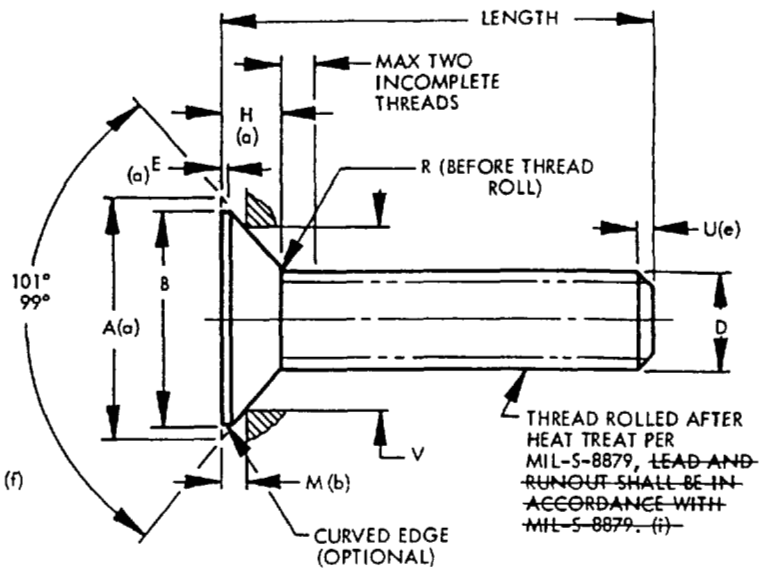
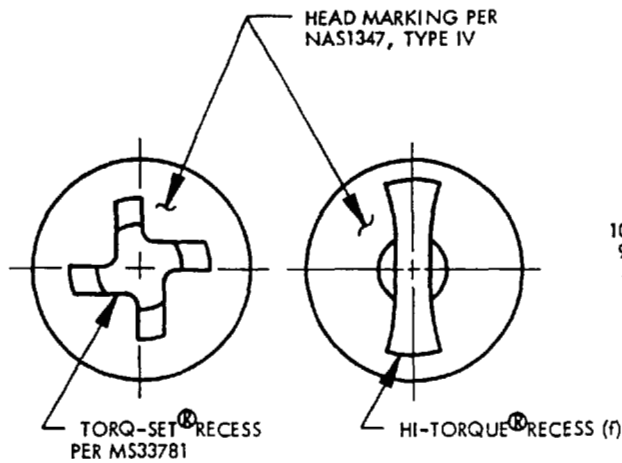


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SEE SHEET 2 FOR RECESS DIMENSIONS AND RECESS TORQUE VALUES

FIRST DASH NO.	THREAD UNJF-3A	A DIA MAX (a)	B DIA MIN	D DIA MAX	E MAX (g)	H REF (a)	M GAGE PROT (b)	R RAD	U REF (e)	V GAGE DIA	Y TIR (c)	Z (d)	TENSILE STRENGTH LBS. MIN. (h)
- 3	.1900-32	.3813	.339	.190	.015	.083	.0285 .0255	.035 .015	.050	.3147 .3145	.005	.0040	3,180
- 4	.2500-28	.5066	.464	.250	.015	.111	.0351 .0319	.035 .015	.050	.4245 .4243	.006	.0030	5,790
- 5	.3125-24	.6335	.578	.312	.015	.140	.0409 .0370	.045 .025	.060	.5389 .5387	.007	.0030	9,260
- 6	.3750-24	.7604	.717	.375	.015	.167	.0459 .0422	.045 .025	.060	.6532 .6530	.008	.0025	14,000

- (a) A, E, AND H ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION. VALUES A, E, AND H ARE CALCULATED LIMITS RESULTING FROM TOLERANCE ON B, D, M, V, AND HEAD ANGLE.
- (b) DIMENSIONS FOR M GAGE PROTRUSION SHALL BE INSPECTED PER NAS 527.
- (c) HEAD EDGE OUT OF ROUNDNESS SHALL NOT EXCEED "Y" TIR.
- (d) THREADS SHALL BE STRAIGHT WITHIN "Z" VALUES TIR PER INCH OF LENGTH.
- (e) POINT SHALL BE FLAT AND CHAMFERED. CHAMFER PLUS INCOMPLETE THREAD SHALL NOT EXCEED "U".
- (f) 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.
- (g) BOLTS WITHOUT PILOT DEPRESSION IN RECESS MAY BE SUPPLIED UNTIL 30 SEPT. 1971.
- (h) 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.
- (i) ~~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.~~
- (j) FOR DESCRIPTION OF STATUS NOTE, SEE NAS380.
- (k) PARTS MANUFACTURED TO NAS621 PROCUREMENT SPECIFICATION PRIOR TO JANUARY 1, 2001 MAY BE SUPPLIED TO DEPLETION.

INACTIVE FOR DESIGN AFTER DECEMBER 31, 1976. SEE NAS1102 AND NAS1219 FOR DESCRIPTION OF STATUS NOTES SEE NAS380

5

SHEET	REVISION
1	5
2	5
3	1

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION

NOTED

TITLE

BOLT, 100° FLUSH TENSION HEAD FULL THREAD

CLASSIFICATION

STANDARD PART

NAS 1582 Documents

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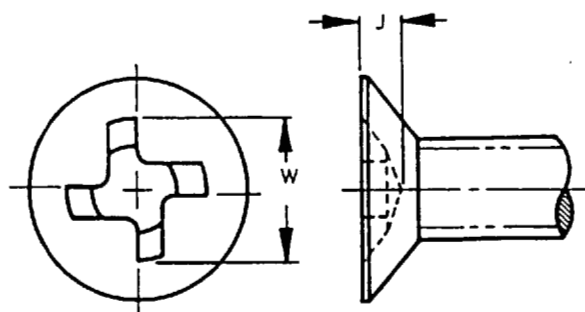
Full document details: AIA NAS1582 2001

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

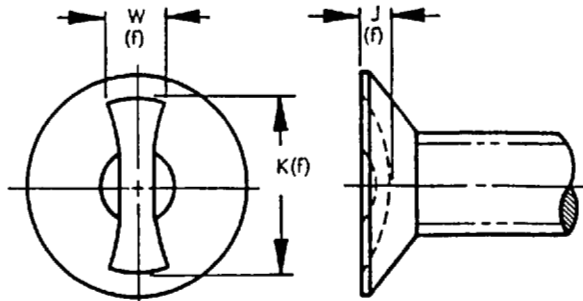
THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

TORQ-SET® RECESS



FIRST DASH NO.	RECESS NO.	J MAX	W DIA MAX	GAGE PENETRATION		RECESS TORQUE IN. LBS. MIN.
				MIN	MAX	
-3	10	.090	.248	.0560	.0685	50
-4	1/4	.118	.325	.0750	.0890	125
-5	5/16	.122	.357	.0700	.0860	250
-6	3/8	.145	.427	.0850	.1030	430

HI TORQUE® RECESS



FIRST DASH NO.	RECESS NO.	J		K REF	W REF	RECESS TORQUE IN. LBS. MIN.
		MIN	MAX			
-3	3	.042	.045	.305	.110	50
-4	4	.051	.054	.422	.134	125
-5	5	.061	.064	.490	.160	250
-6	6	.084	.088	.639	.198	430

MATERIAL:

ALLOY STEEL AND 6Al-4V TITANIUM ALLOY PER PROCUREMENT SPEC OR A-286 CRES PER AMS 5735 (SEE "CODE").

HEAT TREAT:

ALLOY STEEL: 160,000 - 180,000 PSI MINIMUM TENSILE STRENGTH.

A-286 CRES: 160,000 - 180,000 PSI MINIMUM TENSILE STRENGTH.

6Al-4V TI: 160,000 - 180,000 PSI MINIMUM 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:

③ 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: 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:

NAS1582C4H5 = .2500-28 A-286 CRES BOLT; .312 GRIP LENGTH; PASSIVATED; "HI-TORQUE" RECESS.

NAS1582C4T5P = .2500-28 A-286 CRES BOLT; .312 GRIP LENGTH; TYPE II, CLASS 2 CADMIUM PLATE; "TORQ-SET" RECESS.

NOTES:

1. CONCENTRICITY: CONICAL SURFACE OF HEAD TO THREAD PITCH DIA WITHIN .005 TIR.

2. SURFACE TEXTURE PER ANSI B46.1. CONICAL 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 SUPPLIERS 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 621~~ NAS4004

INACTIVE FOR DESIGN AFTER DECEMBER 31, 1976. SEE NAS1102 AND NAS1219

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