

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
11000 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 09-01

REVISION DATE: NOVEMBER 22, 2011

ISSUE DATE: MARCH 1971

FED. SUPPLY CLASS

5307

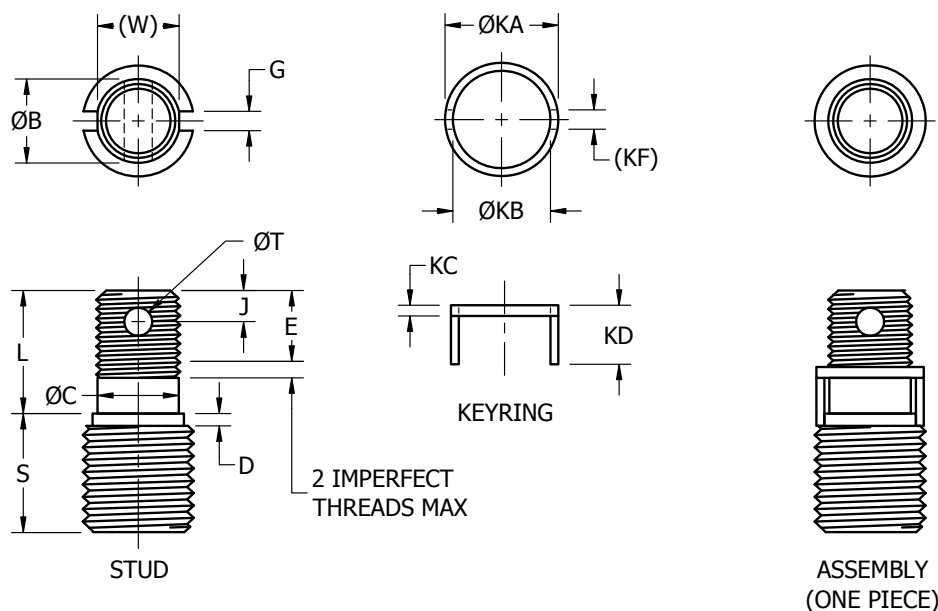


FIGURE 1 – STUD

TABLE I – DIMENSIONS

BASIC PART NUMBER	NUT END THREAD /1/ /2/	STUD END THREAD /1/	WHEEL DIAMENSIONS										(W)	ØKA + .000 - .005	ØKB + .010 - .000	KC + .005 - .000	KD ± .010	(KF)
			ØB ± .005	ØC + .000 - .005	D ± .005	E ± .010	G ± .005	J ± .010	S ± .015	ØT ± .005								
NAS1841	.1120-40 UNJC-3A	.1640-32 UNJC-3A	.122	.112	.025	.343	.035	—	.190	—	.117	.1640	.127	.025	.098	.030		
NAS1842	.1380-32 UNJC-3A	.1900-32 UNJF-3A	.130	.138	.032	.375	.035	—	.250	—	.129	.190	.136	.027	.122	.030		
NAS1843	.1640-32 UNJC-3A	.2500-28 UNJF-3A	.179	.164	.037	.406	.065	.109	.312	.070	.173	.250	.185	.032	.127	.060		
NAS1844	.1900-32 UNJF-3A	.3125-24 UNJF-3A	.236	.190	.040	.437	.065	.125	.375	.070	.234	.312	.242	.035	.145	.060		
NAS1845	.2500-28 UNJF-3A	.3750-24 UNJF-3A	.289	.250	.045	.500	.081	.156	.437	.076	.285	.375	.295	.040	.175	.076		
NAS1846	.3125-24 UNJF-3A	.4375-20 UNJF-3A	.338	.312	.052	.562	.081	.156	.500	.076	.335	.437	.344	.047	.203	.076		
NAS1847	.3750-24 UNJF-3A	.5000-20 UNJF-3A	.398	.375	.052	.625	.096	.172	.562	.106	.393	.500	.404	.047	.234	.091		
NAS1848	.4375-20 UNJF-3A	.5625-18 UNJF-3A	.447	.437	.060	.687	.128	.172	.625	.106	.435	.562	.453	.055	.255	.123		
NAS1849	.5000-20 UNJF-3A	.6250-18 UNJF-3A	.507	.500	.060	.812	.128	.187	.687	.106	.497	.625	.516	.055	.255	.123		
NAS1850	.5625-18 UNJF-3A	.7500-16 UNJF-3A	.619	.562	.067	.875	.159	.220	.812	.141	.605	.750	.625	.062	.312	.154		
NAS1851	.6250-18 UNJF-3A	.8750-14 UNJF-3A	.728	.625	.075	.937	.159	.220	.937	.141	.717	.875	.734	.070	.351	.154		
NAS1852	.7500-16 UNJF-3A	1.0000-12 UNJF-3A	.848	.750	.083	1.062	.190	.220	1.062	.141	.821	1.000	.855	.078	.390	.185		
NAS1853	.8750-14 UNJF-3A	1.2500-12 UNJF-3A	1.055	.875	.099	1.187	.190	.250	1.312	.141	1.044	1.250	1.062	.094	.469	.185		
NAS1854	1.0000-12 UNJF-3A	1.3750-12 UNJF-3A	1.149	1.000	.114	1.312	.253	.250	1.437	.141	1.126	1.375	1.156	.109	.531	.248		

(2) COMPLETELY REVISED

THIRD ANGLE PROJECTION		CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NONE	TITLE STUD ASSEMBLY, THREADED, METAL, DOUBLE STEP	② 	CLASSIFICATION PART STANDARD NAS1841 THRU NAS1854 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
Association of America Inc.
with AIANAS "USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD."
permitted without license from IHS or APPLICATION OR (2) THE EXISTENCE OF OR APPLIC
Not for Resale. 01/04/2016 15:51:20 MST

Full document details: AIA NAS1841-1854 2011



NAS1841 THRU
NAS1854
SHEET 1 OF 4

SHEET 1 OF 4

MATERIAL:

KEYRING:

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

STUD:

4130 STEEL (UNS G41300) PER AMS-S-6758, OR 4140 (UNS G41400) STEEL PER ~~MIL-S-5626~~ AMS6349 OR AMS6382.

303 CRES (UNS S30300) PER ASTM A581/A581M, CONDITION B, FOR STUDS Ø.500 STUD END AND SMALLER AND ASTM A582/A582M, CONDITION A, FOR STUDS LARGER THAN Ø.500 STUD END.

A286 CRES (UNS S66286) STEEL PER AMS5731.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759

4130 OR 4140 STEEL: 160-180 KSI Ft_u

A286 CRES: 160 KSI Ft_u MINIMUM

FINISH:

STUD AND KEYRING:

410, 420, 303 AND A286 CRES STEEL, PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

4130 OR 4140 STEEL, CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

SILVER PLATE PER AMS2411 (.0002 TO .0005) WHEN CODED.

KEYRING TO HAVE SAME FINISH AS STUD.

CODE:

DASH NUMBER DESIGNATES NUT END LENGTH "L" IN .0625 INCREMENTS.

NO LETTER BEFORE THE DASH NUMBER DESIGNATES 4130 OR 4140 STEEL.

ADD "C" IN PLACE OF THE DASH TO DESIGNATE 303 CRES STEEL.

ADD "CA" IN PLACE OF THE DASH TO DESIGNATE A286 CRES STEEL.

THE LETTER "D" AFTER THE DASH NUMBER DESIGNATES A DRILLED NUT END.

ADD LETTER "S" AFTER DASH NUMBER TO DESIGNATE SILVER PLATE.

EXAMPLES OF PART NUMBERS:

NAS1844-14D = STUD ASSEMBLY, DOUBLE STEP, STEEL, .1900-32 NUT END THREAD, .875 LONG NUT END, DRILLED, CADMIUM PLATE.

NAS1844-14 = STUD ASSEMBLY, DOUBLE STEP, STEEL, .1900-32 NUT END THREAD, .875 LONG NUT END, UNDRILLED, CADMIUM PLATE.

NAS1844C14D = STUD ASSEMBLY, DOUBLE STEP, 303 CRES STEEL, .1900-32 NUT END THREAD, .875 LONG NUT END, DRILLED, PASSIVATED.

NAS1844CA14D = STUD ASSEMBLY, DOUBLE STEP, A286 CRES STEEL, .1900-32 NUT END THREAD, .875 LONG NUT END, DRILLED, PASSIVATED.

NAS1844CA14S = STUD ASSEMBLY, DOUBLE STEP, A286 CRES STEEL, .1900-32 NUT END THREAD, .875 LONG NUT END, UNDRILLED, PASSIVATED, SILVER PLATE.

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 09-01

② COMPLETELY REVISED

REVISION
2
NAS1841 THRU NAS1854
SHEET 2



Documents

Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America Inc. MS PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS Licensee= www.sepana.ir/5991803002, User=sam, albert
No reproduction or networking permitted without license from IHS Not for Resale, 01/04/2016 15:51:20 MST TRADEMARKS RIGHTS.

Full document details: AIA NAS1841-1854 2011