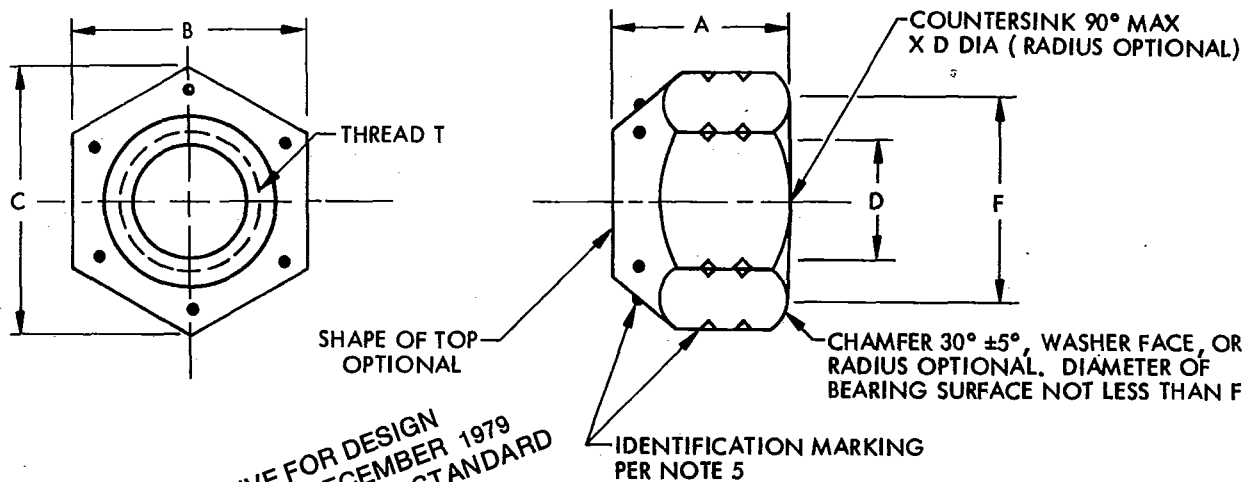


NATIONAL AEROSPACE STANDARD

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



5 INACTIVE FOR DESIGN
AFTER 31 DECEMBER 1979
NO SUPERSEDING STANDARD

THREAD T	DASH NUMBER		A MAX	B		C (REF)	CSK D DIA	F DIA MIN	AVERAGE WT PER 100	ULTIMATE TENSILE STRENGTH
	STEEL	CRES		MAX	MIN					
.2500-28 UNJF-3B	A4	C4	.226	.438	.428	.505	.266	.416	.7	4,580
.3125-24 UNJF-3B	A5	C5	.273	.500	.489	.577	.328	.475	1.0	7,390
.3750-24 UNJF-3B	A6	C6	.337	.563	.551	.650	.391	.534	1.4	11,450
.4375-20 UNJF-3B	A7	C7	.385	.688	.675	.794	.453	.653	2.6	15,450
.5000-20 UNJF-3B	A8	C8	.448	.750	.736	.866	.516	.713	3.3	21,110
.5625-18 UNJF-3B	A9	C9	.496	.875	.861	1.010	.594	.831	5.4	26,810
.6250-18 UNJF-3B	A10	C10	.559	.938	.922	1.083	.656	.891	6.8	34,130
.7500-16 UNJF-3B	A12	C12	.665	1.125	1.088	1.299	.781	1.069	11.6	50,020
.8750-14 UNJF-3B	A14	C14	.776	1.313	1.269	1.516	.906	1.247	15.9	68,440
1.0000-12 UNJF-3B	A16	C16	.887	1.500	1.450	1.732	1.031	1.425	23.6	90,000
1.1250-12 UNJF-3B	A18	C18	.999	1.687	1.631	1.949	1.156	1.603	40.4	116,700
1.2500-12 UNJF-3B	A20	C20	1.094	1.875	1.812	2.165	1.281	1.781	54.4	147,940
1.3750-12 UNJF-3B	A22	C22	1.206	2.062	1.994	2.273	1.406	1.959	75.0	178,000
1.5000-12 UNJF-3B	A24	C24	1.317	2.250	2.175	2.598	1.531	2.137	88.0	212,500
1 14 NS-2B	A17	C17	.887	1.500	1.450	1.732	1.031	1.425	23.6	92,180

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:

NAS1409A6 = .3750-24 STEEL NUT

NAS1409C6 = .3750-24 CRES NUT

LIST OF CURRENT SHEETS

NO	REV
1	5
2	4

CUSTODIAN: NATIONAL AEROSPACE STANDARD COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION
		STANDARD PART
NOTED	NUT, SELF-LOCKING, HEXAGON-REGULAR HEIGHT, FINE THREAD, NON-AIRBORNE USE	NAS 1409

SHEET 1 OF 2

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NATIONAL AEROSPACE STANDARD

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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

- NOTES:
1. MINIMUM "A" LIMITED ONLY BY STRENGTH REQUIREMENT.
 2. THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION. THREADS 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
.2500-28	1,300	40	2,120	67	2,930	91
.3125-24	2,100	82	3,410	11.5	4,720	15.5
.3750-24	3,240	12.5	5,260	20.5	7,280	29
.4375-20	4,360	20	7,080	33	9,810	45
.5000-20	5,940	31	9,660	50	13,370	70
.5625-18	7,560	44	12,280	72	17,010	100
.6250-18	9,600	63	15,600	102	21,600	141
.7500-16	14,040	110	22,820	179	31,590	245
.8750-14	19,200	175	31,200	285	43,200	395
1.0000-12	25,000	210	40,620	340	56,250	470
1.0000-14	25,850	215	42,010	350	58,170	485
1.1250-12	32,840	305	52,780	495	73,080	690
1.2500-12	40,960	425	66,560	690	92,160	960
1.3750-12	50,400	580	81,900	940	113,400	1,300
1.5000-12	60,840	760	98,860	1,240	136,890	1,720

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

4 INACTIVE FOR DESIGN
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NAS 1409 SHEET 2
Documents

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