

FED. SUPPLY CLASS

5305

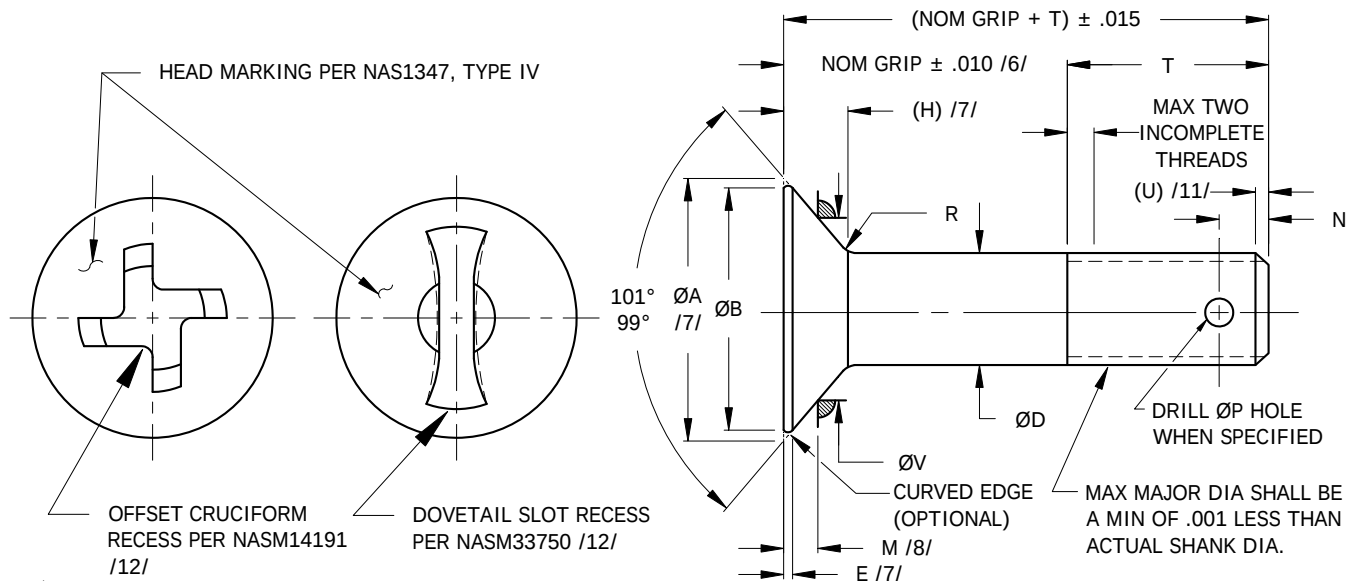


FIGURE 1 – 100° FLUSH HEAD BOLT

TABLE I – DIMENSIONS

FIRST DASH NO.	THREAD UNJF-3A	ØA MAX /7/	ØB MIN	ØD		E MAX /7/	(H) /7/	M GAGE PROT /8/	N	ØP	R RAD	T	(U) /11/	ØV GAGE	Y FIM /9/	Z FIM /10/
				PLATED	UN- PLATED											
3	.1900-32	.381	.339	.1895 .1885	.1895 .1890	.015	.083	.0285 .0255	.126 .106	.080 .070	.035 .015	.338	.050	.3147 .3145	.005	.0040
4	.2500-28	.506	.464	.2495 .2485	.2495 .2490	.015	.111	.0338 .0309	.126 .106	.086 .076	.035 .015	.425	.050	.4245 .4243	.006	.0030
5	.3125-24	.634	.578	.3120 .3110	.3120 .3115	.015	.140	.0409 .0370	.130 .110	.086 .076	.045 .025	.469	.060	.5389 .5387	.007	.0030
6	.3750-24	.760	.717	.3745 .3735	.3745 .3740	.015	.167	.0459 .0422	.130 .110	.116 .106	.045 .025	.578	.060	.6532 .6530	.008	.0025
7	.4375-20	.889	.826	.4370 .4360	.4370 .4365	.022	.195	.0470 .0425	.134 .114	.116 .106	.055 .035	.694	.080	.7784 .7782	.009	.0025
8	.5000-20	1.014	.951	.4995 .4985	.4995 .4990	.022	.222	.0529 .0482	.134 .114	.116 .106	.055 .035	.735	.080	.8902 .8900	.010	.0020
9	.5625-18	1.141	1.071	.5615 .5605	.5615 .5610	.025	.250	.0590 .0541	.134 .114	.151 .141	.055 .035	.840	.090	1.0028 1.0026	.010	.0020
10	.6250-18	1.272	1.201	.6240 .6230	.6240 .6235	.025	.280	.0683 .0631	.134 .114	.151 .141	.055 .035	.902	.090	1.1124 1.1122	.010	.0020

⑤ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 5
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, 100° FLUSH HEAD, 160 KSI UTS	CLASSIFICATION PART STANDARD
		NAS1790 SHEET 1 OF 6



Documents
SHEET 1 OF 6

OFFSET CRUCIFORM RECESS

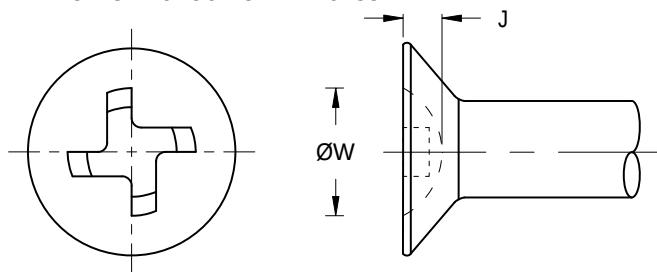


FIGURE 2 – OFFSET CRUCIFORM

DOVETAIL SLOT RECESS

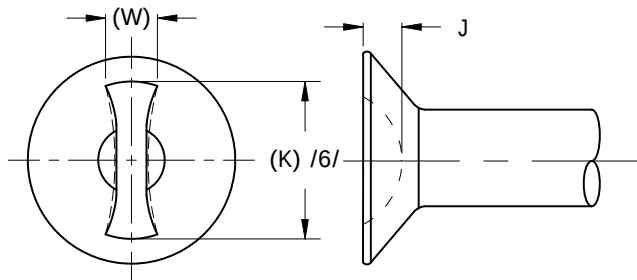


FIGURE 3 – DOVETAIL SLOT RECESS

TABLE II – OFFSET CRUCIFORM DIMENSIONS

FIRST DASH NO.	RECESS NO.	J MAX	$\varnothing W$ MAX	GAGE PENETRATION		RECESS VALUES	
				MIN	MAX	TORQUE IN-LBF MIN	RAISED METAL IN. MAX
3	10	.090	.248	.0560	.0685	60	.005
4	1/4	.118	.325	.0750	.0890	140	.005
5	5/16	.122	.357	.0700	.0860	220	.005
6	3/8	.145	.427	.0850	.1030	520	.006
7	7/16	.169	.498	.1005	.1205	750	.007
8	1/2	.193	.568	.1155	.1375	900	.008
9	9/16	.217	.638	.1305	.1545	1,300	.009
10	5/8	.241	.708	.1450	.1710	2,100	.010

TABLE III – DOVETAIL SLOT RECESS DIMENSIONS

FIRST DASH NO.	RECESS NO.	J		(K)	(W)	RECESS VALUES	
		MIN	MAX			TORQUE IN-LBF MIN	RAISED METAL IN. MAX
3	3	.042	.045	.305	.110	60	.005
4	4	.051	.054	.422	.134	140	.005
5	5	.061	.064	.490	.160	220	.005
6	6	.084	.088	.639	.198	520	.006
7	7	.096	.100	.715	.224	750	.007
8	8	.101	.105	.766	.256	900	.008
9	9	.114	.118	.877	.300	1,300	.009
10	10	.137	.141	1.020	.344	2,100	.010

MATERIAL:

ALLOY STEEL: 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6349 OR AMS6382, 4340 (UNS G43400) PER AMS6415, E4340 (UNS G43406) PER ~~MIL-S-5000~~ AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER ~~MIL-S-6049~~ AMS6322, AMS6325, OR AMS6327.

CRES: A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.

TITANIUM ALLOY: 6Al-4V (UNS R56400) PER AMS4928 OR AMS4967.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759 FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM:

ALLOY STEEL: 160-180 KSI Ft_u.

CRES: 160-190 KSI Ft_u. PRECIPITATION HARDENING PER AMS5853. /4/

TITANIUM (6Al-4V): 160 KSI Ft_u PER AMS4928 OR AMS4967.

FINISH:

CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2;
PASSIVATE PER AMS2700, METHOD 1, CLASS 4;
ALUMINUM COAT PER NAS4006; OR
NO FINISH.

⑤ COMPLETELY REVISED

REVISION
5