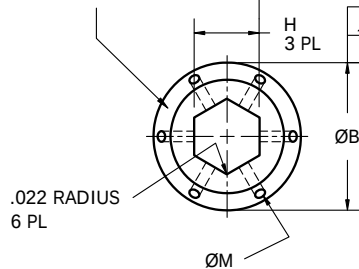


FED. SUPPLY CLASS

5306

HEAD MARKING PER
NAS1347, TYPE IV,
ON TOP OR TAPERED
SLOPE OF HEAD /b/



6 LOCKWIRE HOLES
WHEN DRILLED HEAD IS
SPECIFIED IN PART NUMBER

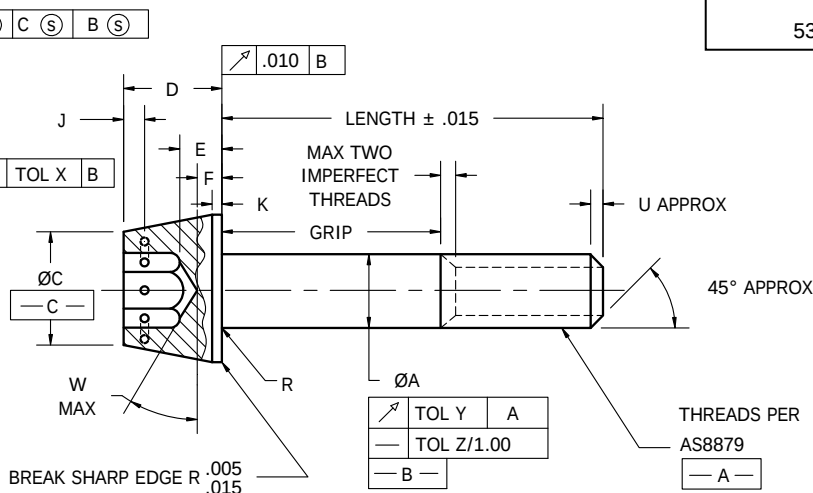


TABLE I – DIMENSIONS

BASIC PART NUMBER	THREAD	ØA		ØB		ØC	D	E	F MIN	H HEX		J	K	ØM +.005 -.000	R		U	W DEGREES MAX	RUNOUT & SHANK STRAIGHTNESS TOLERANCE			TENSILE LBS MIN
		MAX	MIN	MAX	MIN					MAX	MIN				MAX	MIN			X	Y	Z	
NAS172	1.2500-12 UNJF-3A	1.249	1.243	2.125	2.100	1.731	1.205	.548	.320	1.256	1.251	.188	.125	.070	.089	.072	.094	19	.025	.0090	.0020	162,600

MATERIAL:

ALLOY STEEL – 4140 (UNS G41400) PER AMS6382, E4340 (UNS G43406) PER AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER AMS6322, AMS6325 OR AMS6327.

HEAT TREATMENT:

HEAT TREAT: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 OR AMS2759.

160-180 KSI Ft_u

INACTIVE FOR NEW DESIGN AFTER 16 OCTOBER 1980. FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

(10) COMPLETELY REVISED

FORM 09-01	THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE		REVISION 10	
	PROCUREMENT SPECIFICATION	TITLE BOLT, INTERNAL WRENCHING, STEEL, 1.2500-12		CLASSIFICATION PART STANDARD	
	NOTED	(10)		NAS172 SHEET 1 OF 3	

FINISH:

CADMIUM PLATING PER AMS-QQ-P-416, TYPE II, CLASS 2.

CODE:

ADD "DH" TO THE PART NUMBER TO DESIGNATE DRILLED HEAD.
FOR SUFFIX DASH NUMBER TO DESIGNATE GRIP AND LENGTH, SEE TABLE II.

EXAMPLE OF PART NUMBER:

NAS172-28 = 1.2500-12 BOLT, 1.750 INCHES LONG, UNDRILLED.
NAS172DH28 = 1.2500-12 BOLT, 1.750 INCHES LONG, DRILLED HEAD.

NOTES:

- (1) SURFACE ROUGHNESS: SHANK, HEAD BEARING SURFACE, AND THREADS: 32 MICROINCHES Ra; FILLET RADIUS: 20 MICROINCHES Ra; ALL OTHER SURFACES: 125 MICROINCHES Ra PER ASME B46.1.
- (2) MAGNETIC PARTICLE INSPECTION: 100% PER ASTM E 1444.
- (3) TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm .010$.
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (5) APPLICABLE WASHERS, MS20002 AND NAS1587.
- (6) REMOVE ALL BURRS AND SHARP EDGES.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (9) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
- (10) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

PROCUREMENT SPECIFICATION:

NAS4002 EXCEPT:

- (a) PERIPHERY OF TAPERED HEAD AND SOCKET RECESS MAY BE MACHINED.
- /b/ "R" ON HEAD OR POINT END OF BOLT INDICATES THREADS HAVE BEEN ROLLED AFTER HEAT TREAT.
- (c) TRACES OF PARTIAL DECARBURIZATION MAY APPEAR IN A LAYER NOT TO EXCEED .004.
- (d) COLD WORK OF HEAD TO SHANK FILLET RADIUS NOT REQUIRED.
- (e) FATIGUE CAPABILITIES AND TESTS NOT REQUIRED.

⑩ COMPLETELY REVISED

REVISION

10

NAS172
SHEET 2



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