

FED. SUPPLY CLASS

53GP

1. SCOPE

- 1.1 This specification defines the requirements for hand and power drivers for installing and removing screws and bolts having six lobe drive - internal recess per NAS1800. Any sample lot of parts which does not conform to the requirements specified herein may be rejected by the procuring agency.
- 1.2 Recommendations for improvements or corrections of this specification should be directed to the Aerospace Industries Association, 1000 Wilson Boulevard, Suite 1700, Arlington, VA 22209.
- 1.3 Drivers covered by this specification shall conform to NAS1798. Specifications listed herein, of the issue in effect on date of price inquiry, are a part of this specification to the extent specified herein. In case of conflict, this specification shall take precedence.

2. APPLICABLE DOCUMENTS

The following documents form a part of this specification to the extent specified herein.

2.1 Military Specifications

PPP-P-40 Hand Tools, Packaging and Packing Of

Copies can be obtained from the Department of Defense Single Stock Point (DODSSP). <http://dodssp.daps.dla.mil>

2.2 Military Standards

MIL-STD-129 Marking For Shipment and Storage

2.3 Industry Standards

American Society for Quality

ANSI/ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes

Copies can be obtained from the American Society for Quality, 600 North Plankinton Ave., Milwaukee, WI 53203. www.asq.org

ASTM International

ASTM A681 Tool Steel, Alloy

Copies can be obtained from ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959. www.astm.org

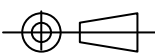
Aerospace Industries Association

NAS1798 Bit, Six Lobe Drive-Internal, Recess - Power And Hand Drivers

NAS1800 Recess, Six Lobe Drive-Internal - Dimensions For Recess And Gages

Copies can be obtained from the Aerospace Industries Association, 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209. www.aia-aerospace.org

② COMPLETELY REVISED

THIRD ANGLE PROJECTION 	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NONE	TITLE BIT, SIX LOBE RECESS DRIVER, SPECIFICATION	CLASSIFICATION SPECIFICATION NAS1798 SHEET 1 OF 5

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 09-01

REVISION DATE: APRIL 27, 2012

ISSUE DATE: JUNE 1978

3. REQUIREMENTS

- 3.1 **Material.** Materials used in manufacturing the drivers shall be rolled, drawn, or forged steel with chemical compositions, strength, and impact resistance equal to or exceeding ASTM A681 (UNS T41902), ASTM A304, Grades 4037H (UNS H40370), 4140H (UNS H41400), 6150H (UNS H61500) or 8740H (UNS H87400).
- 3.2 **Hardness.** The drivers shall be hardened throughout to 56 to 64 HRC for all sizes. The keys shall be hardened to 50 to 54 HRC for all sizes. Hardness tests shall be performed in accordance with 4.5.4.
- 3.3 **Finish.** Finish shall be in accordance with good commercial practice with no presence of burrs or cracks. Surfaces shall be sufficiently smooth to adequately determine all dimensions as specified herein.
- 3.4 **Coating.** A rust preventative coating adequate for interim storage shall be applied.
- 3.5 **Dimensions.** Drivers shall conform to the dimensions of Table I. Tip dimensions shall be inspected in accordance with 4.5.1.
- 3.6 **Performance.** The drivers, when tested as specified in 4.5.2, shall conform to 60% of the torque load requirements of Table I for the specified driver size.
- 3.7 **Toughness.** The drivers shall be subjected to a toughness test to determine whether or not the material is able to absorb energy up to its rupture point. The test shall be conducted as specified in 4.5.3.

4. QUALITY ASSURANCE PROVISIONS

- 4.1 **Responsibility for inspection.** Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the procuring agency. The procuring agency reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to assure that the supplies and services conform to the prescribed requirements.
- 4.2 **Classification of tests.** The inspection and testing of the drivers shall be classified as acceptance tests.
- 4.3 **Test conditions.** The test conditions are described under the individual tests to which they apply.

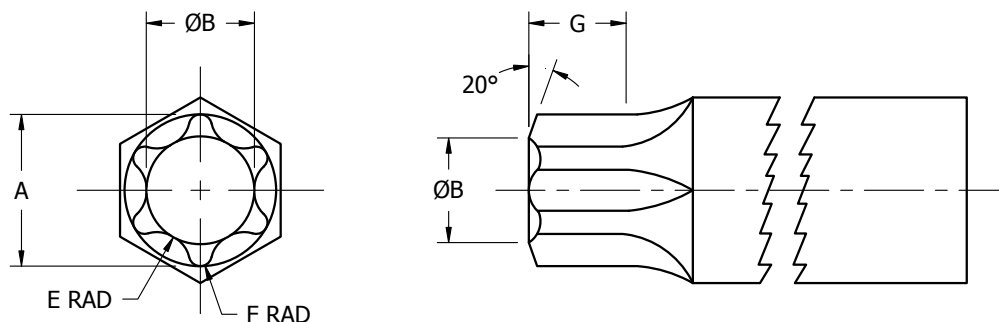


FIGURE 1 – SIX LOBE DRIVE

REVISION
2
NAS1799
SHEET 2



Documents

Document Sharing Hub

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