

FED. SUPPLY CLASS

5305

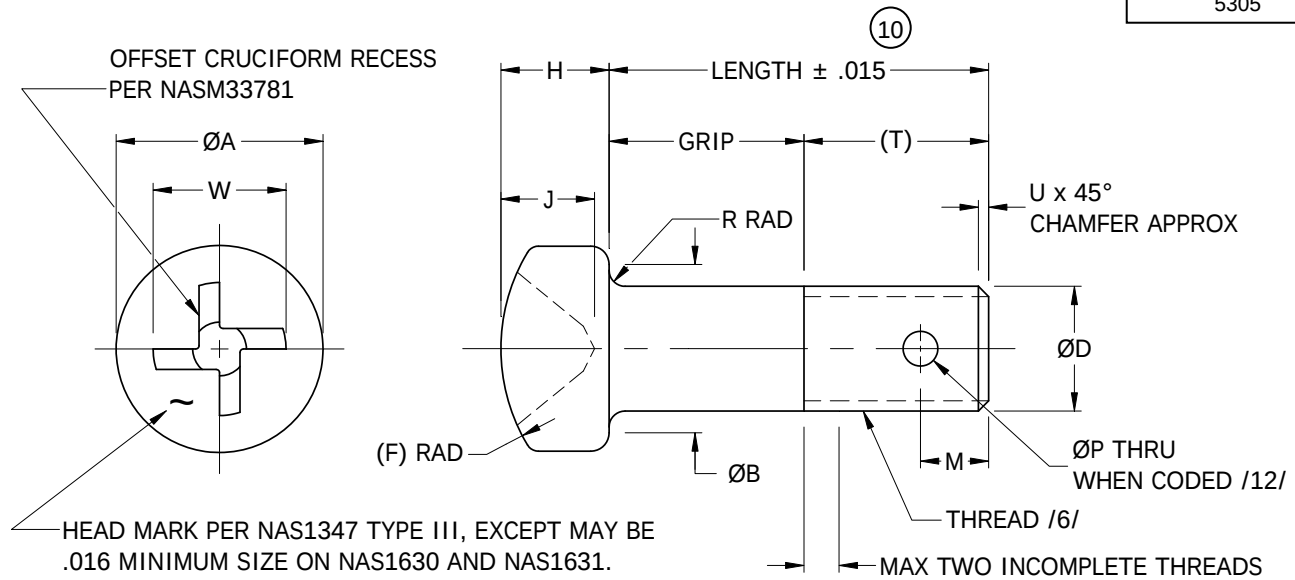


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /6/	ØA	ØB MIN	ØD	(F) RAD	H	R RAD	(T)	U	M ±.010	ØP +.010 -.000	J MAX	W MAX
NAS1630	.1120-40 UNJC-2A	.219 .205	.192	.1120 .1095	.16	.080 .070	.010 .005	.220	.020	—	—	.046	.131
NAS1631	.1380-32 UNJC-2A	.270 .256	.238	.1380 .1355	.20	.097 .087	.010 .005	.276	.031	—	—	.055	.160
NAS1632	.1640-32 UNJC-2A	.322 .306	.289	.1635 .1610	.24	.115 .105	.020 .010	.276	.031	—	—	.065	.190
NAS1633	.1900-32 UNJF-3A	.373 .357	.331	.1895 .1870	.28	.133 .122	.020 .010	.276	.031	.117	.070	.075	.219
NAS1634	.2500-28 UNJF-3A	.492 .473	.424	.2495 .2470	.37	.175 .162	.020 .010	.316	.031	.116	.076	.098	.286

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	RECESS GAGE PENETRATION /1/		TENSILE STRENGTH LBF MIN /3/ /11/		RECESS VALUES	
	MAX	MIN	GRES (140KSI)	CRES, ALLOY STEEL & TITANIUM	TORQUE IN-LBF MIN	RAISED METAL IN MAX
NAS1630	.0320	.0220	840	966	13	.005
NAS1631	.0390	.0285	1,270	1,450	30	.005
NAS1632	.0470	.0355	1,960	2,240	50	.005
NAS1633	.0540	.0415	2,800	3,180	60	.005
NAS1634	.0695	.0555	5,100	5,820	140	.005

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

REVISION DATE: AUGUST 31, 2015

ISSUE DATE: JANUARY 1960

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 10
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, MACHINE, PAN HEAD, SHORT THREAD, OFFSET CRUCIFORM	CLASSIFICATION PART STANDARD NAS1630 THRU NAS1634 SHEET 1 OF 4

MATERIAL:

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

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. PRECIPITATION HARDENING PER AMS5853. /11/

TITANIUM: 160 KSI Ft_u MIN.

FINISH:

- ALLOY STEEL NO CODE - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
CRES NO CODE - PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
"P" CODE - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. (10)
TITANIUM NONE

CODE:

BASIC PART NUMBER DESIGNATES DIAMETER AND THREAD.

DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE II).

"D" FOLLOWING DASH NUMBER DESIGNATES DRILLED THREAD. /12/

"E" IN LIEU OF DASH DESIGNATES CRES.

"P" FOLLOWING DASH NUMBER DESIGNATES AMS-QQ-P-416, TYPE II, CLASS 2 PLATING.

"V" IN LIEU OF DASH DESIGNATES TITANIUM ALLOY.

EXAMPLE OF PART NUMBER:

NAS1632-10 = .1640-32 SCREW, .625 GRIP, ALLOY STEEL, TYPE II PLATING, UNDRILLED THREAD.

~~NAS1633V8DP = .1900-32 SCREW, .500 GRIP, TITANIUM ALLOY, TYPE II PLATING, UNDRILLED THREAD.~~

NOTES:

- /1/ RECESS GAGING AND DRIVERS SHALL BE IN ACCORDANCE WITH NASM33781. /13/
(2) FOR CRES, MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, TEST METHOD 3.
/3/ TENSILE STRESS AREA USED FOR CALCULATION OF ULTIMATE TENSILE STRENGTH VALUES ARE BASED ON FED-STD-H28/2.
(4) ~~"C" CODE MATERIAL INACTIVE FOR DESIGN AFTER 1 JUNE 1971. USE "E" CODE. ("E" PARTS MAY BE DOUBLE IDENTIFIED "CE").~~
(5) ~~FOR DESCRIPTION OF STATUS NOTES, USE NAS380.~~

REVISION

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NAS1630 THRU
NAS1634

SHEET 2



Documents

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