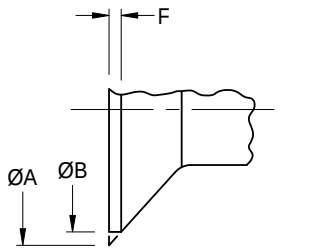


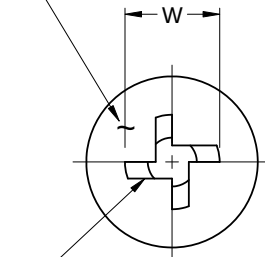
FED. SUPPLY CLASS

5305

INDENTED HEAD MARK PER
NAS1347, TYPE III, EXCEPT
MAY BE .016 MINIMUM SIZE
ON NAS1620 AND NAS1621.



ENLARGED VIEW OF HEAD



OFFSET CRUCIFORM
RECESS PER NASM33781
OR RIBBED PER NASM14191
(SEE CODE)

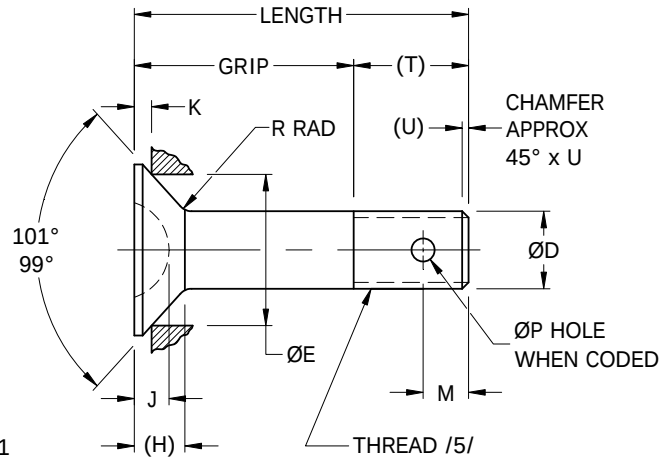


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /5/	ØA	ØB	ØD	F	(H)	R RAD	(T)	(U)	M +.010 -.010	ØP +.010 -.000	J	W	RECESS GAGE PENETRATION /6/		ØE	K	RECESS TORQUE IN-LBF MIN /12/
		MIN	MAX									MAX	MAX	MAX	MIN			
NAS1620	.1120-40 UNJC-3A	.225 .213	.177	.1120 .1095	.015	.045	.020 .005	.220	.020	—	—	.055	.148	.0405	.0305	—	—	14
NAS1621	.1380-32 UNJC-3A	.279 .267	.231	.1380 .1355	.015	.057	.020 .005	.276	.031	—	—	.066	.182	.0500	.0395	—	—	24
NAS1622	.1640-32 UNJC-3A	.334 .323	.277	.1635 .1610	.015	.068	.020 .010	.276	.031	—	—	.078	.215	.0595	.0480	.2671 .2667	.0268 .0240	37
NAS1623	.1900-32 UNJF-3A	.387 .375	.322	.1895 .1870	.016	.080	.020 .010	.276	.031	.117	.070	.090	.248	.0685	.0560	.3147 .3143	.0290 .0263	50
NAS1624	.2500-28 UNJF-3A	.510 .496	.442	.2495 .2470	.018	.106	.020 .010	.316	.031	.116	.076	.118	.325	.0890	.0750	.4245 .4241	.0342 .0316	125
NAS1625	.3125-24 UNJF-3A	.638 .622	.572	.3120 .3095	.021	.133	.025 .010	.375	.047	.119	.076	.122	.357	.0860	.0700	.5389 .5385	.0395 .0370	250
NAS1626	.3750-24 UNJF-3A	.766 .748	.692	.3745 .3720	.023	.159	.030 .015	.391	.047	.120	.106	.145	.427	.1030	.0850	.6532 .6528	.0450 .0426	430
NAS1627	.4375-20 UNJF-3A	.894 .874	.812	.4370 .4345	.026	.186	.035 .015	.453	.047	.124	.106	.169	.498	.1205	.1005	.7676 .7672	.0503 .0481	925
NAS1628	.5000-20 UNJF-3A	1.022 1.000	.932	.4995 .4970	.028	.213	.040 .020	.453	.047	.123	.106	.193	.568	.1375	.1155	.8820 .8816	.0557 .0537	1210

12 COMPLETELY REVISED



THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

12

PROCUREMENT
SPECIFICATION

NOTED

TITLE

SCREW, MACHINE, FLAT 100° HEAD,
SHORT THREAD, OFFSET CRUCIFORM

12

CLASSIFICATION
PART STANDARD

NAS1620 THRU
NAS1628

SHEET 1 OF 5

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	TENSILE STRENGTH LBF MIN		ULTIMATE DOUBLE SHEAR STRENGTH LBF MIN	
	CRES (140 KSI)	CRES (160 KSI), ALLOY STEEL & TITANIUM	CRES (140 KSI)	CRES (160 KSI), ALLOY STEEL & TITANIUM
NAS1620	840	966	1,625	1,840
NAS1621	1,270	1,450	2,480	2,805
NAS1622	1,960	2,240	3,550	4,010
NAS1623	2,800	3,180	4,760	5,380
NAS1624	5,100	5,820	8,220	9,300
NAS1625	8,120	9,200	12,900	14,600
NAS1626	12,300	14,000	18,600	21,000
NAS1627	12,960	14,800	25,300	28,600
NAS1628	17,460	19,950	33,000	37,300

MATERIAL:

- ALLOY STEEL - 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6382, 4340 (UNS G43406) PER ~~MIL-S-5000~~ AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER ~~MIL-S-6049~~ AMS6327, AMS6322 OR AMS6325.
- ~~CORR-RES. STEEL PER AMS5735 (A286), EXCEPT FOR HEAT TREATMENT, DESIGNATED BY "C" CODE.~~
- CRES - A286 (UNS S66286) PER AMS5731, AMS5732, AMS5737 OR AMS5853, EXCEPT FOR HEAT TREATMENT, DESIGNATED BY "E" CODE.
- TITANIUM ALLOY - 6AL-4V (UNS R56400) PER AMS4928 OR AMS4967, DESIGNATED BY "V" CODE.

HEAT TREATMENT:

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
CRES: 160-190 KSI Ft_u /20/
TITANIUM ALLOY: 160 KSI Ft_u MIN

FINISH:

- ALLOY STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. NO CODE. /15/
CRES - PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
~~TITANIUM ALLOY - NONE.~~
CRES AND TITANIUM ALLOY - OPTIONAL CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. DESIGNATED BY "P" PER CODE. /15/

CODE:

BASIC PART NUMBER DESIGNATES DIAMETER AND THREAD.
DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE II).
~~"C" IN LIEU OF DASH DESIGNATES CORR-RES. STEEL (140 KSI).~~
"D" FOLLOWING DASH NUMBER DESIGNATES DRILLED SHANK.
"E" IN LIEU OF DASH DESIGNATES CRES (160 KSI).
"P" FOLLOWING DASH NUMBER DESIGNATES TYPE II PLATING.
"V" IN LIEU OF DASH DESIGNATES TITANIUM ALLOY.
NO CODE LETTER INDICATES OFFSET CRUCIFORM RECESS PER NASM33781.
"R" FOLLOWING DASH NUMBER INDICATES OFFSET CRUCIFORM RIBBED RECESS PER NASM14191. /11/
AFTER DASH, WHERE MORE THAN ONE CODE LETTER IS USED SEQUENTIALLY IN PART NUMBER, ARRANGE LETTERS ALPHABETICALLY.

REVISION

12

NAS1620 THRU
NAS1628
SHEET 2

12 COMPLETELY REVISED