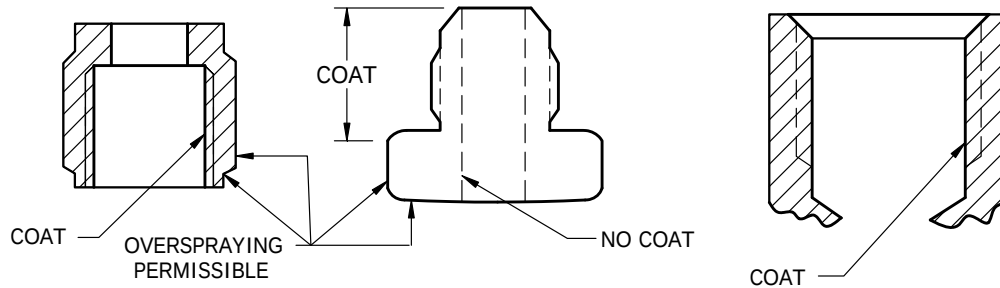


FED. SUPPLY CLASS

4730



MATERIAL:

BASIC FITTING: THE MATERIAL OF THE BASIC FITTING SHALL BE AS SPECIFIED ON THE APPLICABLE AN OR AS DRAWING.

FINISH:

BEFORE APPLICATION OF COATING:

CRES PARTS SHALL BE PASSIVATED PER AMS2700, METHOD 1, CLASS 4.
ALUMINUM ALLOY PARTS SHALL BE ANODIZED PER MIL-A-8625.

LUBRICATION & SEALANT:

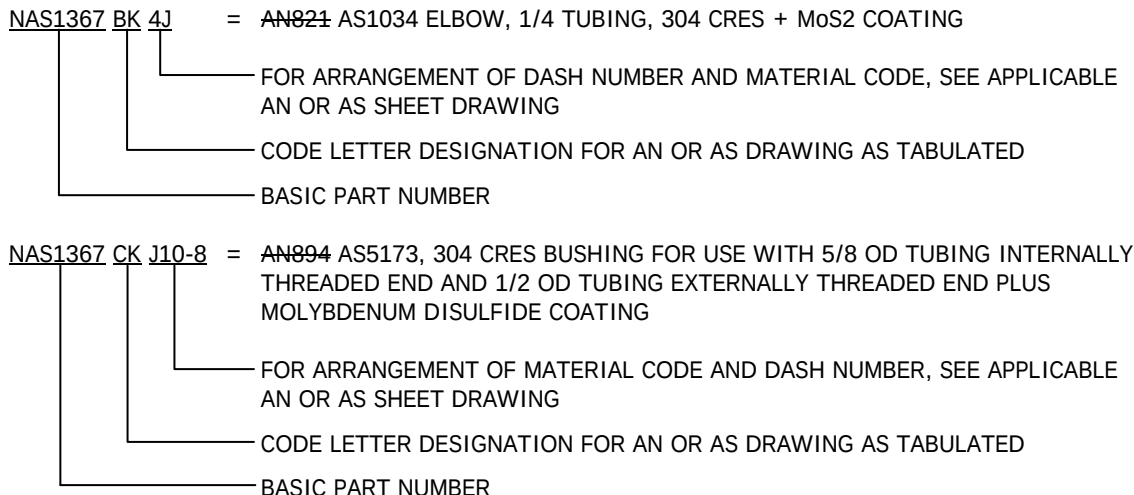
THIS COATING CONSISTS ESSENTIALLY OF MOLYBDENUM DISULFIDE LUBRICATING SOLID WITH A BINDER OF EITHER (A) PHOSPHORIC ACID THINNED WITH WATER AND ALCOHOL TO A PROPER CONSISTENCY FOR SPRAYING OR (B) SODIUM SILICATE THINNED WITH WATER TO A PROPER CONSISTENCY FOR SPRAYING. NO MATERIAL SHALL BE USED IN THE COATING WHICH WILL RENDER THE BAKED COATING IMPACT SENSITIVE TO THE PRESENCE OF LIQUID OXYGEN WHEN TESTED PER NASA HDBK 8060.18 FLAMMABILITY REQUIREMENTS.

APPLICATION: THE THREADS AND SEALING SURFACES SHALL BE COATED BY SPRAYING. OVERSPRAYING ONTO OTHER EXTERNAL SURFACES IS PERMISSIBLE (SEE FIGURE). THE OPENINGS OF THE EXTERNAL THREADED FITTINGS SHALL BE PLUGGED DURING SPRAYING TO KEEP PASSAGE FREE FROM COATING. ALLOW COATING TO AIR DRY FOR THIRTY MINUTES MINIMUM BEFORE BAKING. (DO NOT TOUCH COATING AFTER SPRAYING.) MATERIAL (A) APPLIED TO CRES SHALL BE BAKED AT $380^{\circ}\text{F} \pm 20^{\circ}\text{F}$ FOR ONE HOUR AND ON ALUMINUM AT $260^{\circ}\text{F} \pm 15^{\circ}\text{F}$ FOR THREE HOURS. MATERIAL (B) APPLIED TO CRES SHALL BE BAKED AT $180^{\circ}\text{F} \pm 10^{\circ}\text{F}$ FOR TWO HOURS, THEN $300^{\circ}\text{F} \pm 15^{\circ}\text{F}$ FOR TWO HOURS AND ON ALUMINUM AT $180^{\circ}\text{F} \pm 10^{\circ}\text{F}$ FOR TWO HOURS, THEN $250^{\circ}\text{F} \pm 10^{\circ}\text{F}$ FOR SIX HOURS. AFTER BAKING, THE COATING SHALL BE LIGHTLY BURNISHED WITH A POWER DRIVEN ROTARY STIFF NYLON BRISTLE BRUSH (OR EQUAL) TO REMOVE PARTICLES OF LUBRICANT THAT ARE INCOMPLETELY BONDED. THE RESULTING COATING SHALL BE SHINY, UNIFORM, DARK GREY TO BLACK IN COLOR, SMOOTH AND FREE FROM BLISTERS. IRREGULARITIES, NICKS OR SCRATCHES, SHALL ADHERE TO METAL WHEN SCRAPPED WITH THE FINGERNAIL AND SHALL BE .0001 TO .0005 INCHES THICK.

⑨ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 9
PROCUREMENT SPECIFICATION NONE	TITLE FITTINGS, COATED, LUBRICANT & SEALANT	CLASSIFICATION PART STANDARD NAS1367 SHEET 1 OF 3

EXAMPLES OF PART NUMBER:



NOTES:

- (1) THIS STANDARD PROVIDES THE PROCESS NECESSARY TO REWORK OR MAKE NEW STANDARD CRES OR ALUMINUM ALLOY AN AND AS FITTINGS, TO ADD A LUBRICANT AND SEALANT WHICH IS COMPATIBLE WITH LIQUID AND GASEOUS OXYGEN, AND TO SUPPLY AN IDENTIFYING NUMBER FOR THE PARTS. THIS CONSISTS OF COATING THE THREADS AND SEALING SURFACES OF STANDARD FITTINGS, WITH THE MATERIAL AND TO THE PROCEDURES, AS SPECIFIED BELOW FOR THE PURPOSE OF IMPROVING THE SEALING CHARACTERISTICS OF THE JOINTS WHEN USED IN HIGH PRESSURE GASEOUS SYSTEMS.
- (2) COMPATIBILITY WITH LIQUID AND GASEOUS OXYGEN SERVICE: WHEN COMPATIBILITY WITH LIQUID AND GASEOUS OXYGEN IS REQUIRED, ALL THE AN AND AS FITTINGS SELECTED MUST BE COMPATIBLE BEFORE COATING. ONLY WHEN THE BASIC FITTING MATERIAL IS COMPATIBLE WITH LIQUID AND GASEOUS OXYGEN WILL THE PART RESULTING FROM APPLICATION OF THE COATING ALSO BE COMPATIBLE WITH LIQUID AND GASEOUS OXYGEN WHEN PROPERLY CLEANED AND HANDLED.
- (3) THE NAS IDENTIFICATION SHALL CONSIST OF THE COMPLETE NAS PART NUMBER AND SHALL BE APPLIED TO THE PACKAGE CONTAINING THE INDIVIDUAL PART
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (5) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (6) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (7) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (8) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /9/ ADDITIONAL STANDARDS MAY BE INCLUDED THRU REVISION TO THIS STANDARD BY THE NATIONAL AEROSPACE STANDARDS COMMITTEE FROM THE RESERVED LETTER CODES ALREADY ASSIGNED, BUT MUST NOT BE USED UNTIL DOCUMENTED BY REVISION.

⑨ COMPLETELY REVISED

REVISION
9
NAS1367
SHEET 2



Documents

Document Sharing Hub