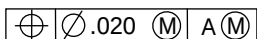


FED.SUPPLY CLASS

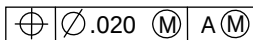
5325

2X Ø .092-.097 POTTING
AND VENT HOLES /3//8/

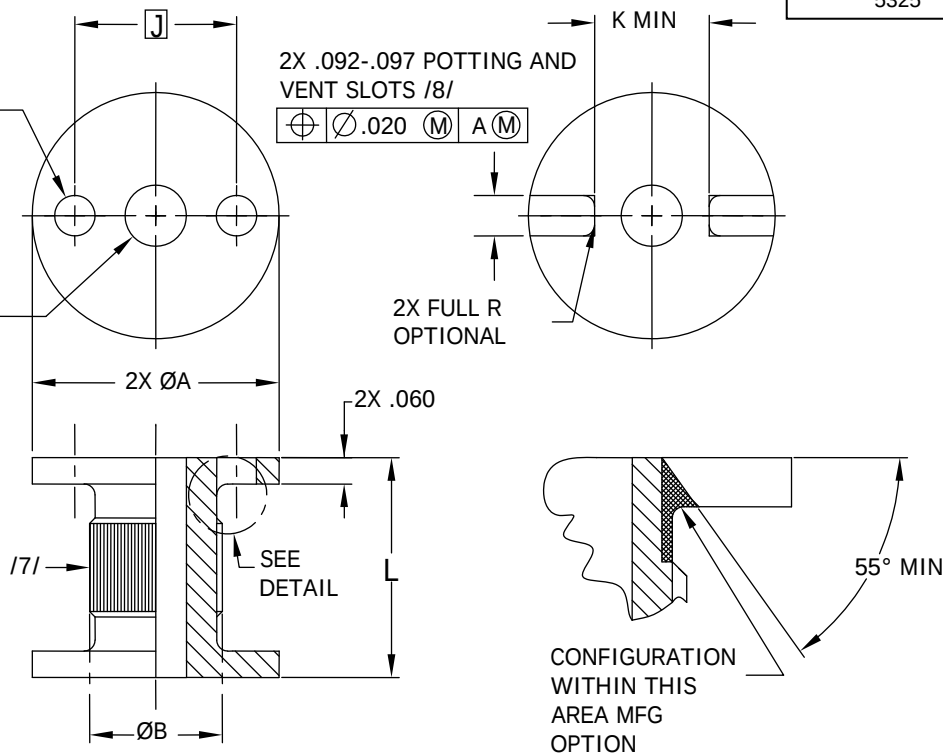


TYPICAL ALL STYLES

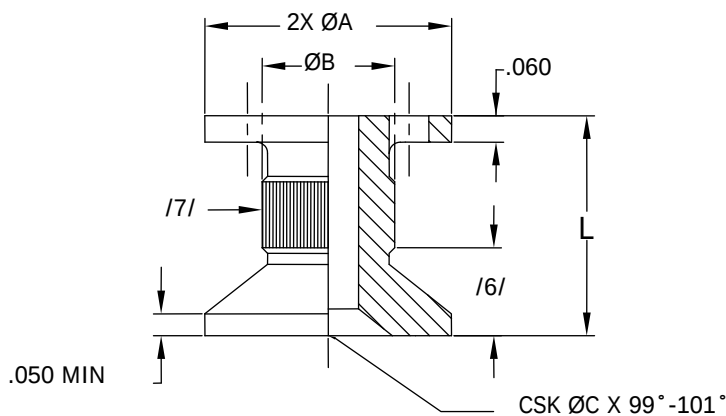
2X .092-.097 POTTING AND
VENT SLOTS /8/



2X FULL R
OPTIONAL



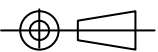
THRU CLEARANCE HOLE STYLE



COUNTERSUNK CLEARANCE HOLE STYLE

⑥ COMPLETELY REVISED

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

6

PROCUREMENT
SPECIFICATION

NONE

TITLE

**INSERT, MOLDED IN, CSK AND THRU CLEARANCE HOLE,
SANDWICH PANEL**

CLASSIFICATION
PART STANDARD

NAS1834
SHEET 1 OF 3



Documents

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TABLE I: DIMENSIONS

FIRST DASH NO.	ØA + .000 - .010	ØB	ØC	ØD CLEARANCE HOLE	J BASIC	K MIN	L MIN /1/	INSTALLATION HOLE SIZE
06	.560	.30	.280	.139-.145	.367	.260	.250	.561-.566
08	.560	.30	.332	.168-.174	.367	.260	.250	.561-.566
3	.560	.30	.385	.195-.201	.367	.260	.250	.561-.566
4	.685	.37	.507	.256-.263	.467	.360	.312	.686-.691
5	.685	.47	.625	.315-.322	.467	.360	.312	.686-.691
6	.841	.50	.750	.376-.383	.591	.484	.375	.842-.847

MATERIAL: CARBON STEEL PER ASTM A 108, ASTM A 576, OR MATERIAL COMPOSITION PER AIR4127 FED-STD-66, ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.
AL ALLOY, GRADE 2024 (UNS A92024), TEMPER T4 OR T351 PER AMS-QQ-A-225/6.
CORROSION RESISTANT STEEL, TYPE 303 (UNS S30300) PER ASTM A 582/A 582M.

FINISH: CARBON STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
AL ALLOY - ANODIZE PER MIL-A-8625, TYPE I, CLASS OPTIONAL.
CRES - PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

CODE: NO LETTER AFTER BASIC NUMBER INDICATES CARBON STEEL, CADMIUM PLATED.
SUFFIX "A" TO BASIC NUMBER INDICATES AL ALY, ANODIZED.
SUFFIX "C" TO BASIC NUMBER INDICATES CRES, PASSIVATED.
FIRST DASH NUMBER INDICATES CLEARANCE HOLE SIZE. SEE TABLE I.
SUFFIX "K" TO FIRST DASH NUMBER INDICATES COUNTERSUNK TYPE.
SECOND DASH NUMBER INDICATES LENGTH IN THOUSANDTHS.

EXAMPLE OF PART NUMBER:

NAS1834-3-500 = CARBON STEEL, CADMIUM PLATED, .500 LONG, WITH THRU CLEARANCE HOLE FOR Ø .1900 BOLT.
NAS1834C4-500 = CRES, PASSIVATED, .500 LONG, WITH THRU CLEARANCE HOLE FOR Ø .2500 BOLT.
NAS1834C4K1250 = CRES, PASSIVATED, 1.250 LONG, WITH COUNTERSUNK THRU CLEARANCE HOLE FOR Ø .2500 BOLT.

NOTES:

- /1/ MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- (2) TOLERANCES UNLESS OTHERWISE SPECIFIED:
.XXX - ± .010
.XX - ± .02
- /3/ BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.
- (4) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (5) DIMENSIONS IN INCHES.
- /6/ EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA.
- /7/ STRAIGHT OR DIAMOND ANTIROTATION KNURL (MANUFACTURER'S OPTION).
- /8/ POTTING AND VENT HOLES OR SLOTS (MANUFACTURER'S OPTION).
- (9) ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUNOUT TO DATUM A.
- (10) DIMENSIONAL LIMITS APPLY AFTER PLATING.

⑥ COMPLETELY REVISED

REVISION

6

NAS1834
SHEET 2



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