

FED. SUPPLY CLASS

5306

HEAD MARKING PER NAS1347, TYPE IV
EXCEPT ADD "R" AFTER DIAMETER DASH
NUMBER ON SIZES 3, 4 AND 5 TO INDICATE
NASM14191 RECESS WHERE APPLICABLE

HEAD MARKING PER
NAS1347, TYPE IV

DOVETAIL SLOT RECESS
PER NASM33750 /8/ /9/

OFFSET CRUCIFORM RECESS
PER NASM14191 OR NASM33781
(SEE CODE) /8/ /9/

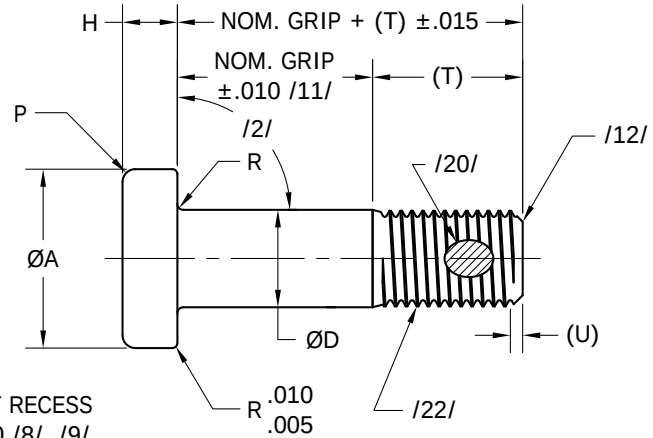


TABLE I – DIMENSIONS

FIRST DASH NO.	THREAD UNJF-3A	ØA	ØD		H	P RAD	R RAD	(T) /16/	(U) /16/	Z FIM /3/	TENSILE STRENGTH A & C CODE LBS. MIN /10/	TENSILE STRENGTH V CODE LBS. MIN /21/
			UNPLATED	PLATED								
3	.1900-32	.374 .360	.1895 .1890	.1895 .1885	.125 .115	.035 .025	.020 .010	.363	.050	.0040	3,180	3,180
4	.2500-28	.492 .477	.2495 .2490	.2495 .2485	.150 .140	.040 .025	.020 .010	.403	.050	.0030	5,790	5,820
5	.3125-24	.612 .597	.3120 .3115	.3120 .3110	.188 .176	.050 .035	.025 .010	.501	.060	.0030	9,260	9,200
6	.3750-24	.740 .722	.3745 .3740	.3745 .3735	.220 .206	.050 .035	.025 .015	.594	.060	.0025	14,000	14,000
7	.4375-20	.813 .795	.4370 .4365	.4370 .4360	.245 .230	.060 .040	.025 .015	.675	.080	.0025	19,000	18,900
8	.5000-20	.925 .905	.4995 .4990	.4995 .4985	.280 .262	.065 .045	.030 .020	.768	.080	.0020	25,600	25,600

14 COMPLETELY REVISED

THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

14

REVISION
14

PROCUREMENT
SPECIFICATION
NOTED

TITLE
**BOLT, SHEAR, FLAT PAN HEAD, CLOSE TOLERANCE, DOVETAIL
SLOT, OFFSET CRUCIFORM, AND OFFSET CRUCIFORM-RIBBED,
SELF-LOCKING AND NONLOCKING, 95 KSI Fsu**

CLASSIFICATION
PART STANDARD

NAS1578

SHEET 1 OF 6

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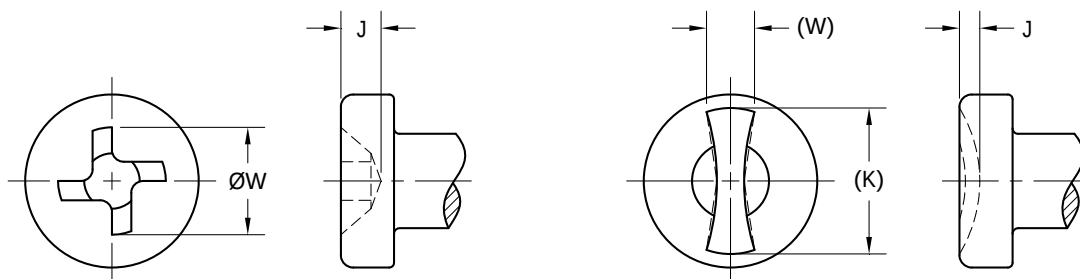


TABLE II – OFFSET CRUCIFORM RECESS

FIRST DASH NO.	RECESS NUMBER /8/ /9/	J MAX	ØW MAX	GAGE PENETRATION	
				MIN	MAX
3	10	.098	.263	.0635	.0760
4	1/4	.128	.345	.0850	.0990
5	5/16	.134	.382	.0825	.0895
6	3/8	.161	.457	.1000	.1180
7	7/16	.169	.498	.1005	.1205
8	1/2	.193	.568	.1155	.1375

TABLE III – DOVETAIL SLOT RECESS

FIRST DASH NO.	RECESS NUMBER /8/ /9/	J		(K) /16/	(W) /16/
		MIN	MAX		
3	3	.042	.045	.302	.105
4	4	.051	.054	.414	.135
5	5	.061	.064	.485	.152
6	6	.084	.088	.635	.190
7	7	.091	.095	.692	.216
8	8	.101	.105	.772	.254

MATERIAL: ALLOY STEEL – 4140 (UNS G41400) PER MIL-S-5626 OR AMS6382, 4340 (UNS G43406) PER MIL-S-5000, AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER MIL-S-6049 OR AMS6322, AMS6325 OR AMS6327. CRES - A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853. TITANIUM ALLOY - 6Al-4V (UNS R56400) PER AMS4928 OR AMS4967. LOCKING ELEMENT - POLYAMIDE OR EQUIVALENT.

HEAT TREAT: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759 FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM.

ALLOY STEEL: 160-180 KSI Ft_u; 95 KSI Fsu MIN.
CRES: 160-190 KSI Ft_u; 95 KSI Fsu MIN. /10/
TITANIUM: 160 KSI Ft_u MIN.; 95 KSI Fsu MIN.

FINISH: ALLOY STEEL: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
CRES: PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. (SEE CODE FOR FINISH)
TITANIUM: NO FINISH

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SHEET 2

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