

FED. SUPPLY CLASS

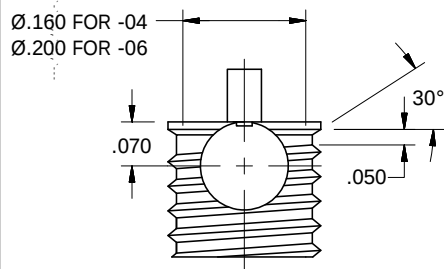
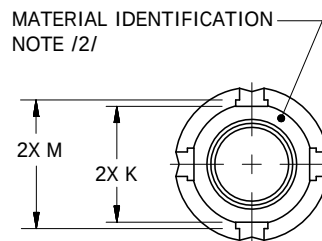
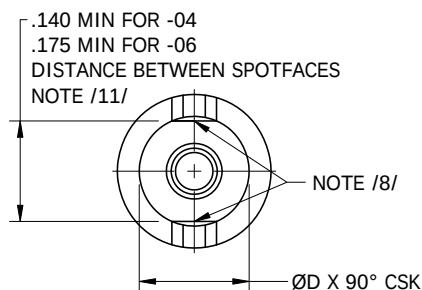
5340

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

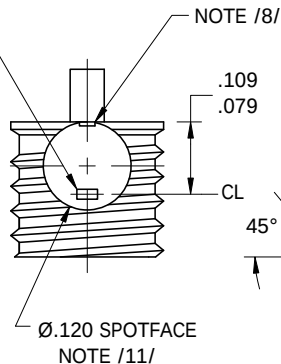
THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE:

REVISION DATE: JANUARY 30, 2015

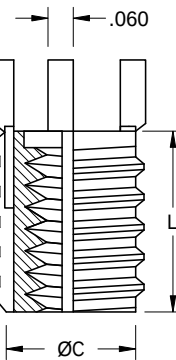
ISSUE DATE: JANUARY 1961



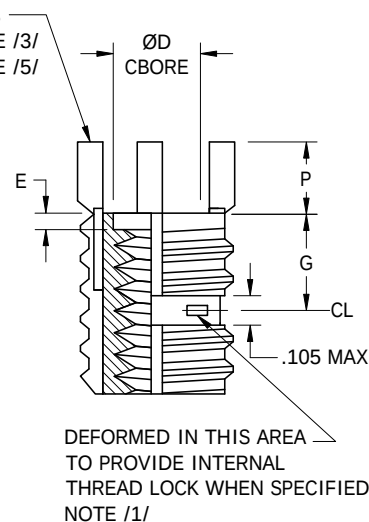
NON SELF-LOCKING



SELF-LOCKING



NON SELF-LOCKING

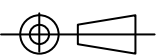


SELF-LOCKING

FOR -.04 AND -.06 ONLY
NOTE /4/ NOTE /12/

FOR -.08 THRU -.10 ONLY
NOTE /12/

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
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PROCUREMENT
SPECIFICATION
NOTES /1/ /6/

TITLE
**INSERT, SCREW THREAD, SELF-LOCKING AND
NON SELF-LOCKING, METAL, LIGHTWEIGHT**

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CLASSIFICATION
PART STANDARD

NAS1395
SHEET 1 OF 4



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TABLE I – DIMENSIONS

DASH NO.	INTERNAL THREAD /13/	EXTERNAL THREAD /14/ MOD	MOD MINOR DIA	L ±.015	ØC ±.005	ØD ±.005 CBORE	E	G ±.030	K ±.004	KEY DIMENSIONS		M MAX
										QTY	P ±.015	
04	.1120-40 UNJC-3B	.2160-24 NC-2A	/15/	.250	---	.150	---	---	---	---	.100	---
06	.1380-32 UNJC-3B	.2500-20 UNC-2A	/15/	.250	---	.195	---	---	---	---	.100	---
08	.1640-32 UNJC-3B	.3125-18 UNC-2A	.256 .249	.312	.250	.172	.040	.220	.220	2	.130	.266
3	.1900-32 UNJF-3B	.3750-16 UNC-2A	.320 .312	.312	.310	.196	.070	.220	.284	2	.130	.326
4	.2500-28 UNJF-3B	.4375-14 UNC-2A	.383 .375	.375	.375	.257	.070	.220	.345	2	.190	.399
5	.3125-24 UNJF-3B	.5000-13 UNC-2A	.440 .432	.437	.430	.316	.070	.220	.407	4	.190	.447
6	.3750-24 UNJF-3B	.5625-12 UNC-2A	.503 .495	.500	.495	.380	.070	.250	.469	4	.190	.510
7	.4375-20 UNJF-3B	.6250-11 UNC-2A	.565 .551	.625	.550	.445	.100	.280	.532	4	.190	.572
8	.5000-20 UNJF-3B	.6875-11 NS-2A	.627 .613	.688	.615	.507	.100	.280	.595	4	.190	.635
9	.5625-18 UNJF-3B	.8125-16 UN-2A	.752 .744	.812	.745	.580	.100	.320	.720	4	.190	.760
10	.6250-18 UNJF-3B	.8750-14 UNF-2A	.815 .807	.875	.805	.640	.100	.330	.782	4	.190	.822

MATERIAL:

- INSERT – CRES 303 (UNS S30300) PER AMS5640, TYPE I OR ASTM A582/A582M, OR 303Se (UNSS30323) PER AMS5640, TYPE 2, AMS5738 OR ASTM A582/A582M.
- ALLOY STEEL 4130 (UNS G41300) PER AMS-S-6758, OR 4140 (UNS G41400) PER AMS6349 OR AMS6382, OR 8740 (UNS G87400) PER AMS6322.
 - CRES A286 (UNS S66286) PER AMS5734 OR AMS5737.

LOCKING KEYS – CRES 302 (UNS S30200) PER ASTM A580/A580M, CHEMISTRY ONLY (-08 THRU -10 ONLY).

LOCKING KEYS (SELF BROACHING) – CRES 420 (UNS S42000) OR 440C (UNS S44004) PER AMS-QQ-S-763, CHEMISTRY ONLY (-08 THRU -10 ONLY).

HEAT TREATMENT:

ALLOY STEEL INSERTS SHALL BE HEAT TREATED TO 160-180 KSI IN ACCORDANCE WITH AMS2759.
CRES A286 INSERTS MADE FROM AMS5734 SHALL BE HEAT TREATED TO 140 KSI MINIMUM.

FINISH:

- CRES - A286, 303 AND 303Se SHALL BE PASSIVATED PER AMS2700, METHOD 1, CLASS 4.
- A286, 303 AND 303Se - SILVER PLATE PER AMS2410.

ALLOY STEEL - CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.

LUBRICANT:

SOLID FILM LUBRICANT PER AS5272, TYPE I, SELF-LOCKING INSERTS ONLY.

REVISION

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NAS1395

SHEET 2

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