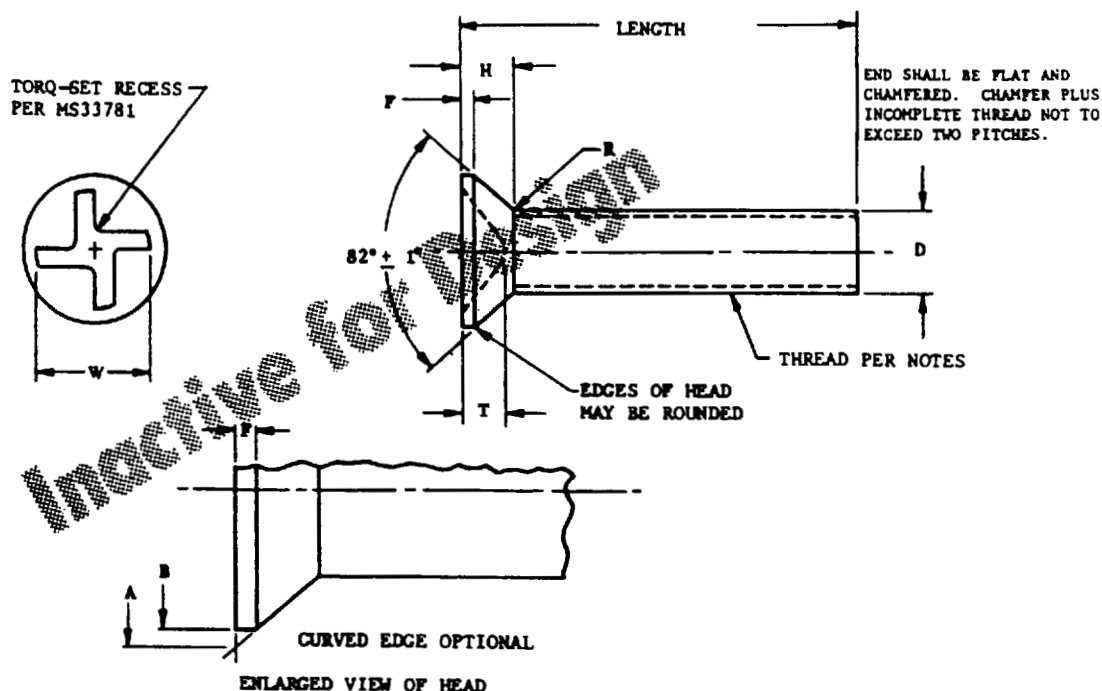


NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N. W., WASHINGTON, D. C. 20036

AIA AND ITS COMMITTEES WILL NOT INVESTIGATE THE APPLICABILITY OF PATENTS TO THE SUBJECT MATTER OF NAS STANDARDS AND IN RESPECT THEREOF DO NOT ASSUME ANY LIABILITY TO PATENT OWNERS OR TO PROSPECTIVE USERS.

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.



PART NUMBER	THREAD SEE NOTE (m)	A DIA	B ABSOLUTE MIN DIA	F	H (REF)	R	D DIA MAX	T MAX	W MAX	RECESS GAGE PENETRATION (b)	
										MAX	MIN
NAS1393-00	.0600-80 UNJF-3A	.119 .105	.095	.010 .005	.035	.010 .005	.060	.033	.087	.0250	.0170
NAS1393-01	.0730-64 UNJC-3A	.146 .130	.120	.010 .005	.043	.010 .005	.073	.039	.104	.0300	.0215

THREAD (SEE THD NOTE)	MIN TENSILE STRENGTH, LBS	
	CORR RES STEEL (140 KSI)	ALLOY STEEL CRES (160 KSI) TI (6AL-4V)
~~0-80 UNF-3A~~	~~252~~	~~288~~
~~.0600-80 UNJF-3A~~	~~252~~	~~288~~
~~1-64 UNC-3A~~	~~368~~	~~420~~
~~.0730-64 UNJC-3A~~	~~368~~	~~420~~

7

LIST OF CURRENT SHEETS

SHEET	REVISION
1	7
2	7

TOLERANCE ^{+.000} -.031	TOLERANCE ^{+.000} -.031	TOLERANCE ^{+.000} -.031	TOLERANCE ^{+.000} -.031
DASH NO.	LENGTH	DASH NO.	LENGTH
3	.188	7	.438
4	.250	8	.500
5	.312	9	.563
6	.375	10	.625
		11	.688
		12	.750
		13	.813
		14	.875
		15	.938
		16	1.000

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION
		STANDARD PART
NOTED	SCREW, MACHINE-FLAT 82 DEG HEAD, FULL THREAD, TORQ-SET	NAS 1393

SHEET 1 OF 2

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5161 River Road
Washington, D.C. 20016

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MATERIAL: Alloy steel per NAS498.

~~Corr. res. steel per AMS5735 (A286), except for heat treatment, designated by "C" code.~~~~Corr. res. steel per AMS5737 (A286), except for heat treatment, designated by "E" code.~~

(7) Titanium alloy (6Al-4V) per NAS662+NAS4004, designated by "V" code.

HEAT TREATMENT: Alloy steel - 160,000-180,000 PSI UTS per MIL-H-6875.

~~Corr. res. steel - 160,000 PSI UTS min. at room temperature.~~~~Corr. res. steel - 160,000 PSI UTS min. at room temperature.~~

Titanium alloy - 160,000 PSI UTS min.

FINISH: Alloy steel - Cadmium plate per QQ-P-416, Type II, Class 3, Type I plating designated by "W" per code.

Corr. res. steel - Clean and passivate in accordance with QQ-P-35.

Titanium alloy - None.

Corr. res. steel and titanium alloy - Optional cadmium plate per QQ-P-416, Type II, Class 3, designated by "P" code.

CODE: First dash number designates diameter and thread.

Second dash number indicates length in .062 increments (converted to three decimal places per ANSI Y14.5).

~~"C" in lieu of first dash designates Corr. res. steel (160 KSI).~~~~"E" in lieu of first dash designates Corr. res. steel (160 KSI).~~~~"P" following second dash number designates Type II plating~~~~"V" in lieu of first dash designates Titanium Alloy.~~~~"W" following second dash number designates Type I plating.~~

EXAMPLE: NAS1393-00-8 = .0600-80 screw, .500 length, alloy steel, Type II plating.

~~NAS1393000-10 = .0600-80 screw, .625 length, corr. res. steel (160 KSI).~~~~NAS1393-01-10W = .0730-64 screw, .625 length, alloy steel, Type I plating.~~

NAS1393V01-10P = .0730-64 screw, .625 length, titanium alloy, Type II plating.

- NOTES:
- (a) Diameter of unthreaded portion of screws shall not be less than minimum pitch diameter nor more than maximum major diameter of thread.
 - (b) Recess gaging in accordance with MS33781; flushness gaging details per NAS518 and NAS519.
 - (c) Screws shall be free from burrs and sharp edges.
 - (d) "Torq-Set" screws to be installed and removed with drivers per MS33781.
 - (e) Concentricity: Conical surface of head and pitch diameter of screw within .005 TIR.
 - (f) For corrosion resistant steel, magnetic permeability shall be less than 2.0 (air = 1.0) for a field strength $H = 200$ Orstedts. (Magnetic permeability indicator per MIL-I-17214.)
 - (g) Tensile stress areas used for calculation of ultimate tensile strength values based on NBS Handbook H-28 (1957).
 - (h) "C" code material inactive for design after 1 June 1971. Use "E" code. ("E" parts may be double identified "CE")
 - (j) Dimensions in inches.
 - (k) For description of status notes, see NAS380.
 - (l) Surface Roughness: "D" diameter, underside of head, and sides and root of threads - 32 microinches, other surfaces - 125 microinches, per ANSI B46.1.
 - (m) Threads in accordance with MIL-S-8879. ~~Threads in accordance with MIL-S-7742 are acceptable until 31 December 1969.~~
- (7) (n) PARTS MANUFACTURED TO NAS621 PROCUREMENT SPECIFICATION PRIOR TO JANUARY 1, 2001 MAY BE SUPPLIED TO DEPLETION.

PROCUREMENT SPECIFICATION:

NAS498 FOR ALLOY STEEL; AMS7478 FOR CORROSION RESISTANT STEEL, EXCEPT THAT STRESS RUPTURE REQUIREMENTS ARE NOT APPLICABLE; ~~NAS662+~~ NAS4004 FOR TITANIUM ALLOY. OPTIONAL CORROSION RESISTANT STEEL PER 7479 EXCEPT STRESS RUPTURE AND HEAT TREATMENTS ARE NOT APPLICABLE. TENSILE LOAD VALUES AS TABULATED HEREIN.

Inactive for Design

NAS 1393

SHEET 2

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