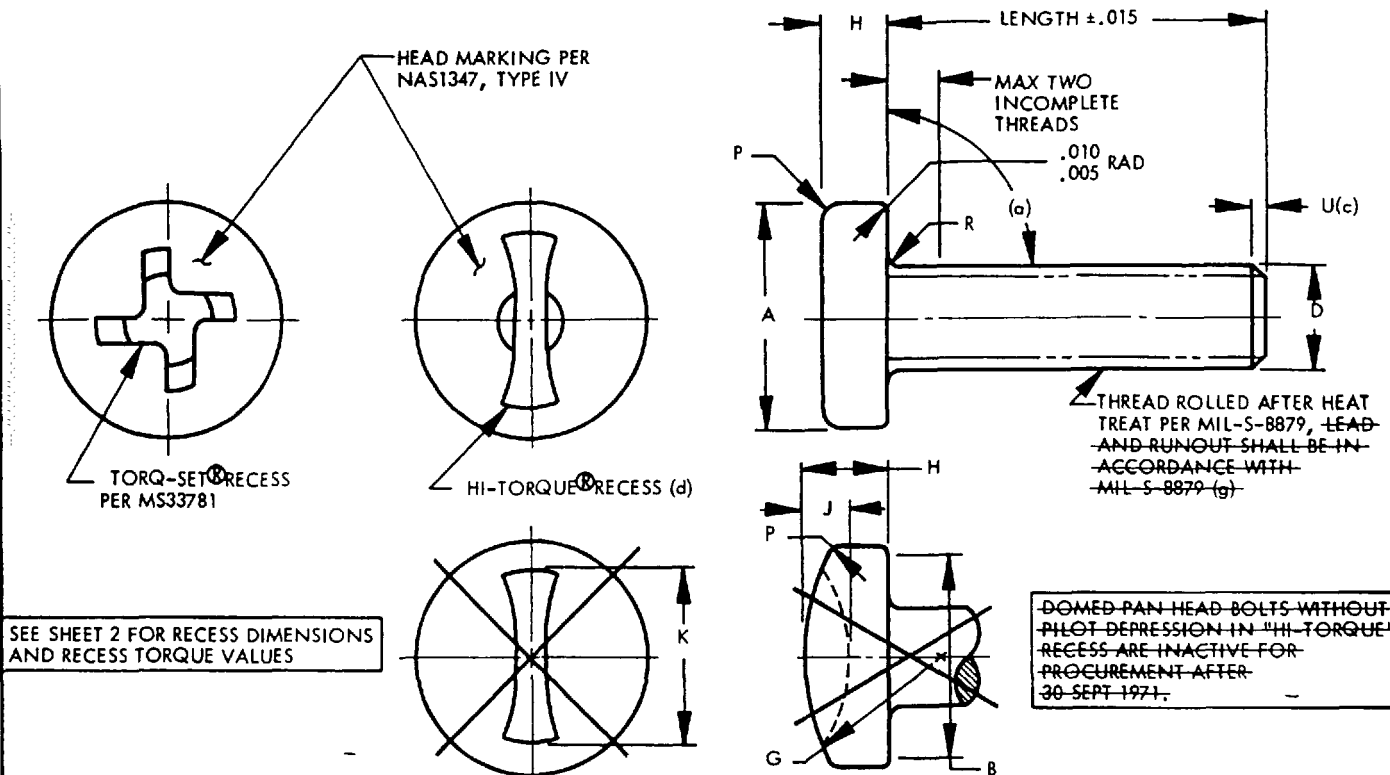


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FIRST DASH NO.	THREAD UNJF-3A	A DIA	B BRG DIA MIN	D DIA MAX	G RAD REF	H	H	P RAD	P RAD	R RAD	U REF (c)	Z TIR (b)	TENSILE STRENGTH LBS. MIN. (f)
- 3	.1900-32	.374 .360	.381	.190	.280	.133 .122	.125 .115	.060 .050	.035 .025	.020 .010	.050	.0040	3,180
- 4	.2500-28	.492 .477	.424	.250	.370	.175 .162	.150 .140	.065 .055	.040 .025	.020 .010	.050	.0030	5,790
- 5	.3125-24	.612 .597	.518	.312	.530	.218 .203	.188 .176	.075 .060	.050 .035	.025 .010	.060	.0030	9,260
- 6	.3750-24	.740 .722	.611	.375	.650	.261 .244	.220 .206	.080 .065	.050 .035	.025 .015	.060	.0025	14,000

- (a) BEARING SURFACE OF HEAD SHALL BE PERPENDICULAR TO THREAD PITCH DIA WITHIN .003 TIR.
- (b) THREADS SHALL BE STRAIGHT WITHIN "Z" VALUES TIR PER INCH OF LENGTH.
- (c) POINT SHALL BE FLAT AND CHAMFERED. CHAMFER PLUS INCOMPLETE THREAD SHALL NOT EXCEED "U".
- (d) HI-TORQUE RECESS PER MS33750. BOLT RECESS SHALL BE TORQUE TESTED WITH APPLICABLE MS33750 DRIVER WITH AXIAL END PRESSURE NOT EXCEEDING 15 POUNDS. BOLTS ARE REJECTABLE IF MINIMUM TORQUE VALUES LISTED ON SHEET 2 CAUSE FRACTURE OF BOLT OR DISTORTION WHICH RESULTS IN RAISE OF METAL AT EDGE OF SLOT EXCEEDING .005 ABOVE SURROUNDING AREA. SAMPLING SHALL BE PER MIL-STD-105, 4% AQL LEVEL S-1.
- (e) BOLTS WITHOUT PILOT DEPRESSION IN RECESS MAY BE SUPPLIED UNTIL 30 SEPT. 1971.
- (5) (f) THESE TENSILE VALUES APPLY TO ALLOY STEEL AND A-286 CRES PARTS ONLY. TENSILE VALUES FOR 6Al-4V TITANIUM ALLOY ARE LISTED IN NAS 621 NAS4004.
- (g) FASTENER SUPPLIERS MAY SUPPLY FASTENERS WITH MIL-S-7742 THREADS UNTIL 30 SEPT. 1971. FASTENERS WITH MIL-S-7742 THREADS MAY BE USED UNTIL STOCK IS DEPLETED.
- (h) FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.
- (5) (i) PARTS MANUFACTURED TO NAS621 PROCUREMENT SPECIFICATION PRIOR TO JANUARY 1, 2001 MAY BE SUPPLIED TO DEPLETION.

**INACTIVE FOR DESIGN AFTER DECEMBER 31, 1976. SEE
NAS1100 AND NAS1216
FOR DESCRIPTION OF STATUS NOTES SEE NAS380**

(5) LIST OF CURRENT SHEETS

SHEET	REVISION
1	5
2	5
3	1

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION
NOTED

TITLE
BOLT, FLAT PAN HEAD
FULL THREAD

CLASSIFICATION
STANDARD PART

NAS 1579
Documents

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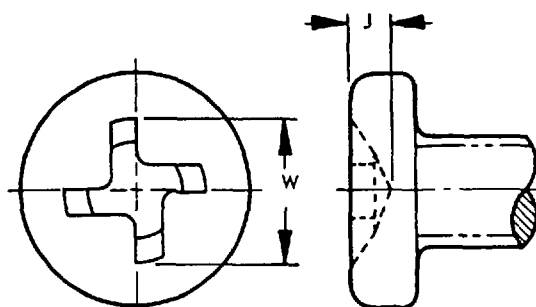
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REVISION 1 1 May 1964 2 30 Sept. 1970 3 30 Sept. 1971 4 30 March 1977 5 8 Jan. 2001
APPROVAL DATE FEB. 1963

NATIONAL AEROSPACE STANDARD

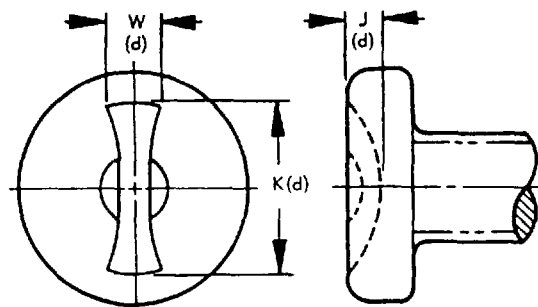
AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N. W. WASHINGTON, D. C. 20036

TORQ-SET® RECESS



FIRST DASH NO.	RECESS NO.	J MAX	W DIA MAX	GAGE PENETRATION		RECESS TORQUE IN. LBS. MIN
				MIN	MAX	
-3	10	.075	.219	.0415	.0540	
-4	1/4	.098	.286	.0555	.0695	
-5	5/16	.122	.357	.0700	.0860	
-6	3/8	.145	.427	.0850	.1030	

HI-TORQUE® RECESS



FIRST DASH NO.	RECESS NO.	J (d)		K REF (d)	W REF (d)	RECESS TORQUE IN. LBS. MIN (d)
		MIN	MAX			
-3	3	.042	.045	.302	.105	50
-4	4	.051	.054	.414	.135	125
-5	5	.061	.064	.485	.152	250
-6	6	.084	.088	.635	.190	430

MATERIAL: ALLOY STEEL AND 6Al-4V TITANIUM ALLOY PER PROCUREMENT SPEC. OR A-286 CRES PER AMS5735 (SEE "CODE").

HEAT TREAT: ALLOY STEEL: 160,000 - 180,000 PSI TENSILE STRENGTH.
A-286 CRES: 160,000 - 180,000 PSI TENSILE STRENGTH.
6Al-4V TI: 160,000 - 180,000 PSI TENSILE STRENGTH.

FINISH: PASSIVATE PER QQ-P-35 OR CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, OR TYPE II, CLASS 3 (SEE "CODE").

CODE: FIRST DASH NUMBER INDICATES NOMINAL THREAD DIAMETER IN 16THS. SECOND DASH NUMBER INDICATES OVERALL LENGTH IN .0625 INCREMENTS.

MATERIAL: CODE LETTER "A" FOLLOWING BASIC PART NUMBER INDICATES ALLOY STEEL.

CODE LETTER "C" FOLLOWING BASIC PART NUMBER INDICATES A-286 CRES.

CODE LETTER "V" FOLLOWING BASIC PART NUMBER INDICATES 6Al-4V TITANIUM.

FINISH: ALLOY STEEL: NO CODE LETTER FOLLOWING SECOND DASH NUMBER INDICATES TYPE II, CLASS 2, CADMIUM PLATE.

A-286 CRES: NO CODE LETTER FOLLOWING SECOND DASH NUMBER INDICATES PASSIVATE.

CODE LETTER "P" FOLLOWING SECOND DASH NUMBER INDICATES TYPE II, CLASS 2, CADMIUM PLATE.

6Al-4V TI: NO CODE LETTER FOLLOWING SECOND DASH NUMBER INDICATES NO FINISH.

RECESS: CODE LETTER "H" FOLLOWING FIRST DASH NUMBER INDICATES "HI-TORQUE" RECESS.

CODE LETTER "T" FOLLOWING FIRST DASH NUMBER INDICATES "TORQ-SET" RECESS.

EXAMPLE OF PART NUMBER:

NAS1579C4H5 = .2500-28 A-286 CRES BOLT; .312 OVERALL LENGTH; PASSIVATED; "HI-TORQUE" RECESS.

NAS1581C4T5P = .2500-28 A-286 CRES BOLT; .312 OVERALL LENGTH; TYPE II, CLASS 2, CADMIUM PLATE; "TORQ-SET" RECESS.

NOTES:

1. CONCENTRICITY: "A" DIA TO "D" DIA WITHIN .008 TIR.

2. SURFACE TEXTURE PER ANSI B46.1 BEARING SURFACE OF HEAD, FILLET RADIUS OF HEAD AND ALL THREAD ELEMENTS 32 RHR MAX. ALL OTHER SURFACES 125 RHR MAX.

3. ALLOY STEEL PARTS WITH TYPE II, CLASS 3, CADMIUM PLATE MAY BE FURNISHED FROM SUPPLIER'S STOCK UNTIL 1 JULY 1978.

4. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.

5. DIMENSIONS IN INCHES AND TO BE MET AFTER PLATING (WHEN REQUIRED).

PROCUREMENT SPEC:

ALLOY STEEL: NAS 498 EXCEPT TENSILE VALUES AS TABULATED.

A-286 CRES: NAS 498 EXCEPT TENSILE VALUES AS TABULATED, AND FLUORESCENT PENETRANT INSPECTION IN PLACE OF MAGNETIC PARTICLE INSPECTION.

5. 6Al-4V TI: ~~NAS 627~~ NAS4004

INACTIVE FOR DESIGN AFTER DECEMBER 31, 1976. SEE NAS1100 AND NAS1216

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APPROVAL DATE

FEB. 1963