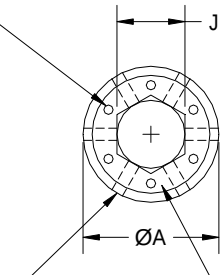


FED. SUPPLY CLASS

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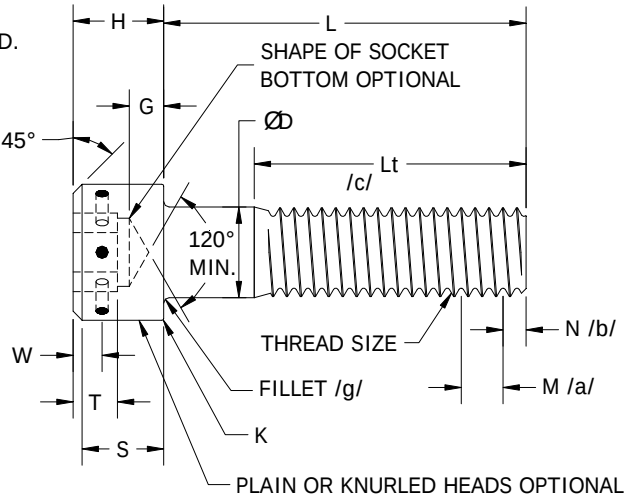
WHEN SELF-LOCKING ELEMENT IS SPECIFIED:
HEAD MARKING OF A MINIMUM OF SIX (6)
DOTS, RAISED OR DEPRESSED, IS REQUIRED.
TOP OR SIDE LOCATION OPTIONAL.
(SCREW SIZES 04 AND LARGER)



ØB
FOR NUMBER OF HOLES,
SEE NOTE /d/

IDENTIFICATION
SEE NOTE /e/

30° TO 45°
/f/



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TABLE I

NOMINAL SIZE DASH NO.	THREAD SIZE	ØD BODY DIAMETER		ØA HEAD DIAMETER		H HEAD HEIGHT		S HEAD SIDE HEIGHT	J SOCKET SIZE	T KEY ENGAGEMENT	G WALL THICKNESS	K CHAMFER OR RADIUS
		MAX.	MIN.	MAX.	MIN.	MAX.	MIN.					
00	.0600-80	.060	.0568	.096	.091	.060	.057	.054	.050	.025	.020	.003
01	.0730-72	.073	.0695	.118	.112	.073	.070	.066	.062	.031	.025	.003
02	.0860-64	.086	.0822	.140	.134	.086	.083	.077	.078	.038	.029	.003
03	.0990-56	.099	.0949	.161	.154	.099	.095	.089	.078	.044	.034	.003
04	.1120-48	.112	.1075	.183	.176	.112	.108	.101	.094	.051	.038	.005
06	.1380-40	.138	.1329	.226	.218	.138	.134	.124	.109	.064	.047	.005
08	.1640-36	.164	.1585	.270	.262	.164	.159	.148	.141	.077	.056	.005
3	.1900-32	.190	.1840	.312	.303	.190	.185	.171	.156	.090	.065	.005
4	.2500-28	.250	.2435	.375	.365	.250	.244	.225	.188	.120	.095	.008
5	.3125-24	.3125	.3053	.469	.457	.312	.306	.281	.250	.151	.119	.008
6	.3750-24	.375	.3678	.562	.550	.375	.368	.337	.312	.182	.143	.008
7	.4375-20	.4375	.4294	.656	.642	.437	.430	.394	.375	.213	.166	.010
8	.5000-20	.500	.4919	.750	.735	.500	.492	.450	.375	.245	.190	.010
10	.6250-18	.625	.6163	.937	.921	.625	.616	.562	.500	.307	.238	.010
12	.7500-16	.750	.7406	1.125	1.107	.750	.740	.675	.625	.370	.285	.010
14	.8750-14	.875	.8647	1.312	1.293	.875	.864	.787	.750	.432	.333	.015
16	1.0000-12	1.000	.9886	1.500	1.479	1.000	.988	.900	.750	.495	.380	.015

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ARLINGTON, VA 22209

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: OCTOBER 31, 2014

ISSUE DATE: APRIL 1962

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 11
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, CAP, SOCKET HEAD, UNDRILLED AND DRILLED, PLAIN AND SELF-LOCKING, ALLOY STEEL, CORROSION-RESISTANT STEEL AND HEAT-RESISTANT STEEL. UNRF-3A	CLASSIFICATION PART STANDARD
		NAS1351 SHEET 1 OF 6

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TABLE II

NOMINAL SIZE DASH NO.	L _t MINIMUM BASIC THREAD LENGTH /c/	SAFETY WIRE HOLE WHEN SPECIFIED				MINIMUM BREAKING STRENGTH (LBF)		
		W DRILLED HOLE LOCATION		ØB DRILLED HOLE /d/		ALLOY STEEL	CORROSION RESISTANT STEEL	HEAT RESISTANT STEEL
		MAX.	MIN.	MAX.	MIN.			
00	.500					324	140	288
01						500	220	445
02	.625	/d/	/d/	/d/	/d/	710	310	631
03						940	420	836
04	.750	.040	.026	.039	.033	1,190	530	1,058
06		.050	.035			1,820	810	1,620
08	.875	.060	.040			2,650	1,180	2,360
3		.065	.045	.050	.044	3,600	1,600	3,200
4	1.000	.085	.065			~~6,200~~ 6,550 /h/	2,910	5,820
5	1.125	.104	.084			~~9,850~~ 10,400 /h/	4,640	9,280
6	1.250	.123	.103			~~14,900~~ 15,800 /h/	7,020	14,080
7	1.375	.141	.121	.067	.061	~~20,200~~ 21,400 /h/	9,500	19,000
8	1.500	.160	.140			~~27,000~~ 28,800 /h/	12,800	25,600
10	1.750	.198	.178			43,500	20,500	41,000
12	2.000	.235	.215			63,400	26,100	59,700
14	2.250	.273	.253	.097	.091	86,500	35,600	81,400
16	2.500	.310	.290			113,000	46,400	106,200

/a/ "M" MIN. (5 THREAD PITCHES) = REGION OF MINIMUM ENGAGEMENT WITH FULL FEMALE THREAD REQUIRED TO MEET MIL-DTL-18240 REQUIREMENTS.

11 LOCKING ELEMENT WITHIN "M" REGION MUST DEVELOP REQUIRED TORQUE WHEN TESTED IN ACCORDANCE WITH MIL-DTL-18240.
LENGTH OR DIAMETER OF LOCKING ELEMENT MAY BE MORE OR LESS THAN "M" PROVIDING ALL OTHER REQUIREMENTS ARE MET.

/b/ "N" = ONE (1) COMPLETE THREAD PLUS UNTHREADED PORTION OF END. FOR EASE OF STARTING, LOCKING ELEMENT SHALL NOT BE EFFECTIVE WITHIN THIS AREA.

/c/ SCREWS WHICH HAVE A LENGTH LESS THAN THE MINIMUM BASIC THREAD LENGTH, SHALL BE THREADED AS CLOSE TO HEAD AS PRACTICABLE. FOR SCREWS WHICH HAVE A LENGTH GREATER THAN THE MINIMUM BASIC THREAD LENGTH, THE BODY AND GRIP LENGTH SHALL BE IN ACCORDANCE WITH ASME B18.3.

/d/ DRILLED HOLE DATA IN ACCORDANCE WITH PROCUREMENT SPEC FF-S-86.
PARTS SHALL HAVE DRILLED HEADS IF SPECIFIED BY CODE H.
SCREW SIZES 04 AND 06 SHALL HAVE TWO (2) DRILLED HOLES SPACED 180°.
SCREW SIZES 08 THRU 16 SHALL HAVE SIX (6) DRILLED HOLES SPACED 60°.
(DRILLED HOLES NOT APPLICABLE TO SCREW SIZES BELOW 04).

/e/ IDENTIFICATION LETTER "N" IMPRESSED ON THE TOP OR SIDE OF THE HEAD, FOR SCREW SIZES 04 AND LARGER ONLY, TO DENOTE HEAT-RESISTANT STEEL.

/f/ THE INTERSECTION OF THE TOP AND SIDE OF THE HEAD MAY BE CHAMFERED OR RADIUS AT THE MANUFACTURER'S OPTION PER ASME B18.3.

/g/ THE FILLET SHALL BE IN ACCORDANCE WITH ASME B18.3.

/h/ MINIMUM BREAKING STRENGTH VALUES ARE BASED ON 180 KSI HEAT TREATMENT. LINED THROUGH STRENGTH VALUES WERE BASED ON 170 KSI.

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REVISION

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NAS1351
SHEET 2



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