

FED. SUPPLY CLASS

5306

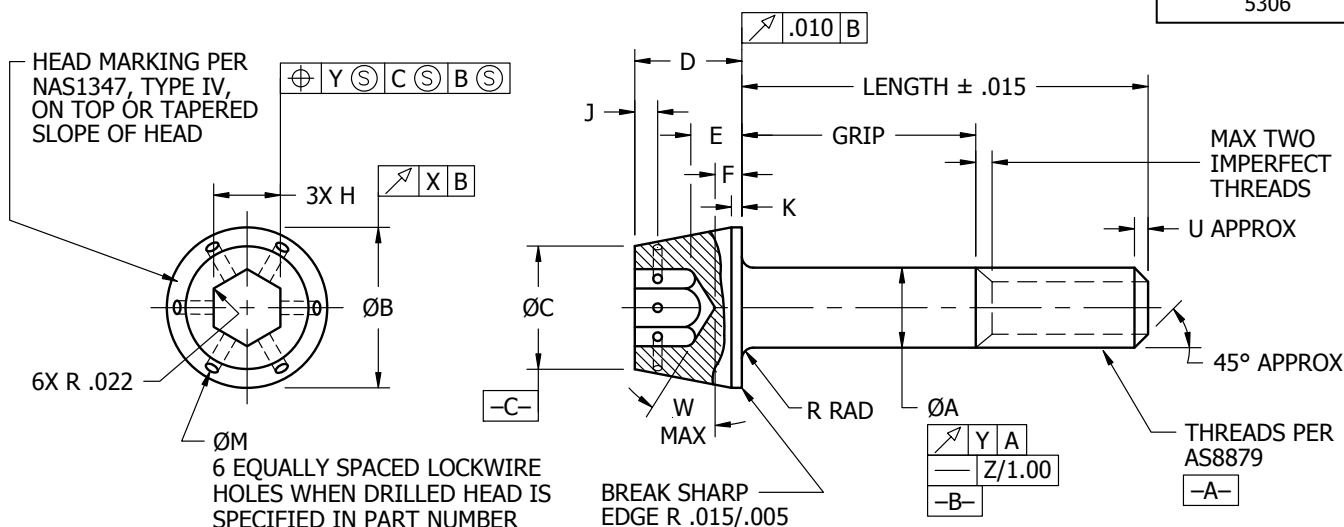


TABLE I - DIMENSIONS

BASIC PART NUMBER	THREAD	ØA		ØB		ØC	D	E	F MIN	H HEX	
		MAX	MIN	MAX	MIN					MAX	MIN
NAS174	1.3750-12 UNJF-3A	1.374	1.368	2.313	2.283	1.898	1.351	.614	.352	1.382	1.376

BASIC PART NUMBER	J	K	ØM +.005 -.000	R RAD		U	W DEGREES MAX	RUNOUT & SHANK STRAIGHTNESS TOLERANCE			TENSILE TEST LBF MIN
				MAX	MIN			X	Y	Z	
NAS174	.188	.125	.070	.089	.072	.094	20	.025	.009	.002	200,300

MATERIAL:

ALLOY STEEL IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759: 160-180 KSI FTU.

FINISH:

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

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		
	NOTED	TITLE BOLT, INTERNAL WRENCHING, STEEL, 1.3750-12	CLASSIFICATION PART STANDARD NAS174 SHEET 1 OF 3

CODE:

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

EXAMPLES OF PART NUMBER:

NAS174-30 = 1.3750-12 BOLT, 1.875 INCHES LONG, UNDRILLED.
NAS174DH30 = 1.3750-12 BOLT, 1.875 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 E1444.
- (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) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (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) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.

PROCUREMENT SPECIFICATION:

NAS4002 EXCEPT:

- (a) PERIPHERY OF TAPERED HEAD AND SOCKET RECESS MAY BE MACHINED.
- (b) "R" RAD ON HEAD OR POINT END OF BOLT INDICATES THREADS HAVE BEEN ROLLED AFTER HEAT TREATMENT.
- (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

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NAS174
SHEET 2



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Full document details: AIA NAS174 2012