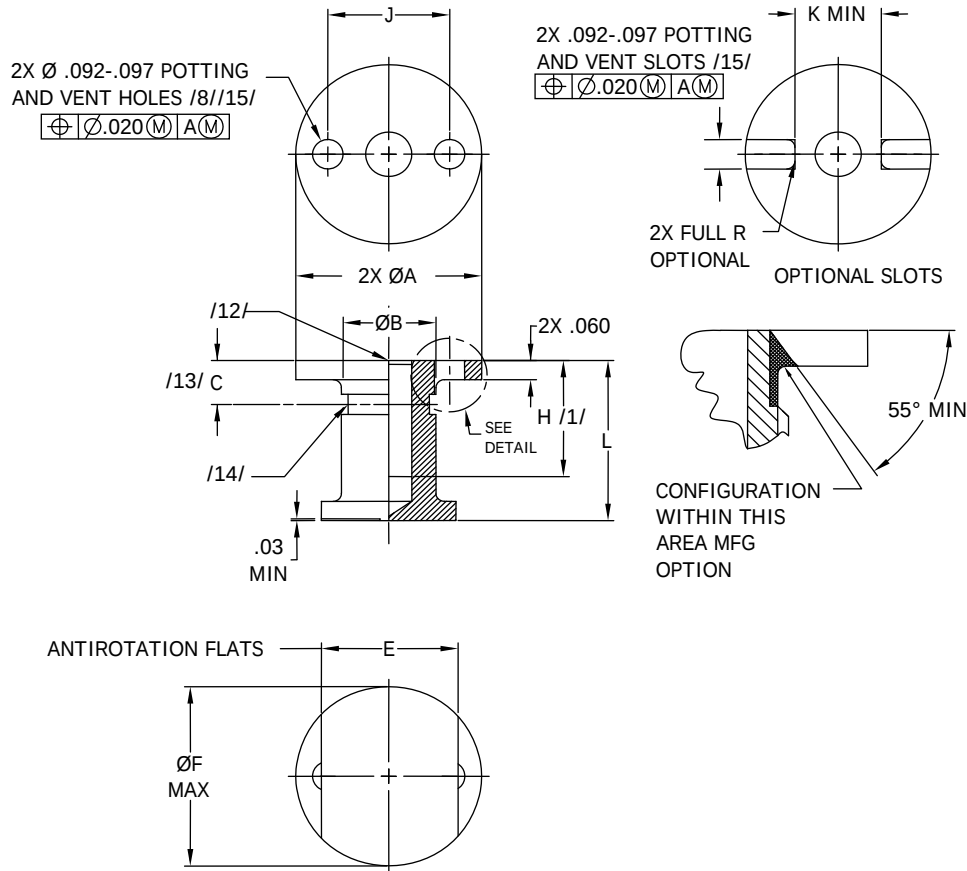
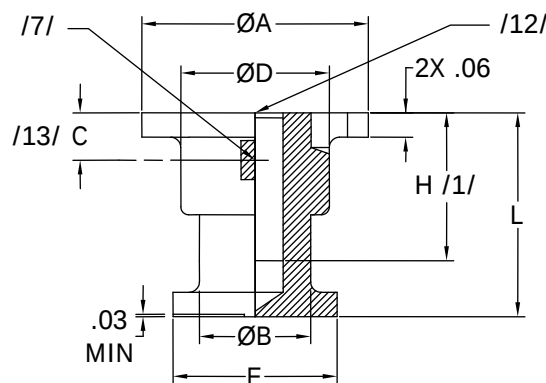


FED.SUPPLY CLASS

5325



ALL STEEL AND CRES SELF-LOCKING AND NONSELF-LOCKING OR NONSELF-LOCKING ALUMINUM STYLE



ALUMINUM SELF-LOCKING STYLE OR ALTERNATE NONSELF-LOCKING ALUMINUM STYLE

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 9
PROCUREMENT SPECIFICATION NONE	TITLE INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING, NONSELF-LOCKING, SANDWICH PANEL	CLASSIFICATION PART STANDARD NAS1832 SHEET 1 OF 3

TABLE I

FIRST DASH NO.	THREAD CLASS 3B MINOR ØA	ØA +.000 -.010	ØB	C	ØD	E	ØF MAX	H /1/	J BASIC	K MIN	L MIN /2/	INSTALLATION HOLE SIZE
06	.1380-32 UNJC	.560	.300	.12	.375	.400	.560	.25	.367	.260	.37	.561-.566
08	.1640-32 UNJC	.560	.300	.12	.375	.400	.560	.25	.367	.260	.37	.561-.566
3	.1900-32 UNJF	.560	.300	.12	.375	.400	.560	.25	.367	.260	.37	.561-.566
4	.2500-28 UNJF	.685	.375	.14	.440	.520	.685	.31	.467	.360	.50	.686-.691
5	.3125-24 UNJF	.685	.475	.16	.500	.520	.685	.31	.467	.360	.50	.686-.691
6	.3750-24 UNJF	.841	.500	.22	.550	.560	.841	.37	.591	.484	.50	.842-.847

MATERIAL: CARBON STEEL PER ASTM A108, ASTM A576 OR MATERIAL COMPOSITION PER AIR 4127 ~~FED-STD-66~~,
ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.

AL ALLOY, GRADE 2024 (UNS A92024), TEMPER T4 OR T351 PER QQ-A-225/6.

CORROSION RESISTANT STEEL, TYPE 303 (UNS S30300) PER ASTM A 582/A 582M ~~ASTM A582~~.

NONMETALLIC LOCKING ELEMENT - POLYAMIDE PER FED SPEC L-P-410.

FINISH: CARBON STEEL - CADMIUM PLATE PER AMS-QQ-P-416. TYPE II. CLASS 2.
AL ALLOY - ANODIZE PER MIL-A-8625. TYPE 1, CLASS OPTIONAL.
CRES - PASSIVATE PER AMS2700, TYPE II; SILVER PLATE PER AMS2410 OR AMS2411, OR CADMIUM PLATE
PER AMS-QQ-P-416, TYPE II, CLASS 2.
SOLID FILM LUBRICANT PER AS5272, TYPE 1, APPLIED TO THREADS ONLY.

CODING: NO LETTER AFTER BASIC NUMBER INDICATES CARBON STEEL, CADMIUM PLATED.
SUFFIX "A" TO BASIC NUMBER INDICATES AL ALLOY, ANODIZED.
SUFFIX "C" TO BASIC NUMBER INDICATES CRES, PASSIVATED.
FIRST DASH NUMBER INDICATES NOMINAL THREAD SIZE, SEE TABLE I.
SUFFIX "N" TO FIRST DASH NUMBER INDICATES NONSELF-LOCKING.
SECOND DASH NUMBER INDICATES LENGTH IN .125 INCREMENTS. /10/
NO LETTER AFTER SECOND DASH NUMBER FOR CRES INDICATES PASSIVATE ONLY. /9/
SUFFIX "M" TO SECOND DASH NUMBER INDICATES SOLID FILM LUBRICANT. /9/
SUFFIX "P" TO SECOND DASH NUMBER INDICATES CADMIUM PLATE ON CRES INSERT. /9/
SUFFIX "S" TO SECOND DASH NUMBER INDICATES SILVER PLATE ON CRES INSERT. /9/

EXAMPLE OF PART NUMBER:

NAS1832-3-4M .1900-32 UNJF-3B THREAD, CARBON STEEL, CADMIUM PLATED WITH SOLID FILM LUBRICANT,
.500 LONG, SELF-LOCKING.
NAS1832A3N4 .1900-32 UNJF-3B THREAD, AL ALLOY, ANODIZED, .500 LONG, NONSELF-LOCKING.
NAS1832C08-3S .1640-32 UNJC-3B THREAD, CRES. SILVER PLATED, .375 LONG, SELF-LOCKING.
NAS1832C08-3P .1640-32 UNJC-3B THREAD. CRES. CADMIUM PLATED, .375 LONG, SELF-LOCKING.
NAS1832C4N5 .2500-28 UNJF-3B THREAD, CRES, PASSIVATED, .625 LONG, NONSELF-LOCKING.

NOTES:

- /1/ MINIMUM THREAD "H" IN SHORT LENGTHS. MINIMUM THREAD "H" WHERE LENGTH PERMIT SHALL BE 2X
DIAMETER OF THREAD.
- /2/ MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- (3) THREADS PER AS8879.

REVISION

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NAS1832
SHEET 2



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