

FED. SUPPLY CLASS

5320

1. Scope and Classification.

1.1 Scope. This specification establishes the requirements for self-locking blind fasteners which are capable of being installed when only one side of an assembly is accessible.

1.2 Classification. This specification covers blind fasteners of the following classes:

Class 1. General Purpose (usable up to 450 °F)

Class 2. High Temperature (usable up to 1200 °F)

Class 3. Light Weight (usable up to 250 °F)

Class 4. Titanium (usable up to 600 °F)

2. Applicable Documents.

2.1 The following publications of the issue in effect on the date of invitation for bids shall form a part of this specification to the extent specified herein.

2.1.1 Specifications.

Federal

QQ-A-225/6 — Aluminum Alloy 2024 Bar, Rod, and Wire; Rolled, Drawn or Cold Finished

QQ-A-225/9 — Aluminum Alloy 7075 Bar, Rod, Wire, and Special Shapes; Rolled, Drawn, or Cold Finished

QQ-A-250/13 — Aluminum Alloy Alclad 7075, Plate and Sheet

QQ-S-763 — Steel Bars, Shapes, and Forgings, Corrosion-Resisting

PPP-B-566 — Boxes, Folding, Paperboard

PPP-B-665 — Boxes, Paper board, Metal Edged and Components

Military

MIL-S-5626 — Steel, Chrome Molybdenum (4140) Bars, Rods, and Forging Stock (Aircraft Applications) UNS G41400

MIL-H-6088 — Heat Treatment of Aluminum Alloys

MIL-S-6758 — Steel, Chrome Molybdenum (4130) Bars, and Reforging Stock (Aircraft Quality)

MIL-A-8625 — Anodic Coating, for Aluminum and Aluminum Alloys

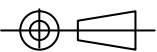
MIL-L-46010 — Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting

MIL-PRF-81329 — Lubricant, Solid Film, Extreme Environment, NATO Code Number S-1737

Copies of Federal Specification and Standards and Military Specification may be obtained upon application to the DODSSP Subscription Service Desk, Building 4D, 700 Robins Ave, Philadelphia, PA 19111-5049.

⑤ COMPLETELY REVISED

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
5

PROCUREMENT
SPECIFICATION

NONE

TITLE
**FASTENER, BLIND, ⑤
INTERNALLY THREADED, EXTERNAL SLEEVE
SELF-LOCKING**

CLASSIFICATION
SPECIFICATION

NAS1675
SHEET 1 OF 27



Documents
Document Sharing Hub

SAE International

AMS2700	Passivation Treatments For Corrosion Resistant Steel
AMS2759	Heat Treatment of Steel parts, General Requirements
AMS2770	Alloy Parts, Aluminum, Heat treatment
AMS2759/3	Heat Treatment of Precipitation-Hardening Corrosion-Resistant and Maraging Steel Parts
AMS4911	Titanium Alloy Steel 6Al-4V (UNS R56400)
AMS4928	Titanium Alloy Bars and Forgings, 6Al-4V (UNS R56400)
AMS4967	Titanium Alloy Bars and Forgings, 6Al-4V (UNS R56400)
AMS5639	Steel, Corrosion Resistant (UNS S30400)
AMS5641	Steel, Corrosion Resistant (UNS S30323)
AMS5731	Steel, Corrosion and Heat Resistant (UNS S66286)
AMS5734	Steel, Corrosion and Heat Resistant (UNS S66286)
AMS5737	Steel, Corrosion and Heat Resistant (UNS S66286)
AMS6322	Steel, Bars, Forgings and Rings (UNS G87400)
AMS6349	Steel Bars (UNS G41400)
AMS-S-6758	Steel, Chrome - Molybdenum (4130) Bars, and Reforging Stock (Aircraft Quality)
AS5272	Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting
AMS-H-81200	Heat Treatment of Titanium and Titanium Alloys
AMS-QQ-A-225/6	Aluminum Alloy 2024 Bar, Rod, and Wire; Rolled, Drawn, or Cold Finished
AMS-QQ-A-225/9	Aluminum Alloy 7075 Bar, Rod, Wire, and Special Shapes; Rolled, Drawn, or Cold Finished
AMS-QQ-A-250/13	Aluminum Alloy Alclad 7075, Plate and Sheet
AMS-QQ-P-416	Plating, Cadmium (Electrodeposited)
AMS-QQ-S-763	Steel, Corrosion Resistant, Bars, Wire, Shapes, and Forgings

Copies can be obtained from SAE International, 400 Commonwealth Dr., Warrendale, PA 15096-0001
www.sae.org

2.1.2

Standards.

Military

MIL-STD-129 Marking for Shipment and Storage

ASME

ASME B46.1 Surface Texture

Copies can be obtained from ASME, Three Park Ave., New York, NY 10016-5990 www.asme.org

American Society for Quality

ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes

Copies can be obtained from the American Society for Quality, 600 North Plankinton Ave., Milwaukee, WI 53203 www.asq.org

ASTM International

ASTM E 140	Standard Hardness Conversion Table for Metals
ASTM E 1417	Inspection, Liquid Penetrant
ASTM E 1444	Standard Practice for Magnetic Particle Inspection

Copies can be obtained from ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA, 19428-2959 USA www.astm.org

Aerospace Industries Association

⑤ COMPLETELY REVISED

REVISION
5
NAS1675
SHEET 2



Documents
SHEET 2

Document Sharing Hub

NAS672	Plating, High Strength Steels, Cadmium
NAS1069	Tension Fatigue Test, Procedure for Aeronautical Fasteners
NAS1669	Fastener, Blind, Internally Threaded, External Sleeve, General Purpose, Protruding Head, Self-Locking
NAS1670	Fastener, Blind, Internally Threaded, External Sleeve, General Purpose, Flush Head, Self-locking
NAS1671	Fastener, Blind, Internally Threaded, External Sleeve, High Temperature, Protruding Head, Self-Locking
NAS1672	Fastener, Blind, Internally Threaded, External Sleeve, High Temperature, Flush Head, Self-Locking
NAS1673	Fastener, Blind, Internally Threaded, External Sleeve, Lightweight, Protruding Head, Self-Locking
NAS1674	Fastener, Blind, Internally Threaded, External Sleeve, Lightweight, Flush Head, Millable and Non-millable, Self-Locking
NAS1750	Fastener, Blind, Internally Threaded, External Sleeve, General Purpose, Flush Head, Self-Locking, 1/64 Inch Oversize
NAS1751	Fastener, Blind, Internally Threaded, External Sleeve, General Purpose, Protruding Head, Self-Locking, 1/64 Inch Oversize
NAS1752	Fastener, Blind, Internally Threaded, External Sleeve, High Temperature, Flush Head, Self-Locking, 1/64 Inch Oversize
NAS1753	Fastener, Blind, Internally Threaded, External Sleeve, High Temperature, Protruding Head, Self-Locking, 1/64 Inch Oversize
NAS1754	Fastener, Blind, Internally Threaded, External Sleeve, Lightweight, Flush Head, Millable and Non-Millable, Self-Locking, 1/64 Inch Oversize
NAS1755	Fastener, Blind, Internally Threaded, External Sleeve, Lightweight, Protruding Head, Self-Locking, 1/64 Inch Oversize
NAS5170	Fastener - Blind, Internally Threaded, External Sleeve, Titanium, Flush Head Self-Locking
NAS5171	Fastener - Blind, Internally Threaded, External Sleeve, Titanium, Flush Head Self-Locking, .016 Inch Oversize
NAS5270	Fastener - Blind, Internally Threaded, External Sleeve, Titanium, Protruding Head, Self-Locking
NAS5271	Fastener - Blind, Internally Threaded, External Sleeve, Titanium, Protruding Head, Self-Locking, .016 Inch Oversize
NASM1312	Fastener Test Methods (MIL-STD-1312)

Copies can be obtained from the Aerospace Industries Association, 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209 www.aia-aerospace.org

3. Requirements.

3.1 Qualification. The fasteners under this specification shall be a product which has been tested according to and has passed the qualification tests specified herein. No change in dimensions, material or manufacturing procedures are permitted without requalification.

3.2 Components Parts. The fastener shall be constructed of three components defined as follows:

<u>Nut</u>	Consists of a head on the non-blind side and the shank of the fastener. The nut is internally threaded.
<u>Screw</u>	Consists of a head on the blind side and an externally threaded shank.
<u>Sleeve</u>	A malleable tubular device that expands over the end of the nut and causes the sheets of material to be drawn together.

5 COMPLETELY REVISED

REVISION
5
NAS1675
SHEET 3

NOTE: When a drawing specifies a discardable drive-nut to effect installation, it shall not be considered as a critical component and is not subject to the physical, metallurgical and traceability requirements set forth within this specification.

3.3 Material. Material for fastener components shall be as specified below:

Class 1 Nut, Screw – Alloy Steel (UNS G41400) per ~~MIL-S-5626~~ AMS6349, (UNS G87400) per AMS6322 or (UNS G41300) per ~~MIL-S-6758~~ AMS-S-6758.

Sleeve – CRES (UNS S30400) per ~~QQ-S-763~~ AMS-QQ-S-763, AMS5639 or (UNS S30323) per AMS5641.

Class 2 Nut, Screw, Sleeve – Corrosion and Heat resistant steel (UNS S66286) with Chemical Composition per AMS5731 or AMS5734.

Class 3 Nut – Aluminum Alloy (UNS A97075) per ~~QQ-A-225/9~~ AMS-QQ-A-225/9.

Screw – Alloy steel (UNS G41400) per ~~MIL-S-5626~~ AMS6349, (UNS G87400) per AMS6322 or (UNS G41300) per ~~MIL-S-6758~~ AMS-S-6758.

Sleeve – CRES (UNS S30400) per ~~QQ-S-763~~ AMS-QQ-S-763, AMS5639 or (UNS S30323) per AMS5641.

Class 4 Nut and Screw – 6Al-4V Titanium (UNS R56400) per AMS4928 or AMS4967.

Sleeve – A-286 Corrosion and Heat Resistant Steel (UNS S66286) with Chemical Composition per AMS5731, or AMS5734 or CRES (UNS S30400) per ~~QQ-S-763~~ AMS-QQ-S-763, AMS5639 or (UNS S30323) per AMS5641.

3.4 Design and Construction. The fastener configuration and all dimensions shall conform to the applicable standard drawings. All dimensions are to be met after plating and finishing.

3.4.1 Component Heads. The heads of all screws or nuts manufactured from alloy steel, titanium or corrosion and heat resistant steel shall be forged. Heads of aluminum nut may be machined from heat treated stock or forged and subsequently heat treated.

3.4.2 Threads. The thread on the screw and in the nut shall be suitable for installation of the fastener and shall provide the installed fastener with the performance required by this specification. Threads shall be left-hand. Thread form, contour and dimensions are optional except that the minimum thread root radii for externally threaded screws shall be .002.

3.4.2.1 Rolled Threads. The external thread on the screw shall be fully formed by a single thread rolling process.

3.4.3 Sheet Take-Up. The fastener sleeve shall be capable of engaging the lower surface of the lower sheet when the total sheet thickness is equal to the maximum grip of the fastener and the total gap between all sheets is .031 of an inch when tested in accordance with Section 4.

3.5 Heat Treatment. Heat treatment of fasteners manufactured to this specification shall conform to Specifications AMS-H-81200, AMS2770, AMS2759, AMS2759/3 as required to meet the strength requirements and metallurgical properties as defined herein. Aluminum components machined from heat treated stock shall have available mill certification that heat treatment was per ~~MIL-H-6088~~ AMS2772. Aluminum components heat treated by the fastener manufacturer after heading or forging shall be heat treated to AMS2770.

3.6 Protective Treatment. Protective treatment for fastener components shall be as specified below.

Class 1 Nut, Screw – Cadmium plated per AMS-QQ-P-416, Type II, Class 2 or NAS672. Nuts may be deformed after plating to provide self locking feature.

⑤ COMPLETELY REVISED

REVISION
5
NAS1675
SHEET 4



Documents

Document Sharing Hub

Sleeve – Passivate per AMS2700, Method 1, Class 4, Cadmium plate per AMS-QQ-P-416, Type I, Class 3.

Class 2 Nut, Screw and Sleeve – Passivate per AMS2700, Method 1, Class 4.

Class 3 Nut – Anodize per MIL-A-8625, Type II. Clear on nominal diameters, green on oversize diameter fasteners.

Screw – Cadmium plate per AMS-QQ-P-416, Type II, Class 2 or NAS672.

Sleeve – Passivate per AMS2700, Method 1, Class 4. Cadmium plate per AMS-QQ-P-416, Type I, Class 3.

Class 4 Nut & Screw – None

Sleeve – Passivate per AMS2700, Method 1, Class 4.

3.6.1 Embrittlement Relief. Alloy steel components plated in accordance with AMS-QQ-P-416, shall, within four hours, be heated to a temperature of 375 °F ± 25 °F and held at this temperature for a minimum of 23 hours.

3.7 Lubrication. Unless otherwise specified on the applicable part standard, the following lubricants may be applied by the fastener manufacturer to any or all components to facilitate driving:

Solid Film Lube per MIL-L-46010 AS5272, Type I or MIL-L-46010, Type III
Graphite Free Dry Film Lube per MIL-PRF-81329
Cetyl Alcohol lube
Paraffin Wax
Carbo Wax

There shall be no deterioration of the lubricant adversely affecting fastener installation within two years after delivery of fasteners.

3.8 Mechanical Properties.

3.8.1 Double Shear Strength. The double shear strength shall be as specified in Table I when tested in accordance with Section 4.6.2.

3.8.2 Single Shear Lap Joint Strength. Single shear lap joints as defined in Paragraph 4.6.3 shall have the strength shown in Table V when tested in accordance with Section 4.6.3.

3.8.3 Tensile Strength. The tensile strength shall be as specified in Table I when tested in accordance with Section 4.6.4. The fastener tensile strength as listed in Table I is defined as the load level at which the slope of the fastener load-deflection curve becomes zero for the first time. This is the "first peak tension strength" of the fastener, not the ultimate or breaking strength of the fastener which may follow some component failure within the fastener on the second or third peaking of the load.

TABLE I – STRENGTH REQUIREMENTS

Double Shear Strength (Min.) Pounds				
Fastener Size	Class 1	Class 2	Class 3	Class 4
08	3355	2700	1920	3150
3	5240	4530	3100	4600
4	9000	7200	5300	7900
5	12000	10350	–	11350
6	19500	15750	–	16450

⑤ COMPLETELY REVISED

REVISION

5

NAS1675
SHEET 5



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America, Inc. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS. Licensee= www.sepana.ir/5991803002, User=sam, albert
No reproduction or networking permitted without license from IHS. Not for Resale, 01/04/2016 22:37:17 MST TRADEMARKS RIGHTS.

Full document details: AIA NAS1675 2011

Tensile Strength (Min.) Pounds				
Fastener Size	Class 1	Class 2	Class 3	Class 4
08	900	820	750	900
3	1400	1400	950	1400
4	2100	2100	1500	2100
5	3600	3600	—	3600
6	5600	5600	—	5600

3.8.4 Clamp-Up Pre-Load. The fastener shall be capable of a tension pre-load of 20% of the tensile strength as specified in Table I when tested in accordance with Section 4.6.5.

For Class 4 only. The maximum pre-load shall not exceed 80% of the actual ultimate failure load of either the screw or nut when tested per Paragraph 4.6.4.2.

3.8.5 Vibration Endurance. Fasteners shall be capable of withstanding vibration endurance requirements when installed and tested as specified in Section 4.6.7.

3.8.6 Tension-Tension Fatigue Life. The fasteners shall be capable of sustaining an average fatigue life of 30,000 cycles and a minimum fatigue life of 15,000 cycles in tension-tension fatigue when tested in accordance with Section 4.6.8.

3.8.7 Hardness. All alloy steel components shall be within the hardness ranges of 39–43 HRC, HR30N 58.5–62 or HR45N 42–46.5 and all heat resistant steel nuts and screws shall be within the hardness range of 30–45 HRC when tested in accordance with Section 4.6.9.

3.9 Metallurgical Properties.

3.9.1 Surface Effects. The alloy steel components shall show no visual evidence of carbon enrichment, nitrogenization or other case hardening and there shall be no complete decarburization. Partial decarburization shall not extend more than .003 inch from the surface of heads, head to shank fillets, shanks or threads when examined as specified in Paragraph 4.6.10.

3.9.2 Discontinuities. Fastener components shall be examined as specified in Section 4. Any components having discontinuities equal to or exceeding the following limitations shall be rejected. Care must be exercised to avoid confusing cracks, as defined herein, with other discontinuities.

3.9.2.1 Cracks. Fastener components shall be free of cracks in any direction or location. A crack is defined as a clean crystalline break passing through the grain or grain boundary with or without the inclusion of foreign elements.

3.9.2.2 Laps and Seams. Fastener components may possess laps and seams, except in locations specified in 3.9.2.3 and 3.9.2.4. The depth shall not exceed the amounts specified in Table II. A lap is a surface defect caused by folding over hot metal fin or sharp corners and then rolling or forging them into the surface; but not welding them. A seam is a lap that has been closed but not welded.

TABLE II – DEPTH LIMITS FOR LAPS, SEAMS AND DISCONTINUITIES (IN INCHES)

Components	Fastener Size Class 1, 2, 3 only				
	08	3	4	5	6
Nut	.010	.010	.010	.010	.012
Screw	.002	.002	.004	.005	.005
Sleeve	.002	.002	.003	.004	.005
	Class 4 only				
Nut	.005	.005	.005	.005	.006
Screw	.002	.002	.004	.005	.005
Sleeve	.002	.002	.003	.004	.005

REVISION

5

NAS1675
SHEET 6



Document Sharing Hub

5 COMPLETELY REVISED

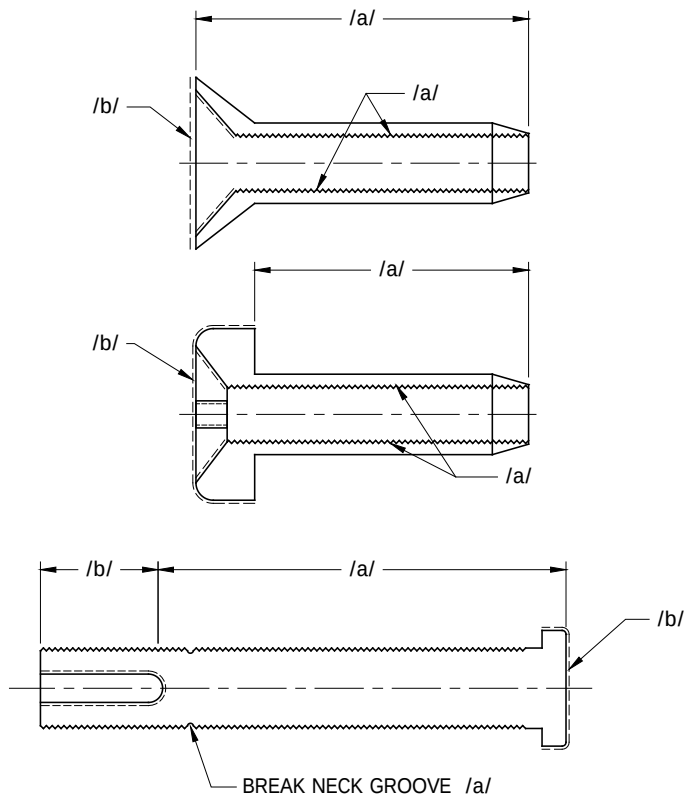
USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America, Inc. ALL RIGHTS RESERVED. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS. ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABLE LAWS, REGULATIONS, ORDINANCES, OR OTHER REQUIREMENTS.
No reproduction or networking permitted without license from IHS. Licensee: www.sepana.ir/5991803002, User=sam, albert
Not for Resale, 01/04/2016 22:37:17 MST TRADEMARK RIGHTS.

Full document details: AIA NAS1675 2011

- 3.9.2.3 Nut Discontinuities. Nuts shall not possess discontinuities such as seams, inclusions, nicks, folds, or gauges exceeding the depth limits shown in Table II. Discontinuities shall not be permitted on the head-to-shank fillet.
- 3.9.2.4 Screw Discontinuities. Laps are sometimes formed in the rolling of threads. Laps which are not permissible are illustrated in Figure 2. Laps not exceeding the limits of Table II which are permissible are also illustrated in Figure 2. Small surface irregularities on the crest of the thread as shown in Figure 2 are permissible within limits specified in Table II. Discontinuities shall not be permitted on the head-to-shank fillet.
- 3.9.2.5 Sleeves. No longitudinal discontinuities shall be permitted.
- 3.9.3 Hydrogen Content. Class 4 Titanium components shall not have hydrogen exceeding .0125% (125 PPM) when examined per Paragraph 4.6.15.
- 3.9.4 Metallurgical Condition. (Class 4 only) Microstructure of titanium components shall be free from indication that it has been heated to a temperature above Beta transus without subsequently receiving a significant mechanical reduction in the Alpha-Beta temperature range. Slight overheating on the non-bearing surfaces of the nut and corebolt heads is permissible providing measurement perpendicular to the surface does not exceed two times the value specified for the applicable component in Table II. (Structure of 6Al-4V alloys which has outlines of equiaxed prior all Beta grains and no primary Alpha is considered overheated.)

Titanium components shall not show evidence of Alpha case in excess of the limitations of Figure 1 when examined as specified in Paragraph 4.6.14.



- /a/ No Alpha Case Permitted
- /b/ Alpha Case Permitted to a Max Depth of .002

FIGURE 1 – ALPHA CASE LIMITATIONS

5 COMPLETELY REVISED

REVISION
5
NAS1675
SHEET 7



Documents

Document Sharing Hub

- 3.10 **Installation.** Fasteners shall drive consistently when installed and examined in accordance with Section 4.
- 3.11 **Identification of Product.** Each fastener assembly shall be permanently and legibly marked as specified on the applicable NAS drawing.
- 3.12 **Locking Features.** Prevailing torque shall be as specified in Table VIII when tested in accordance with Section 4.6.13.

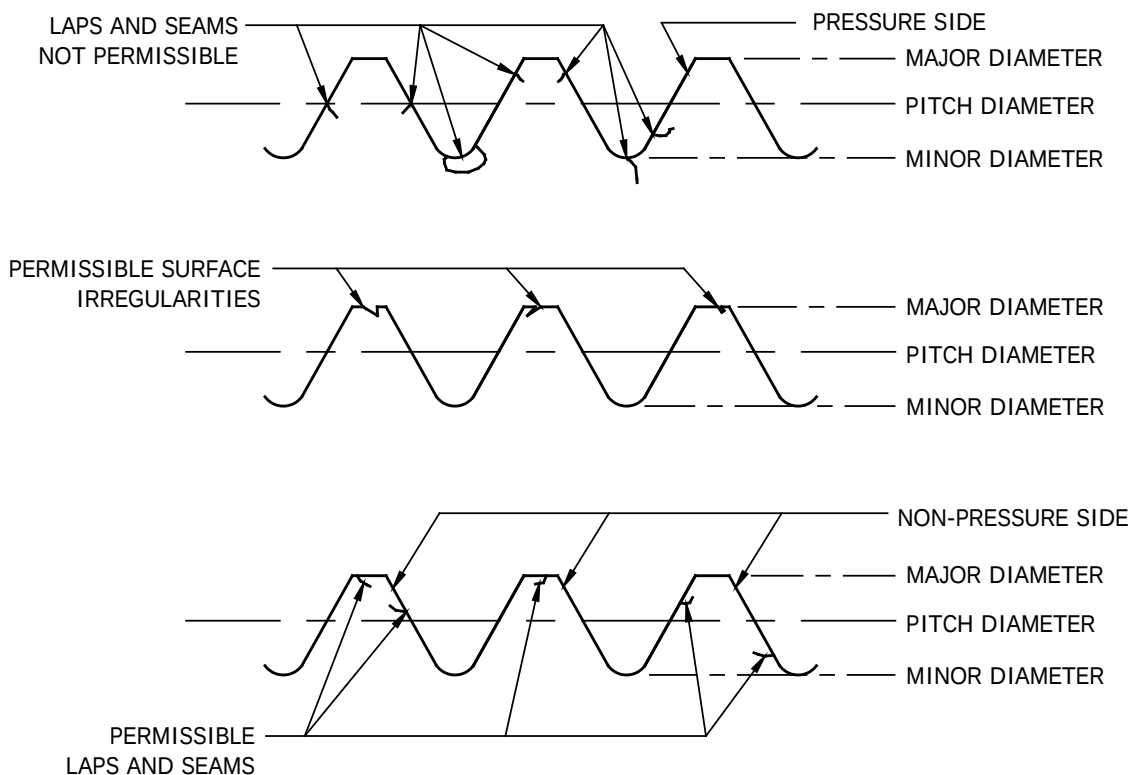


FIGURE 2 – PERMISSIBLE AND NON-PERMISSIBLE LAPS, SEAMS AND SURFACE IRREGULARITIES

4. **QUALITY ASSURANCE PROVISIONS.**

- 4.1 **Responsibility for Inspection.** The supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified the supplier may utilize his own or any other adequate facilities. Inspection records of the examination and tests shall be maintained and shall be available to the buyer on request. The buyer reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to insure compliance with the prescribed requirements.
- 4.2 **Lot Definition.**
- 4.2.1 **Component Production Lot.** A component production lot is a quantity of blind fastener components (e.g., screws, nuts or sleeves) of identical configuration fabricated from the same heat of material by the same procedures, heat treated and processed as a controlled batch.

⑤ COMPLETELY REVISED

REVISION
5
NAS1675
SHEET 8



Documents

Document Sharing Hub

- 4.2.2 Assembly Production Lot. An assembly production lot is a quantity of blind fastener assemblies in which each of the three components represents a single component production lot. The producer must maintain a record defining the component production lots which make up each assembly production lot.
- 4.2.3 Inspection Lot. An inspection lot is that portion of an assembly lot which is procured as one purchase order item. An inspection lot may be received in parts through more than one shipment. Records shall be maintained for a minimum period of five (5) years after completion of fabrication.
- 4.3 Classification of Examination and Tests. The inspection and testing of blind fasteners shall be classified as follows:
- Initial Qualification (4.4)
 - Quality Conformance Inspection (4.5)
- 4.4 Initial Qualification. Initial qualification shall consist of all the examinations and tests defined in Paragraph 4.6. Initial qualification must be accomplished for each diameter and class of blind fastener qualified. Qualification on the flush head configuration constitutes qualification of the equivalent protruding head configuration except for tensile strength and tension-tension fatigue testing which shall be performed on both head styles.
- 4.4.1 Sampling Instructions. Initial qualification sample sizes are as defined in Table III.

TABLE III – SAMPLING FOR QUALIFICATION

	TEST	NO. OF SAMPLES		TEST METHOD
		Class 1,2,3	Class 4	
/a/ {	Dimension Examination	5	5	4.6.1
	Discontinuities	5	All Samples	4.6.11
	Double Shear	5	5	4.6.2
	Single Shear Lap Joint	10	10	4.6.3
/a/ {	Tensile Strength	5	10	4.6.4
	Clamp-Up Preload	5	10	4.6.5
	Sheet Take-Up	5	5	4.6.6
	Vibration Endurance	16 (12)	16 (12)	4.6.7
/a/ {	Tension-Tension Fatigue	5	5	4.6.8
	Hardness	5	–	4.6.9
	Surface Effects	5	–	4.6.10
	Installation – Group A	100	20	4.6.12
	Group B	100	20	4.6.12
	Group C	100	20	4.6.12
	Locking Feature-Prevailing Torque	5	5	4.6.13
	Hydrogen Content	–	1	4.6.15
	Metallurgical Condition	–	2	4.6.14

/a/ When two tests are shown bracketed together, the sample may be used for both tests.

- 4.4.2 Certified Test Report. The manufacturer shall maintain on file a certified test report showing that the manufacturer's product satisfactorily conforms to this specification. The test report shall include as a minimum the actual results of each of the tests specified herein. The certified test report shall be accompanied by a detailed drawing which completely describes the manufacturer's product by specifying all dimensions and tolerances, composition of material selected, finishes, plating and lubricants applied and the heat treatment. The manufacturer's part number for each diameter, length and class shall be included for each test listed in Table III.
- 4.5 Quality Conformance Inspection. Quality conformance inspection is accomplished by the supplier on every assembly lot of blind fasteners. Any test which is appropriate to a blind fastener component and is accomplished on a sampling of a component production lot need not be repeated on a sampling of an assembly production lot. Minimum quality conformance inspection consists of the following:

⑤ COMPLETELY REVISED

REVISION
5
NAS1675
SHEET 9



Documents

Document Sharing Hub