

FED. SUPPLY CLASS

5340

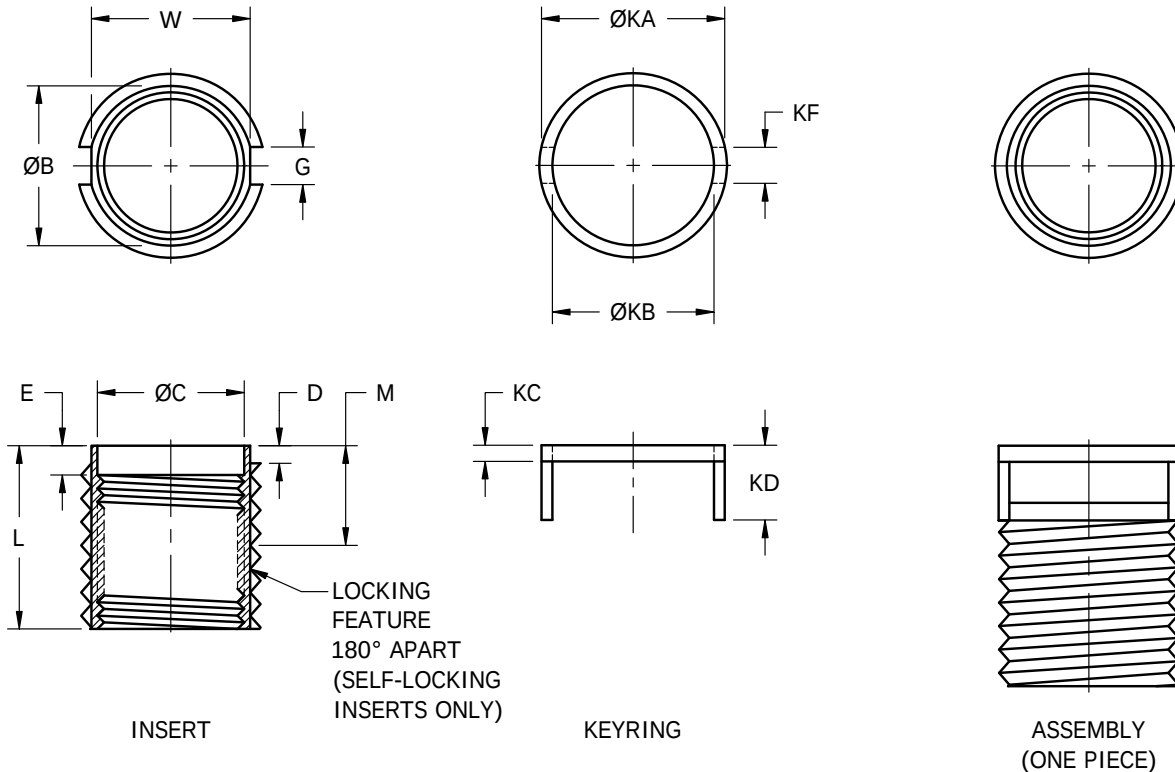


TABLE I – DIMENSIONS

DASH NO.	INTERNAL THREADS /1/ /4/	EXTERNAL THREADS /3/ /4/	ØB ±.005	ØC ±.005	D ±.005	E ±.010	G ±.005	L ±.015	(M)	(W)	ØKA +.000 -.005	ØKB +.010 -.000	KC +.005 -.000	KD ±.010	(KF)
04	.1120-40 UNJC-3B	.1900-32 UNJF-3A	.130	—	.032	—	.035	.187	.065	.129	.190	.136	.027	.122	.030
06	.1380-32 UNJC-3B	.2500-28 UNJF-3A	.179	—	.037	—	.065	.250	.085	.173	.250	.185	.032	.127	.060
08	.1640-32 UNJC-3B	.3125-24 UNJF-3A	.236	.170	.040	.060	.065	.312	.145	.234	.312	.242	.035	.145	.060
3	.1900-32 UNJF-3B	.3750-24 UNJF-3A	.289	.196	.045	.070	.081	.375	.170	.285	.375	.295	.040	.175	.076
4	.2500-28 UNJF-3B	.4375-20 UNJF-3A	.338	.257	.052	.070	.081	.437	.200	.335	.437	.344	.047	.203	.076
5	.3125-24 UNJF-3B	.5000-20 UNJF-3A	.398	.320	.052	.070	.096	.500	.215	.393	.500	.404	.047	.234	.091
6	.3750-24 UNJF-3B	.5625-18 UNJF-3A	.447	.382	.060	.070	.128	.562	.230	.435	.562	.453	.055	.255	.123
7	.4375-20 UNJF-3B	.6250-18 UNJF-3A	.507	.468	.060	.100	.128	.625	.285	.497	.625	.516	.055	.255	.123
8	.5000-20 UNJF-3B	.7500-16 UNJF-3A	.619	.515	.067	.100	.159	.750	.295	.605	.750	.625	.062	.312	.154
9	.5625-18 UNJF-3B	.8750-14 UNJF-3A	.728	.593	.075	.100	.159	.875	.315	.717	.875	.734	.070	.351	.154
10	.6250-18 UNJF-3B	.8750-14 UNJF-3A	.728	.656	.075	.100	.159	.875	.330	.717	.875	.734	.070	.351	.154
12	.7500-16 UNJF-3B	1.0000-12 UNJF-3A	.848	.787	.083	.100	.190	1.000	.350	.821	1.000	.855	.078	.390	.185
14	.8750-14 UNJF-3B	1.2500-12 UNJF-3A	1.055	.907	.099	.100	.190	1.250	.385	1.044	1.250	1.062	.094	.469	.185
16	1.0000-12 UNJF-3B	1.3750-12 UNJF-3A	1.149	1.033	.114	.100	.253	1.375	.415	1.126	1.375	1.156	.109	.531	.248

THIRD ANGLE PROJECTION

PROCUREMENT SPECIFICATION

NAS1838

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

INSERT ASSEMBLY, THREADED METAL, HEAVY DUTY SELF-LOCKING, NON SELF-LOCKING

REVISION

3

CLASSIFICATION

PART STANDARD

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.

FORM 12-01

REVISION DATE: FEBRUARY 29, 2016

ISSUE DATE: MARCH 1971

- 3 MATERIAL: KEYRING - CRES 410 (UNS S41000) PER AMS5504 OR AMS5613,
OR 420 (UNS S42000) PER AMS5506 OR AMS5621.
- INSERT - STEEL 4130 (UNS G41300) PER ~~MIL-S-6758~~ AMS-S-6758,
OR 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6349 OR AMS6382.
- CRES 303 (UNS S30300) PER ASTM A581/A581M, CONDITION B FOR INSERTS .500
EXTERNAL DIAMETER AND SMALLER, AND ASTM A582/A582M, CONDITION A FOR INSERTS
LARGER THAN .500 EXTERNAL DIAMETER.
- CRES A286 (UNS S66286) PER AMS5731.
- HEAT TREATMENT:
- FOR THE INSERT, DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759:
ALLOY STEEL: 160-180 KSI Ft_u
CRES A286: 160 KSI Ft_u MIN
- FINISH: INSERT AND KEYRING:
FOR CRES 410, 420, 303 AND A286, PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
FOR STEEL 4130 OR 4140, CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
SILVER PLATE PER AMS2411 (0.0002 TO 0.0005) WHEN CODED.
KEYRING TO HAVE SAME FINISH AS INSERT.
- LUBRICANT: DRY FILM LUBRICANT PER AS5272 ON SELF-LOCKING INSERT ASSEMBLIES EXCEPT WHEN SILVER
PLATED.
- CODE: NO LETTER BEFORE THE DASH NUMBER DESIGNATES 4130 OR 4140 STEEL.
ADD "C" IN PLACE OF "-" TO DESIGNATE 303 CRES.
ADD "CA" IN PLACE OF "-" TO DESIGNATE A286 CRES.
ADD LETTER "L" AFTER THE DASH NUMBER TO DESIGNATE A SELF-LOCKING INSERT.
ADD LETTER "S" AFTER THE DASH NUMBER TO DESIGNATE SILVER PLATE.
- EXAMPLE OF PART NUMBERS:
- NAS1839-3 = INSERT ASSEMBLY, HEAVY DUTY, STEEL, .1900-32 INTERNAL THREAD,
NON SELF-LOCKING, CADMIUM PLATE.
NAS1839-3L = INSERT ASSEMBLY, HEAVY DUTY, STEEL, .1900-32 INTERNAL THREAD,
SELF-LOCKING, CADMIUM PLATE AND DRY FILM LUBRICANT.
NAS1839C3 = INSERT ASSEMBLY, HEAVY DUTY, 303 CRES, .1900-32 INTERNAL THREAD,
NON SELF-LOCKING, PASSIVATED.
NAS1839CA3 = INSERT ASSEMBLY, HEAVY DUTY, A286 CRES, .1900-32 INTERNAL THREAD,
NON SELF-LOCKING, PASSIVATED.
NAS1839CA3LS = INSERT ASSEMBLY, HEAVY DUTY, A286 CRES, .1900-32 INTERNAL THREAD,
SELF-LOCKING, PASSIVATED, SILVER PLATE.
- NOTES:
- /1/ ALL INTERNAL THREADS SHALL CONFORM TO THE REQUIREMENTS OF AS8879 EXCEPT AS NOTED IN
NASM25027.
- (2) LOCKING TORQUE PER NASM25027. (SELF LOCKING INSERTS ONLY).
- /3/ ALL EXTERNAL THREADS SHALL CONFORM TO THE REQUIREMENTS OF AS8879.
- /4/ INTERNAL AND EXTERNAL THREADS SHALL BE CONCENTRIC WITHIN 0.005 FIM.
- (5) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

REVISION

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NAS1839
SHEET 2



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