

FED. SUPPLY CLASS

5306

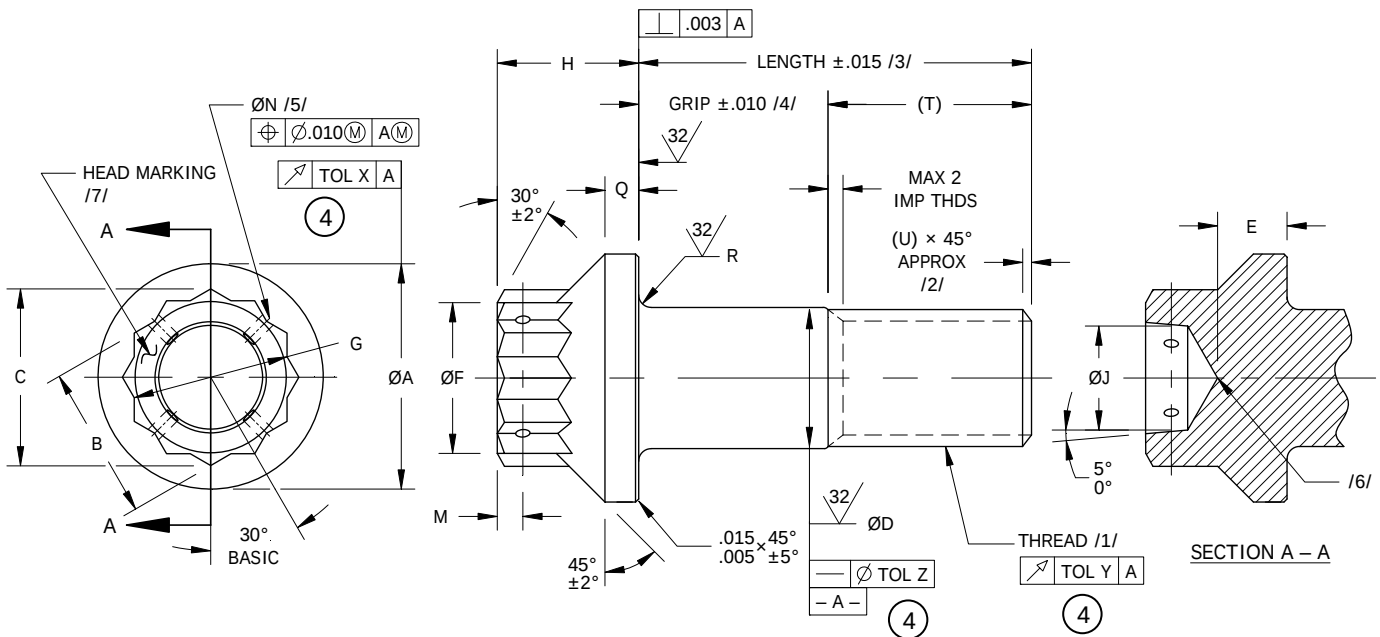


TABLE I – DIMENSIONS

DIA DASH NO.	THREAD SIZE UNJF-3A /1/	ØA ±.005	B		C MIN	ØD		E MIN	ØF +.000 -.015	G MAX	H HEIGHT ±.010	ØJ +.010 -.030	M ±.010
			WIDTH			MAX	MIN						
			MAX	MIN									
3	.1900-32	.364	.251	.243	.277	.1895	.1885	.092	.250	.262	.214	.125	.062
4	.2500-28	.470	.313	.304	.347	.2495	.2485	.135	.312	.327	.254	.180	.062
5	.3125-24	.580	.376	.367	.418	.3120	.3110	.169	.375	.392	.319	.215	.070
6	.3750-24	.644	.439	.430	.490	.3745	.3735	.197	.437	.458	.388	.260	.070
7	.4375-20	.745	.502	.492	.561	.4370	.4360	.228	.500	.524	.435	.320	.070
8	.5000-20	.823	.564	.553	.637	.4995	.4985	.254	.562	.588	.504	.380	.094
9	.5625-18	.933	.627	.616	.703	.5615	.5605	.287	.625	.654	.557	.440	.094
10	.6250-18	1.045	.690	.679	.775	.6240	.6230	.327	.687	.720	.618	.500	.094
12	.7500-16	1.225	.814	.803	.917	.7490	.7480	.380	.812	.849	.711	.570	.094
14	.8750-14	1.433	.940	.928	1.059	.8740	.8730	.438	.937	.980	.808	.650	.125
16	1.0000-12	1.620	1.064	1.052	1.200	.9990	.9980	.493	1.062	1.110	.923	.740	.125
18	1.1250-12	1.870	1.252	1.239	1.414	1.1240	1.1225	.556	1.250	1.306	1.051	.840	.125
20	1.2500-12	2.120	1.314	1.301	1.484	1.2490	1.2475	.636	1.312	1.371	1.155	.950	.125
22	1.3750-12	2.308	1.440	1.427	1.628	1.3740	1.3725	.698	1.437	1.502	1.266	1.070	.188
24	1.5000-12	2.495	1.627	1.614	1.842	1.4990	1.4975	.750	1.625	1.695	1.434	1.200	.188
28	1.7500-12	3.300	2.190	2.176	2.484	1.7490	1.7470	.917	2.188	2.284	1.951	1.488	.188

REVISION DATE: DECMEBER 19, 2014

ISSUE DATE: DECEMBER 1974

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

4

PROCUREMENT SPECIFICATION

TITLE

**BOLT, TENSION, 12-POINT, EXTERNAL WRENCHING,
220 KSI MIN F_{tu} , 132 KSI MIN F_{su} ,
H-11 STEEL, 900 °F**

CLASSIFICATION
PART STANDARD

NOTED

NAS1785
SHEET 1 OF 4

SHEET 1 OF 4

TABLE I – DIMENSIONS (CONTINUED)

DIA DASH NO.	THREAD SIZE UNJF-3A /1/	ØN ±.005	Q LAND ±.010	R RAD		(T)	(U) CHAM.	POSITIONAL TOLERANCES		
				MAX	MIN			X	Y	Z PER INCH OF BOLT
3	.1900-32	.037	.050	.041	.031	.390	.039	.005	.0045	.0030
4	.2500-28	.037	.042	.041	.031	.500	.045	.005	.0045	.0030
5	.3125-24	.055	.050	.041	.031	.593	.052	.006	.0045	.0030
6	.3750-24	.055	.091	.057	.047	.643	.052	.008	.0045	.0030
7	.4375-20	.055	.099	.057	.047	.733	.062	.009	.0060	.0030
8	.5000-20	.055	.123	.057	.047	.813	.062	.010	.0060	.0030
9	.5625-18	.055	.133	.057	.047	.910	.068	.011	.0060	.0030
10	.6250-18	.055	.150	.073	.063	.970	.068	.012	.0060	.0030
12	.7500-16	.055	.178	.073	.063	1.151	.078	.015	.0060	.0030
14	.8750-14	.055	.198	.073	.063	1.337	.089	.018	.0090	.0030
16	1.0000-12	.055	.222	.073	.063	1.523	.104	.020	.0090	.0030
18	1.1250-12	.055	.258	.073	.063	1.683	.104	.022	.0090	.0030
20	1.2500-12	.055	.269	.087	.077	1.823	.104	.025	.0090	.0030
22	1.3750-12	.055	.274	.087	.077	1.983	.104	.028	.0120	.0030
24	1.5000-12	.055	.335	.087	.077	2.133	.104	.030	.0120	.0030
28	1.7500-12	.055	.365	.087	.077	2.443	.104	.030	.0120	.0030

MATERIAL: STEEL – H-11 (UNS T20811) PER AMS6487

HEAT TREATMENT:

BOLTS SHALL BE HARDENED TO DEVELOP THE MECHANICAL PROPERTIES SPECIFIED.
SEE PROCUREMENT SPECIFICATION.

FINISH: DIFFUSED NICKEL-CADMIUM PLATE PER AMS2416, WITH CHROMATE TREATMENT

CODE:

DIA DASH NUMBER INDICATES NOMINAL SHANK DIAMETER IN .0625 INCREMENTS.
LETTER "H" BETWEEN DIA AND GRIP DASH NUMBERS INDICATES DRILLED HEAD.
GRIP DASH NUMBER INDICATES GRIP LENGTH IN .0625 INCREMENTS.
THE LETTER "X" FOLLOWING THE GRIP DASH NUMBER DESIGNATES .0156 OVERSIZE.
THE LETTER "Y" FOLLOWING THE GRIP DASH NUMBER DESIGNATES .0312 OVERSIZE.

EXAMPLE OF PART NUMBER:

NAS1785 - 8 H 24 X

NOMINAL/OVERSIZE SHANK CODE:
NO CODE = NOMINAL DIA SHANK
"X" = .0156 OVERSIZE DIA SHANK
"Y" = .0312 OVERSIZE DIA SHANK

GRIP DASH NUMBER

DRILLED HEAD OPTION:
"_" = UNDRILLED HEAD
"H" = DRILLED HEAD

DIA DASH NUMBER

BASIC NUMBER

REVISION

4

NAS1785
SHEET 2



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