

FED. SUPPLY CLASS

5305

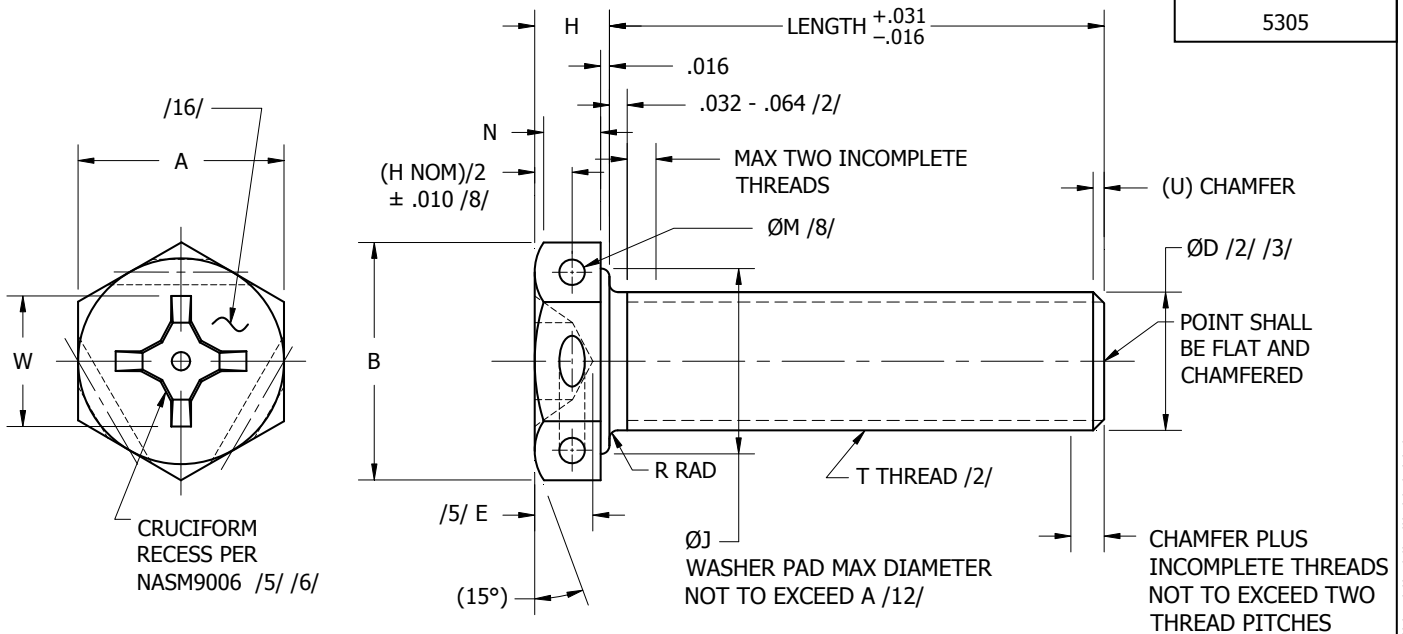


FIGURE 1 - CONFIGURATION

TABLE I - DIMENSIONS

FIRST DASH NO	T THREAD SIZE PER AS8879 /2/	A HEX	B MIN	ØD /2/ /3/	H	ØJ MIN /12/	ØM +.010 - .000	N MIN	R RAD	(U)	W	E PEN /5/	RECESS SIZE /5/
04	.1120-40 UNJC-3A	.189 .181	.207	.112 .094	.060 .049	.156	-	.032	.015 .005	.031	.116 .103	.071 .055	1
06	.1380-32 UNJC-3A	.251 .243	.277	.138 .115	.093 .080	.210	-	.050	.015 .005	.039	.154 .141	.075 .052	2
08	.1640-32 UNJC-3A	.251 .243	.277	.164 .141	.110 .096	.210	-	.056	.015 .005	.039	.169 .156	.090 .067	2
3	.1900-32 UNJF-3A	.314 .305	.348	.190 .167	.120 .105	.272	.046	.062	.020 .010	.039	.184 .171	.105 .082	2
4	.2500-28 UNJF-3A	.376 .367	.410	.250 .224	.140 .125	.335	.046	.073	.020 .010	.045	.247 .234	.118 .095	3
5	.3125-24 UNJF-3A	.439 .429	.480	.312 .282	.171 .156	.398	.070	.102	.020 .010	.052	.317 .304	.148 .126	4
6	.3750-24 UNJF-3A	.502 .492	.552	.375 .345	.203 .188	.460	.070	.131	.025 .015	.052	.342 .329	.173 .151	4

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	NOTED

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

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TITLE
**SCREW, HEX HEAD, CRUCIFORM RECESS,
FULL THREAD, A286 CRES, 160 KSI FtU**

CLASSIFICATION
PART STANDARD

NAS1802
SHEET 1 OF 3
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MATERIAL:

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

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759:
160-190 KSI Ft_u.
PRECIPITATION HARDENING IN ACCORDANCE WITH AMS5853. /11/

FINISH:

PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR TYPE 8, CLASS 4.
PASSIVATE PER AMS2700 METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT,
PASSIVATE PER AMS2700 METHOD 2 - NO POST TREATMENT OR
CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

CODE:

FIRST DASH NUMBER INDICATES DIAMETER PER TABLE I.
DASH (" - ") FOLLOWING FIRST DASH NUMBER INDICATES UNDRILLED HEAD.
LETTER "D" FOLLOWING FIRST DASH NUMBER INDICATES DRILLED HEAD (-3 THRU -6 SIZES ONLY).
SECOND DASH NUMBER INDICATES LENGTH IN .0625 INCREMENTS.
NO LETTER FOLLOWING THE SECOND DASH NUMBER INDICATES PASSIVATED FINISH **PER AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 4.**
LETTER "B" FOLLOWING THE SECOND DASH NUMBER INDICATES PASSIVATE PER AMS2700 METHOD 2 - NO POST TREATMENT.
LETTER "M" FOLLOWING THE SECOND DASH NUMBER INDICATES PASSIVATE PER AMS2700 METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT.
LETTER "P" FOLLOWING SECOND DASH NUMBER INDICATES CADMIUM PLATE.

EXAMPLES OF PART NUMBER:

- ⑨ NAS1802-4-16 = .2500-28 UNJF-3A SCREW, 1.000 LONG, PASSIVATED **PER AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 4.**
- ⑨ NAS1802-04-12 = .1120-40 UNJC-3A SCREW, .750 LONG, PASSIVATED **PER AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 4.**
- ⑨ NAS1802-4D16 = .2500-28 UNJF-3A SCREW, DRILLED HEAD, 1.000 LONG, PASSIVATED **PER AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 4.**
- ⑨ **NAS1802-4D16B = .2500-28 UNJF-3A SCREW, DRILLED HEAD, 1.000 LONG, PASSIVATED PER AMS2700 METHOD 2 - NO POST TREATMENT.**
- ⑨ **NAS1802-4D16M = .2500-28 UNJF-3A SCREW, DRILLED HEAD, 1.000 LONG, PASSIVATED PER AMS2700 METHOD 1, TYPE 8, CLASS 4- NO POST TREATMENT.**
- NAS1802-4D16P = .2500-28 UNJF-3A SCREW, DRILLED HEAD, 1.000 LONG, CADMIUM PLATED.

NOTES:

- (1) TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS ± .010, ANGLES ± 1°.
- /2/ SCREW LENGTHS OF TWO INCHES OR LESS SHALL HAVE AN UNTHREADED SHANK OF .032 TO .064 ADJACENT TO THE HEAD TO SHANK FILLET RADIUS WITH A "ØD" SHANK AS TABULATED IN TABLE I. SCREWS OVER TWO INCHES LONG SHALL HAVE A MINIMUM FULL THREAD FORM LENGTH OF 1.75 INCHES AND AN UNTHREADED "ØD" SHANK SEGMENT TO WITHIN A MINIMUM

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NAS1802

SHEET 2



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