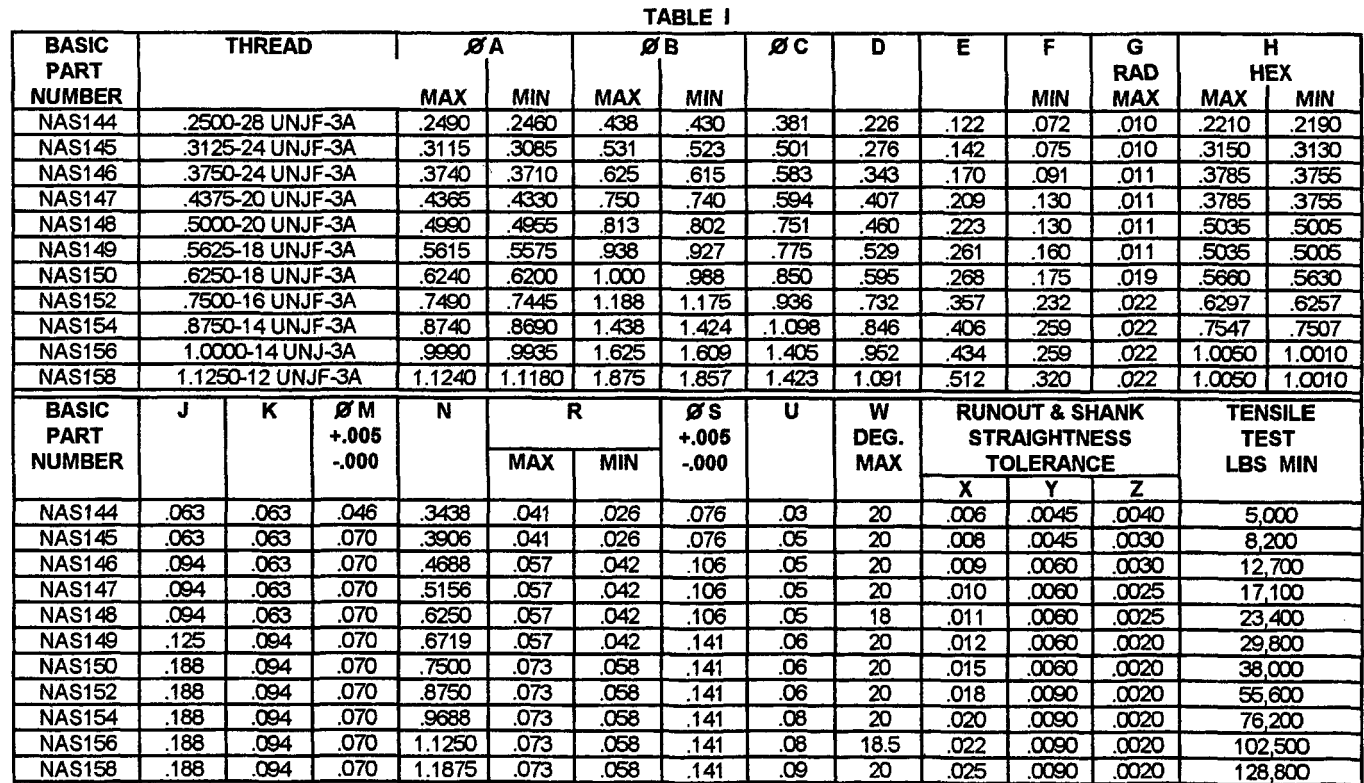




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USE MS20004 THRU MS20024

12

12

LIST OF CURRENT SHEETS			
SHEET	REV	SHEET	REV
1	12	3	NEW
2	9	4	NEW

NATIONAL AEROSPACE STANDARDS COMMITTEE

THIRD
ANGLE
PROJE



TITLE

CLASSIFICATION
PART STANDARD
NAS144 THRU 158
SHEET 1 OF 4

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APPROVAL DATE: MAY 1942 REVISION: (12) FEB 2002



MATERIAL: ALLOY STEEL IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.

HEAT TREAT: 160,000 TO 180,000 PSI TENSILE STRENGTH IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.

FINISH: CADMIUM PLATING PER QQ-P-416, TYPE II, CLASS 2.

CODE: ADD "DH" TO THE PART NUMBER TO DESIGNATE DRILLED HEAD.
ADD "A" TO THE PART NUMBER TO DESIGNATE DRILLED SHANK.
FOR SUFFIX DASH NUMBER TO DESIGNATE GRIP AND LENGTH, SEE TABLE II.

EXAMPLES: NAS144-25 = .2500-28 BOLT, 1.5625 INCHES LONG, UNDRILLED.
NAS144DH -25 = .2500-28 BOLT, 1.5625 INCHES LONG, DRILLED HEAD.
NAS144ADH-25 = .2500-28 BOLT, 1.5625 INCHES LONG, DRILLED HEAD AND SHANK.

NOTES:

1. **SURFACE TEXTURE:** PER ASME B46.1.
SHANK, HEAD BEARING SURFACE, AND THREADS,
32 MICROINCHES Ra.
FILLET RADIUS, 20 MICROINCHES Ra.
ALL OTHER SURFACES, 125 MICROINCHES Ra.
2. **MAGNETIC PARTICLE INSPECTION:** 100% PER ASTM E1444.
3. **TOLERANCE:** UNLESS OTHERWISE SPECIFIED, $\pm .010$.
4. **DIMENSIONS:** IN INCHES, PER ANSI Y14.5M - 1982.
5. **APPLICABLE WASHERS, MS20002 AND NAS1587.**
6. **LOCK WIRE HOLES SHALL BE FREE OF BURRS AND SHARP EDGES.**
7. **ALL DIMENSIONS APPLY AFTER PLATING.**
8. **PROCUREMENT SPECIFICATION:** NAS4002 EXCEPT;
 - a) PERIPHERY OF TAPERED HEAD AND SOCKET RECESS MAY BE MACHINED.
 - b) "R" ON HEAD OR POINT END OF BOLT INDICATES THREADS HAVE BEEN ROLLED AFTER HEAT TREAT.
 - c) TRACES OF PARTIAL DECARBURIZATION MAY APPEAR IN A LAYER NOT TO EXCEED:
.002 IN DEPTH FOR NOM DIAMETERS .2500 THRU .5000.
.003 IN DEPTH FOR NOM DIAMETERS .5625 THRU 1.0000.
.004 IN DEPTH FOR NOM DIAMETERS 1.1250.
 - d) COLD WORK OF HEAD TO SHANK FILLET RADIUS NOT REQUIRED.
 - e) FATIGUE CAPABILITIES AND TESTS NOT REQUIRED.

⑨ COMPLETELY REVISED.

NAS144 THRU 158
SHEET 2

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