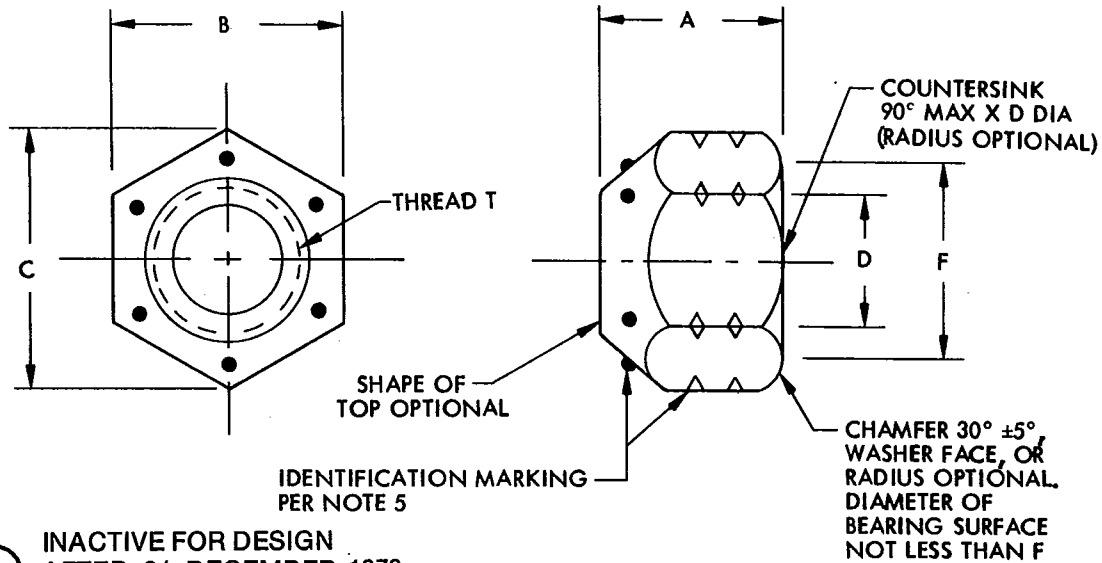


NATIONAL AEROSPACE STANDARD

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 HEREIN



6 INACTIVE FOR DESIGN
AFTER 31 DECEMBER 1979
NO SUPERSEDING STANDARD

THREAD T UNJC-3B	DASH NUMBER		A			C	CSK D DIA	F DIA MIN	AVERAGE WT PER 100	ULTIMATE TENSILE STRENGTH
	STEEL	CRES	MAX	MAX	MIN					
.2500-20	A4	C4	.226	.438	.428	.505	.266	.416	.7	3,760
.3125-18	A5	C5	.273	.500	.489	.577	.328	.475	1.0	6,360
.3750-16	A6	C6	.337	.563	.551	.650	.391	.534	1.4	9,540
.4375-14	A7	C7	.385	.688	.675	.794	.453	.653	2.6	13,140
.5000-13	A8	C8	.448	.750	.736	.866	.516	.713	3.3	17,730
.5625-12	A9	C9	.496	.875	.861	1.010	.594	.831	5.4	22,890
.6250-11	A10	C10	.559	.938	.922	1.083	.656	.891	6.8	28,530
.7500-10	A12	C12	.665	1.125	1.088	1.299	.781	1.069	11.6	42,770
.8750-9	A14	C14	.776	1.313	1.269	1.516	.906	1.247	15.9	60,330
1.0000-8	A16	C16	.887	1.500	1.450	1.732	1.031	1.425	23.6	79,280
1.1250-7	A18	C18	.999	1.687	1.631	1.949	1.156	1.603	40.4	104,600
1.2500-7	A20	C20	1.094	1.875	1.812	2.165	1.281	1.781	54.4	133,300
1.3750-6	A22	C22	1.206	2.062	1.994	2.273	1.406	1.959	75.0	147,000
1.5000-6	A24	C24	1.317	2.250	2.175	2.598	1.531	2.137	88.0	181,000

MATERIAL: STEEL, NON-CORROSION RESISTANT PER FED-STD-66.
CORROSION RESISTANT (TYPE 303 OR 305) PER FED-STD-66.

FINISH: NON-CORROSION RESISTANT STEEL, CADMIUM PLATE PER QQ-P-416 PLUS AN APPROVED DRY FILM LUBRICANT. TYPE AND CLASS OF PLATING IS OPTIONAL IF LUBRICATED NUTS WILL MEET THE SALT SPRAY REQUIREMENTS OF QQ-P-416, TYPE II. CORROSION RESISTANT STEEL, PASSIVATE. DRY FILM LUBRICANT.

CODE: INSERT "X" IN LIEU OF "A" IN THE STEEL CODE FOR CADMIUM PLATED STEEL NUTS WITHOUT LUBRICANT.

EXAMPLE OF PART NUMBERS: NAS1408A4 = .2500-20 STEEL NUT
NAS1408C4 = .2500-20 CRES NUT

LIST OF CURRENT SHEETS

NO	REV
1	6
2	4

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION STANDARD PART
NOTED	NUT, SELF-LOCKING, HEXAGON-REGULAR HEIGHT, COARSE THREAD, NON-AIRBORNE USE	NAS 1408

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- NOTES: 1. MINIMUM "A" LIMITED ONLY BY STRENGTH REQUIREMENT.
2. THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION. THREADS IN ACCORDANCE WITH MIL-S-7742 ARE ACCEPTABLE UNTIL 31 DECEMBER 1969.
3. TOP LOCKING THREAD DEVICE SHALL BE SUCH THAT BOTTOM THREADS OF NUT SHALL ASSEMBLE ONE FULL TURN ON ANY MATING EXTERNAL THREAD ACCEPTED BY THE PROPER GO RING THREAD GAGE.
4. MAGNETIC PERMEABILITY OF CRES NUTS SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH $H = 200$ OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT.
5. SAE GRADE 8 STRENGTH MARKING SHALL BE EITHER RAISED MARKS, 60° APART ON TOP CONICAL PORTION, OR 2 ANGLE NOTCHES IN HEXAGONAL CORNERS.

PROCUREMENT SPECIFICATION:

MIL-N-25027 EXCEPT AS NOTED. ALL NUTS SHALL MEET QUALIFICATION AND INSPECTION REQUIREMENTS. MANUFACTURERS SHALL PROVIDE EVIDENCE OF QUALIFICATION WHEN REQUIRED. TESTING SHALL BE PERFORMED BY MANUFACTURER OR INDEPENDENT LABORATORY. PROCURING AGENCY MAY CONDUCT CONFIRMING QUALIFICATION TESTS. NO QPL SHALL BE ESTABLISHED. MIL-N-6034 AND THE ROOM TEMPERATURE SELF-LOCKING REQUIREMENTS OF MIL-N-25027, EXCEPT DRY FILM LUBRICATED CRES NUTS NEED ONLY MEET 5 REUSE CYCLES.

ASSEMBLY TORQUES AT LOAD

BASED ON MINOR DIAMETER STRESS AREA

BASED ON CAD PLATED BOLTS, NUTS AND WASHERS; WASHERS HARDENED

(LB-IN ABOVE HEAVY LINE, LB-FT BELOW)

SIZE	40,000 PSI		65,000 PSI		90,000 PSI	
	LOAD (LBS)	TORQUE	LOAD (LBS)	TORQUE	LOAD (LBS)	TORQUE
.2500-20	1,080	34	1,750	55	2,420	75
.3125-18	1,820	71	2,950	9	4,090	13.5
.3750-16	2,710	10.5	4,410	17.5	6,100	24
.4375-14	3,730	17	6,060	28	8,400	39
.5000-13	5,030	26	8,170	43	11,310	59
.5625-12	6,480	38	10,530	62	14,580	81
.6250-11	8,080	53	13,130	86	18,180	119
.7500-10	12,080	95	19,630	154	27,180	215
.8750-9	16,760	153	27,240	250	37,710	345
1.0000-8	22,040	185	35,820	300	49,590	415
1.1250-7	27,720	260	45,040	420	62,370	580
1.2500-7	35,600	370	57,850	600	80,100	840
1.3750-6	42,160	480	68,510	790	94,860	1,080
1.5000-6	51,760	650	84,110	1,060	116,460	1,460

THE MEAN OF ANY ONE GROUP OF 5 OR MORE TESTS MUST NOT VARY MORE THAN $\pm 15\%$ FROM THE LISTED VALUE

NO SINGLE TEST RESULT FROM ANY ONE GROUP OF 5 OR MORE TESTS SHALL VARY MORE THAN $\pm 25\%$ FROM THE LISTED VALUE.

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INACTIVE FOR DESIGN
AFTER 31 DECEMBER 1979
NO SUPERSEDING STANDARD

NAS 1408

SHEET 21
Documents

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