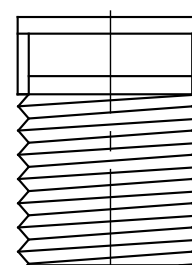
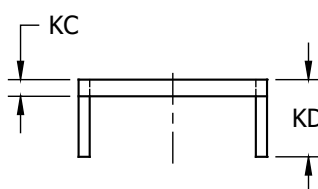
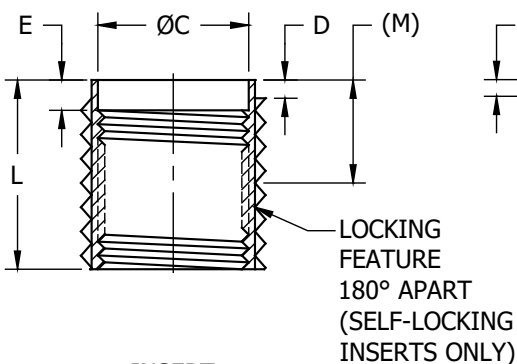
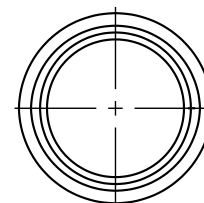
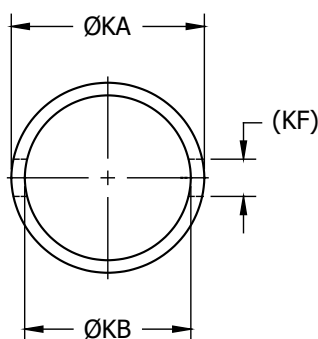
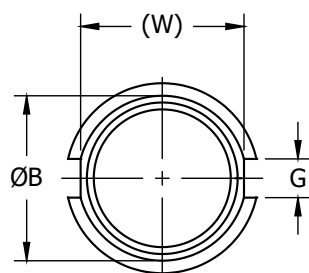


FED. SUPPLY CLASS

5340



INSERT

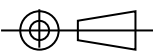
KEYRING

ASSEMBLY
(ONE PIECE)

TABLE I – DIMENSIONS

DASH NUMBER	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)
08	.1640-32 UNJC-3B	.2500-28 UNJF-3A	.185	--	.037	--	.065	.250	.145	.182	.250	.191	.032	.127	.060
3	.1900-32 UNJF-3B	.3125-24 UNJF-3A	.244	.196	.040	.060	.065	.312	.170	.242	.312	.250	.035	.145	.060
4	.2500-28 UNJF-3B	.3750-24 UNJF-3A	.306	.257	.045	.070	.081	.375	.200	.304	.375	.312	.040	.175	.076
5	.3125-24 UNJF-3B	.4375-20 UNJF-3A	.369	.320	.052	.070	.081	.437	.215	.367	.437	.375	.047	.203	.076
6	.3750-24 UNJF-3B	.5000-20 UNJF-3A	.431	.382	.052	.070	.096	.500	.230	.424	.500	.437	.047	.234	.091
7	.4375-20 UNJF-3B	.5625-18 UNJF-3A	.486	.468	.060	.070	.128	.562	.285	.476	.562	.492	.055	.255	.123
8	.5000-20 UNJF-3B	.6250-18 UNJF-3A	.545	.515	.060	.100	.128	.625	.295	.542	.625	.551	.055	.255	.123

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
3

PROCUREMENT
SPECIFICATION

NAS1838

TITLE
**INSERT ASSEMBLY, THREADED METAL,
LIGHT WEIGHT SELF-LOCKING,
NON SELF-LOCKING**

CLASSIFICATION
PART STANDARD

NAS1840
SHEET 1 OF 4

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY CONFORMANCE OF ITEMS PRODUCED UNDER NATIONAL AEROSPACE STANDARDS. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF ITEMS FOR ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABILITY THERETO OF PATENT OR TRADEMARKS RIGHTS.

MATERIAL: KEYRING - 410 CRES (UNS S41000) PER AMS5504 OR AMS5613,
OR 420 CRES (UNS S42000) PER AMS5506 OR AMS5621.

INSERT - 4130 STEEL (UNS G41300) PER ~~MIL-S-6758~~ AMS-S-6758,
OR 4140 STEEL (UNS G41400) PER ~~MIL-S-5626~~ AMS6382 OR AMS6349,
HT 160,000 - 180,000 PSI PER AMS2759.

- 303 CRES STEEL (UNS S30300) PER ASTM A581/A581M, CONDITION B FOR INSERTS WITH
EXTERNAL DIAMETER OF Ø.500 AND SMALLER, AND ASTM A582/A582M CONDITION A, FOR
INSERTS LARGER THAN AN EXTERNAL DIAMETER OF Ø.500.

- A286 CRES STEEL (UNS S66286) PER AMS5731, HT 160,000 PSI MINIMUM.

FINISH: INSERT AND KEYRING:
410, 420, 303 AND A286 CRES STEEL, PASSIVATE PER AMS 2700, METHOD 1, CLASS 4.
4130 OR 4140 STEEL, 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 THE DASH NUMBER TO DESIGNATE 303 CRES STEEL.
ADD "CA" IN PLACE OF THE DASH NUMBER TO DESIGNATE A286 CRES STEEL.
THE LETTER "L" AFTER THE DASH NUMBER DESIGNATES A SELF-LOCKING INSERT.
ADD LETTER "S" AFTER DASH NUMBER TO DESIGNATE SILVER PLATE.

EXAMPLE OF PART NUMBERS:

NAS1840-3 = INSERT ASSEMBLY, LIGHT WEIGHT, STEEL, .1900-32 INTERNAL THREAD,
NON SELF-LOCKING, CADMIUM PLATE.

NAS1840-3L = INSERT ASSEMBLY, LIGHT WEIGHT, STEEL, .1900-32 INTERNAL THREAD,
SELF-LOCKING, CADMIUM PLATE AND DRY LUBRICANT.

NAS1840C3 = INSERT ASSEMBLY, LIGHT WEIGHT, 303 CRES STEEL, .1900-32 INTERNAL THREAD,
NON SELF-LOCKING, PASSIVATED

NAS1840CA3 = INSERT ASSEMBLY, LIGHT WEIGHT, A286 CRES STEEL, .1900-32 INTERNAL THREAD,
NON SELF-LOCKING, PASSIVATED

NAS1840CA3LS = INSERT ASSEMBLY, LIGHT WEIGHT, A286 CRES STEEL, .1900-32 INTERNAL THREAD,
SELF-LOCKING, PASSIVATED, SILVER PLATE

REVISION

3

NAS1840
SHEET 2



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