

FED. SUPPLY CLASS

5325

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

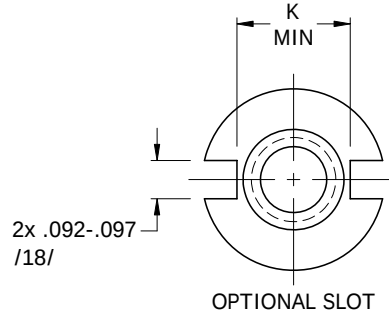
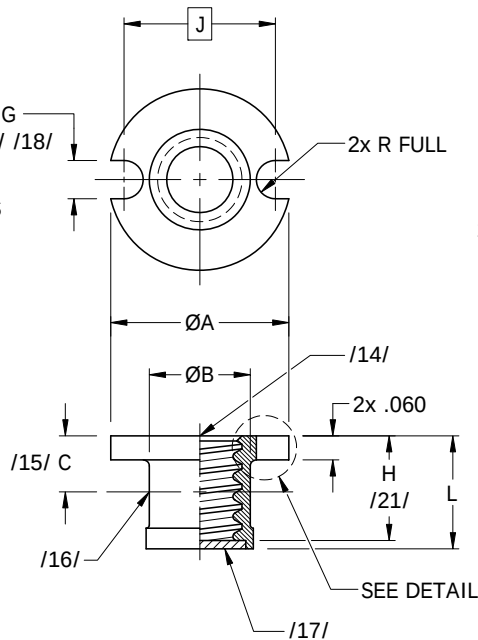
THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

REVISION DATE: JULY 31, 2012

ISSUE DATE: JUNE 1970

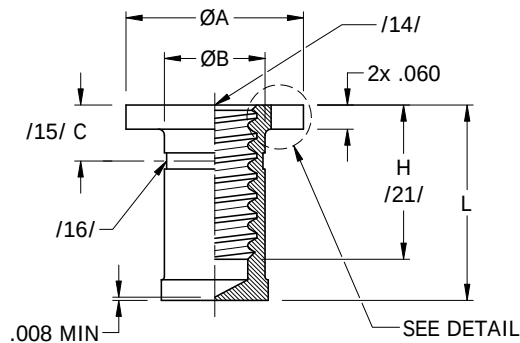
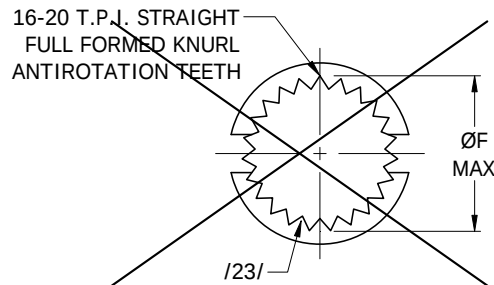
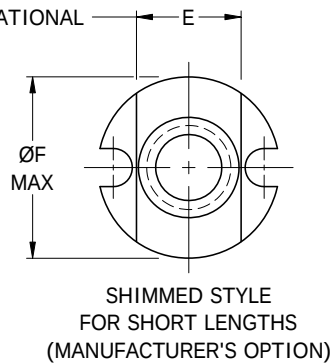
2x .092-.097 POTTING
AND VENT SLOTS /8/ /18/

$\oplus$ $\varnothing .020$ (M) A (M)
TYPICAL ALL STYLES

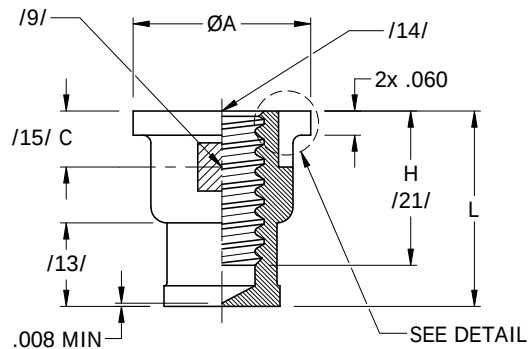


CONFIGURATION
WITHIN THIS AREA
MFG OPTION
DETAIL
TYPICAL ALL STYLES

ANTIROTATIONAL
FLATS



BLIND TAPPED STYLE FOR LONG LENGTHS
ALL STEEL AND CRES SELF-LOCKING AND
NONSELF-LOCKING OR NONSELF-LOCKING
ALUMINUM STYLE



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

9 COMPLETELY REVISED

THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
9

PROCUREMENT
SPECIFICATION

TITLE

CLASSIFICATION
PART STANDARD

NONE

**INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING,
NONSELF-LOCKING, LIGHTWEIGHT, SANDWICH PANEL**

NAS1836
SHEET 1 OF 3

TABLE I – DIMENSIONS

FIRST DASH NO.	THREAD CLASS 3B MINOR DIA - A -	ØA +.000 -.010	ØB	C	E	ØF MAX	H /21/	J BASIC	K MIN	L /22/ MIN	INSTALLATION HOLE SIZE
06	.1380-32 UNJC	.451	.250	.12	.260	.45	.187	.358	.251	.217	.452-.457
08	.1640-32 UNJC	.451	.250	.12	.260	.45	.187	.358	.251	.217	.452-.457
3	.1900-32 UNJF	.451	.250	.12	.260	.45	.187	.358	.251	.217	.452-.457
4	.2500-28 UNJF	.498	.300	.14	.312	.49	.250	.405	.298	.279	.499-.504

MATERIAL:

CARBON STEEL PER ASTM A 108, ASTM A 576, OR MATERIAL COMPOSITION PER FED-STD-66 AIR4127, ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.
AL ALLOY, GRADE 2024 (UNS A92024), TEMPER T4 OR T351 PER AMS-QQ-A-225/6.
CRES 303 (UNS S30300) PER ASTM A 582/A 582M.
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 I, CLASS OPTIONAL.
CRES - PASSIVATE PER AMS2700, METHOD 1, TYPE 2; SILVER PLATE PER AMS2410 OR AMS2411, OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

LUBRICATION:

SOLID FILM LUBRICANT PER AS5272, TYPE I, APPLIED TO THREADS ONLY.

CODE: 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 .031 INCREMENTS; ALWAYS USE TWO DIGIT DASH NUMBER. /6/
NO LETTER AFTER SECOND DASH NUMBER FOR CRES INDICATES PASSIVATE ONLY. /5/
SUFFIX "M" TO SECOND DASH NUMBER INDICATES SOLID FILM LUBRICANT. /5/
SUFFIX "P" TO SECOND DASH NUMBER INDICATES CADMIUM PLATE ON CRES INSERT. /5/
SUFFIX "S" TO SECOND DASH NUMBER INDICATES SILVER PLATE ON CRES INSERT. /5/

EXAMPLE OF PART NUMBER:

NAS1836-3-08M = .1900-32 UNJF-3B THREAD, CARBON STEEL,
CADMIUM PLATED WITH SOLID FILM LUBRICANT, .248 LONG, SELF-LOCKING.
NAS1836A3N09 = .1900-32 UNJF-3B THREAD, AL ALLOY, ANODIZED, .279 LONG, NONSELF-LOCKING.
NAS1836C08-10S = .1640-32 UNJC-3B THREAD, CRES, SILVER PLATED, .310 LONG, SELF-LOCKING.
NAS1836C08-10P = .1640-32 UNJC-3B THREAD, CRES, CADMIUM PLATED, .310 LONG, SELF-LOCKING.
NAS1836C4N12 = .2500-28 UNJF-3B THREAD, CRES, PASSIVATED, .372 LONG, NONSELF-LOCKING.

NOTE:

- (1) THREADS PER AS8879.
- (2) LOCKING TORQUE PER NASM25027 EXCEPT SELF-LOCKING, CORROSION RESISTANT STEEL INSERT WITHOUT PLATING OR LUBRICANT WILL BE TESTED USING A SILVER PLATED BOLT OR SCREW.
- (3) TOLERANCES UNLESS OTHERWISE SPECIFIED: .XXX ± .010, .XX ± .02.

REVISION
9

9 COMPLETELY REVISED



NAS1836
SHEET 2

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