHER
NICKEL BASE ALLOY: NAS1287C OR NAS1288C WITH NAS1288CW
WASHER
- (7) FOR SELECTION PURPOSES, THE GRIP RANGE IS FROM THE GRIP LENGTH TO THE GRIP LENGTH MINUS .062.
- (8) THE OVERSIZE PINS ARE FOR REPAIR PURPOSES ONLY AND SHALL NOT BE SPECIFIED ON ENGINEERING DRAWINGS.
- (9) USE WASHERS ON OVERSIZE PINS TO PREVENT NUT INTERFERENCE.

④ COMPLETELY REVISED

REVISION

4

NAS1322 THRU
NAS1326

SHEET 2



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