

1. Scope: This design standard defines the dimensional requirements for internal six lobe drive-internal recess head fasteners in 100° shear and tension flush heads and pan heads.
2. Applicable Documents: The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification, to the extent specified herein:

NAS1799 Bit, Six Lobe Recess Driver, Specification For

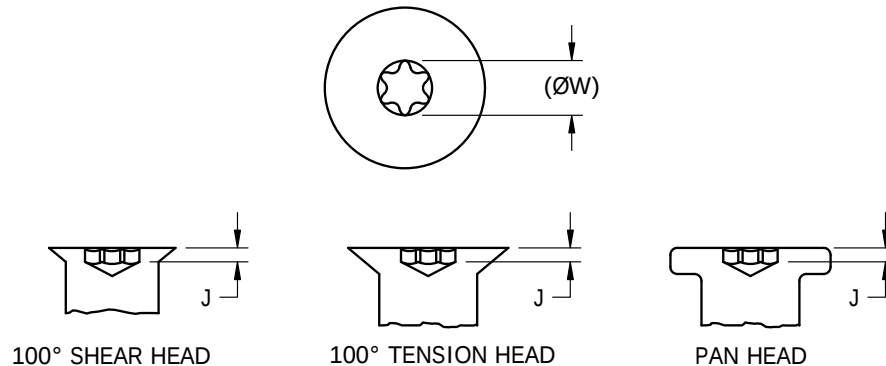


FIGURE 1 – RECESS, SIX LOBE DRIVE

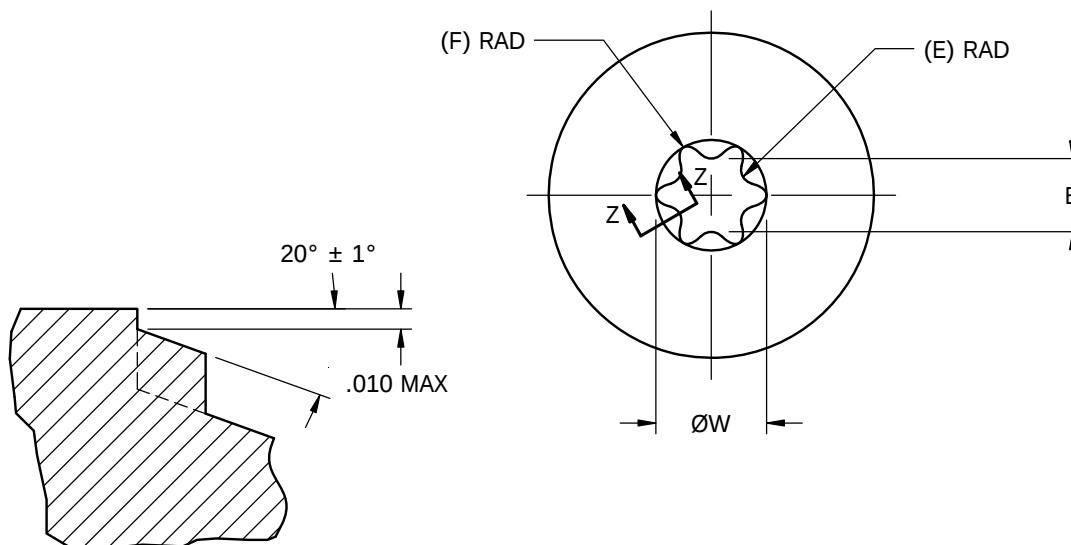
TABLE I – RECESS DEPTH

NOMINAL SCREW SIZE	RECESS NUMBER	(ØW) SEE TABLE II	J RECESS DEPTH			“J” TOL.
			100° SHEAR HEAD	100° TENSION HEAD	PAN HEAD	
#2	T7	.081	.022		.033	+.000 -.006
#4	T10	.111	.028		.034	
#6			.037		.050	
#8			.040		.050	
#10	T20	.155	.040	.050	.060	+.005 -.006
1/4			.050	—	—	
1/4	T30	.221	—	.060	.060	
5/16			.055	.070	.070	
3/8			.060	—	—	
3/8	T40	.266	—	.075	.075	
7/16			.070	—	—	
7/16	T50	.352	—	.100	.100	+.007 -.007
1/2			.100	—	—	
1/2	T55	.446	—	.110	.110	
9/16			.110	.110	—	
9/16	T60	.529	—	—	.140	
5/8	T55	.446	.110	—	—	
5/8	T60	.529	—	.140	.140	

- See Sheet 2 for additional recess design.
- See Sheet 4 for gage point used to measure recess penetration.
- Deleted
- See NAS1799 for dimensions of driver and driver gage.

④ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION NONE	TITLE RECESS, SIX LOBE DRIVE, INTERNAL, DIMENSIONS FOR RECESS AND GAGES	CLASSIFICATION DESIGN STANDARD
	④	NAS1800 SHEET 1 OF 4



SECTION Z-Z

FIGURE 2 – SIX-LOBE DRIVE-INTERNAL RECESS

TABLE II – RECESS DESIGN DIMENSIONS

INCHES							MILLIMETERS (mm)						
RECESS NUMBER	ØW		B		(E) RAD	(F) RAD	RECESS NUMBER	ØW		B		(E) RAD	(F) RAD
	MAX	MIN	MAX	MIN				MAX	MIN	MAX	MIN		
T7	.0825	.0805	.0599	.0579	.0166	.0073	T7	2,096	2,045	1,521	1,471	0,422	0,185
T10	.1120	.1100	.0810	.0790	.0225	.0100	T10	2,844	2,794	2,057	2,007	0,572	0,254
T20	.1560	.1540	.1125	.1105	.0325	.0130	T20	3,962	3,912	2,857	2,807	0,826	0,330
T30	.2225	.2195	.1600	.1570	.0455	.0190	T30	5,651	5,576	4,064	3,988	1,156	0,483
T40	.2680	.2640	.1925	.1885	.0550	.0230	T40	6,807	6,706	4,889	4,788	1,397	0,584
T50	.3540	.3500	.2560	.2520	.0700	.0320	T50	8,991	8,890	6,502	6,401	1,778	0,813
T55	.4490	.4440	.3185	.3135	.1033	.0380	T55	11,404	11,278	8,089	7,963	2,624	0,813
T60	.5310	.5260	.3810	.3760	.1113	.0443	T60	13,487	13,361	9,677	9,551	2,827	1,125

- (e) These tolerances were developed from punch tooling. Recess acceptability shall be determined by penetration gages and hand plug gages. Measurement of individual elements may be used in case of controversy.