

FED. SUPPLY CLASS

5310

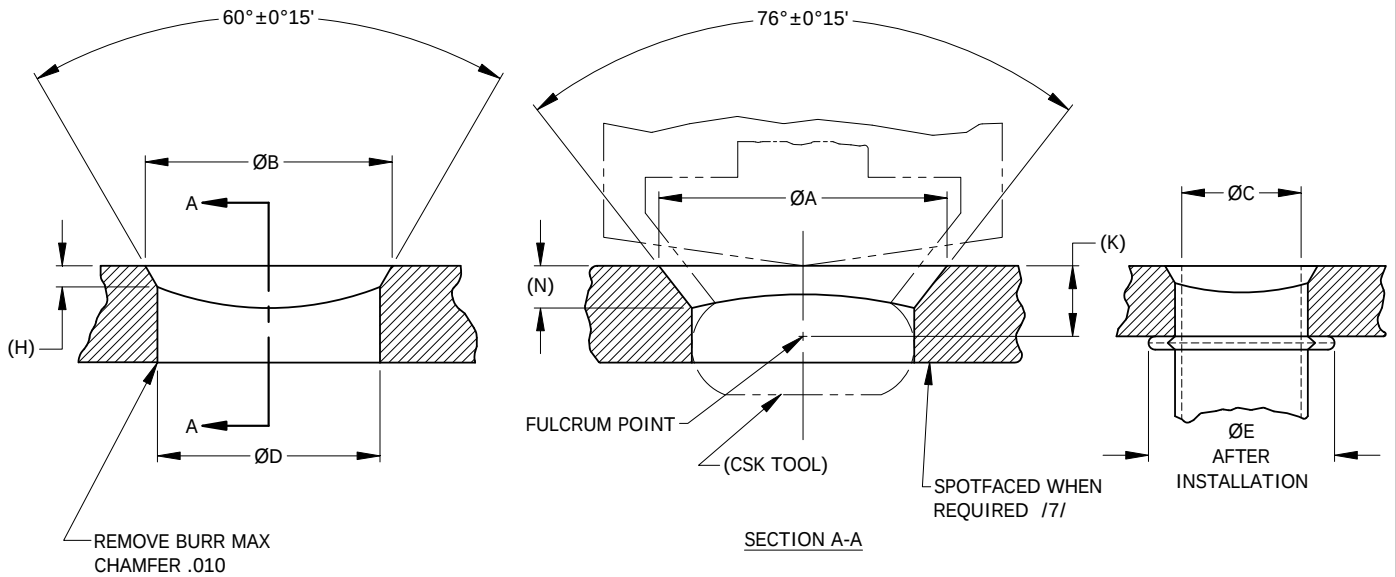


TABLE I – HOLE PREPARATION

REQUIREMENT IDENTIFIER CALLOUT	ØA ±.005 /5/	ØB ±.005 /5/	ØC AFTER INSTALLATION MIN	D HOLE		(ØE)	(H)	(N)	(K)
				PILOT REAM Ø ±.003	ØD				
NAS1736-3	.331	.280	.192	.191	.245 .242	.370	.034	.058	.080
NAS1736-4	.438	.372	.252	.250	.332 .328	.475	.040	.072	.100
NAS1736-5	.520	.446	.315	.312	.401 .397	.565	.044	.080	.100
NAS1736-6	.623	.526	.377	.375	.477 .472	.660	.048	.098	.160
NAS1736-7	.706	.600	.439	.437	.545 .540	.705	.054	.108	.160
NAS1736-8	.794	.680	.502	.500	.620 .615	.800	.058	.116	.160
NAS1736-9	.882	.760	.564	.562	.694 .689	.880	.063	.121	.160
NAS1736-10	.978	.848	.627	.625	.775 .770	.975	.069	.135	.160
NAS1736-12	1.167	1.008	.752	.750	.924 .919	1.135	.079	.160	.220

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	NONE

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE
TITLE NUT, SELF-LOCKING, BLIND RIVET, ELLIPTICAL HEAD, INSTALLATION DATA FOR

REVISION 3
CLASSIFICATION DESIGN STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

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.

FORM 12-01

REVISION DATE: MARCH 31, 2015

ISSUE DATE: APRIL 1968

HOLE PREPARATION

THE NECESSARY DATA FOR HOLE PREPARATION ARE SHOWN IN TABLE I AND THE FIGURE.

NOTES (HOLE):

- (1) DRILL "ØD" HOLE. SEE TABLE I.
- (2) SELECT A CUTTER AND STOP-ROCKER THAT AGREES WITH THE HOLE DIAMETER CALLOUT.
NOTE:
 - (1) CARBIDE BURR TOOLS ARE RECOMMENDED FOR COUNTERSINKING HOLES IN STEEL OR TITANIUM, AND GRAPHITE.
 - (2) HIGH SPEED TOOL STEEL IS RECOMMENDED FOR COUNTERSINKING HOLES IN HIGH STRENGTH ALUMINUM ALLOY.
- (3) ASSEMBLE THE CUTTER AND STOP-ROCKER.
- (4) ADJUST THE STOP-ROCKER ASSEMBLY TO THE CUTTER DEPTH "H" TABLE I, FOR THE APPLICABLE HOLE SIZE CALLOUT.
- /5/ WITH THE STOP-ROCKER ASSEMBLY IN LINE WITH THE CENTERLINE OF THE HOLE, MAKE THE 60° COUNTERSINK. THEN, ROCK THE STOP-ROCKER ASSEMBLY IN EITHER DIRECTION UNTIL THE 8° TAPERED FACE OF THE STOP-ROCKER MAKES CONTACT WITH THE MATERIAL IN WHICH THE COUNTERSINK IS BEING MADE. THEN, PERFORM THE SAME OPERATION IN THE OPPOSITE DIRECTION. STANDARD SHOP PRACTICE PERTAINING TO CUTTER COOLANT SHOULD BE FOLLOWED.
NOTE:
 - (1) BEFORE MAKING PRODUCTION COUNTERSINK, IT IS RECOMMENDED THAT THE ABOVE OPERATION BE PERFORMED IN A TEST COUPON.
 - (2) CHECK HEAD FLUSHNESS USING NUTS FROM THE LOT WHICH ARE TO BE INSTALLED.
 - (3) HEAD FLUSHNESS SHOULD BE $\pm .003$.
 - (4) RE-ADJUSTMENT OF THE CUTTER DEPTH "H" MAY BE NECESSARY TO OBTAIN REQUIRED FLUSHNESS.
- (6) THE INSIDE DIAMETER "ØC" OF THE UNTHREADED PORTION OF THE NUT SHALL BE WITHIN THE LIMITS SPECIFIED IN TABLE I AFTER INSTALLATION.
- /7/ SPOTFACE IS REQUIRED FOR NUT BULBS IF THE ANGLE NORMAL TO THE CENTERLINE OF THE HOLE AND THE UNDER STRUCTURE EXCEEDS 3°. THE SPOTFACE DIAMETER SHALL BE A MINIMUM OF .050 LARGER THAN THE NUT BULB DIAMETER.
- (8) THE MANUFACTURED HEAD OF THE NUT SHALL BE INSTALLED NORMAL TO THE STRUCTURE WITHIN 1°.

EXAMPLE OF REQUIREMENT IDENTIFIER CALLOUT FOR NUT INSTALLATION:

INSTALL PER NAS1736-4

HOLE SIZE AND INSTALLATION DATA FOR INSTALLING
NAS1734 OR NAS1735 NUT HAVING .2500-28 THREAD

BASIC NUMBER

REVISION

3

NAS1736
SHEET 2



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