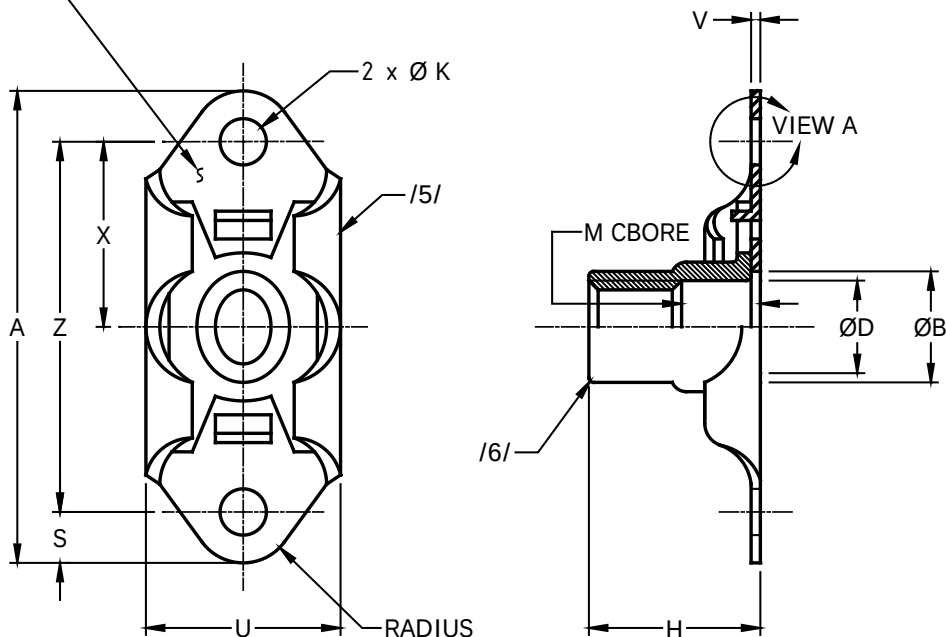


MARK WITH MANUFACTURER'S  
IDENTIFICATION AND WITH A "C"  
FOR CRES MATERIAL.  
LOCATION OPTIONAL

FED. SUPPLY CLASS

5310



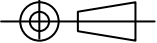
VIEW A  
DIMPLED OR COUNTERSUNK  
RIVET HOLES WHEN SPECIFIED

TABLE I – DIMENSIONS

| DASH<br>NUMBER | THREAD<br>/7/       | A<br>MAX | (Ø B) | Ø D<br>MIN | H<br>MAX<br>/1/ | Ø K<br>+.005<br>-.000 | M<br>MIN | S<br>MIN | Ø T<br>±.010 | U<br>MAX | V<br>MAX | X<br>±.005 | Z<br>±.002 | WEIGHT<br>APPROX<br>LB/100 | AXIAL<br>STRENGTH<br>POUNDS<br>MIN |
|----------------|---------------------|----------|-------|------------|-----------------|-----------------------|----------|----------|--------------|----------|----------|------------|------------|----------------------------|------------------------------------|
| 08-2           | .1640-32<br>UNJC-3B | .948     | .250  | .168       | .312            | .098                  | .125     | .100     | .200         | .416     | .032     | .344       | .688       | .40                        | 1720                               |
| 08-3           |                     |          |       |            | .375            |                       | .188     |          |              |          |          |            |            | .47                        |                                    |
| 08-4           |                     |          |       |            | .438            |                       | .250     |          |              |          |          |            |            | .51                        |                                    |
| 08-5           |                     |          |       |            | .500            |                       | .312     |          |              |          |          |            |            | .54                        |                                    |
| 08-6           |                     |          |       |            | .562            |                       | .375     |          |              |          |          |            |            | .60                        |                                    |
| 3-2            | .1900-32<br>UNJF-3B | .948     | .250  | .194       | .312            | .098                  | .125     | .100     | .200         | .416     | .032     | .344       | .688       | .40                        | 2460                               |
| 3-3            |                     |          |       |            | .375            |                       | .188     |          |              |          |          |            |            | .48                        |                                    |
| 3-4            |                     |          |       |            | .438            |                       | .250     |          |              |          |          |            |            | .50                        |                                    |
| 3-5            |                     |          |       |            | .500            |                       | .312     |          |              |          |          |            |            | .55                        |                                    |
| 3-6            |                     |          |       |            | .562            |                       | .375     |          |              |          |          |            |            | .60                        |                                    |
| 4-2            | .2500-28<br>UNJF-3B | 1.292    | .312  | .254       | .344            | .098                  | .125     | .100     | .200         | .516     | .032     | .500       | 1.000      | .75                        | 4580                               |
| 4-3            |                     |          |       |            | .406            |                       | .188     |          |              |          |          |            |            | .80                        |                                    |
| 4-4            |                     |          |       |            | .469            |                       | .250     |          |              |          |          |            |            | .90                        |                                    |
| 4-5            |                     |          |       |            | .531            |                       | .312     |          |              |          |          |            |            | 1.00                       |                                    |
| 4-6            |                     |          |       |            | .594            |                       | .375     |          |              |          |          |            |            | 1.10                       |                                    |
| 5-2            | .3125-24<br>UNJF-3B | 1.292    | .375  | .317       | .391            | .130                  | .125     | .125     | .230         | .609     | .045     | .500       | 1.000      | 1.15                       | 7390                               |
| 5-3            |                     |          |       |            | .453            |                       | .188     |          |              |          |          |            |            | 1.20                       |                                    |
| 5-4            |                     |          |       |            | .516            |                       | .250     |          |              |          |          |            |            | 1.40                       |                                    |
| 5-5            |                     |          |       |            | .578            |                       | .312     |          |              |          |          |            |            | 1.45                       |                                    |
| 5-6            |                     |          |       |            | .641            |                       | .375     |          |              |          |          |            |            | 1.50                       |                                    |

③ COMPLETELY REVISED

THIRD  
ANGLE  
PROJECTION



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

3

PROCUREMENT  
SPECIFICATION

**NASM25027**

TITLE

**NUT, SELF-LOCKING, PLATE, TWO LUG,  
125 KSI Ft<sub>u</sub>, 450 °F & 800 °F**

CLASSIFICATION  
PART STANDARD

**NAS1870**

SHEET 1 OF 3

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**MATERIAL:**

STEEL - SEE PROCUREMENT SPECIFICATION

CRES - A286 (UNS S66286) TO THE CHEMISTRY OF AMS5525, AMS5732 OR AMS5737

**FINISH:**

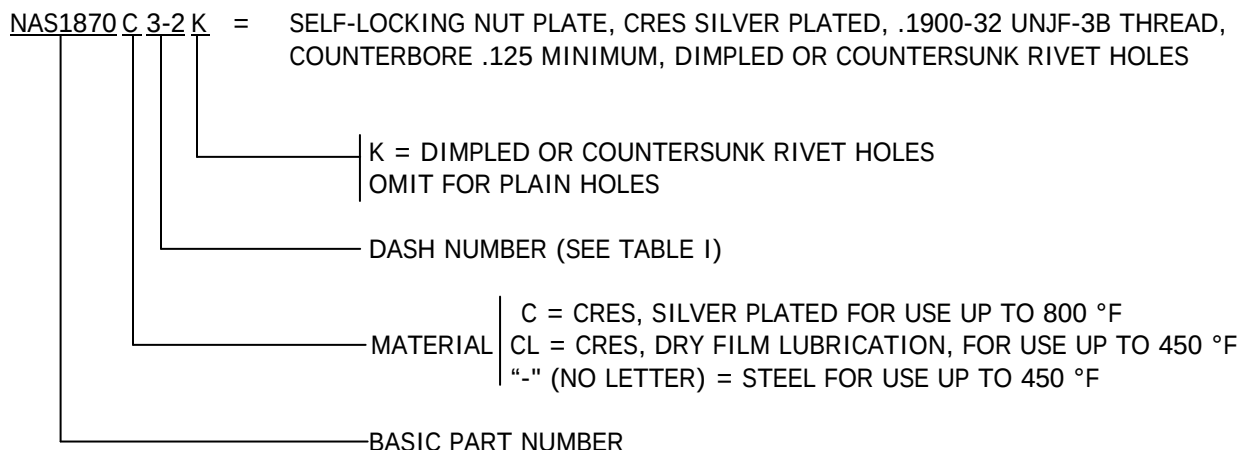
STEEL - CADMIUM PLATE PER AMS-QQ-P-416 PLUS AS5272, TYPE I DRY FILM LUBRICANT.

TYPE AND CLASS OF PLATING IS OPTIONAL IF LUBRICATED NUTS WILL MEET THE SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II.

CRES - 800 °F NUT: SILVER PLATE PER AMS2410. PLATING THICKNESS MEASURED ON ANY EXTERNAL SURFACE OF THE NUT SHALL NOT BE LESS THAN .0002 : THREADS SHALL SHOW COMPLETE COVERAGE BUT THICKNESS REQUIREMENT ON THREADS IS WAIVED. OPTIONAL SILVER PLATE ON NUT RETAINING CAGE.

450 °F NUT: DRY FILM LUBRICANT IN ACCORDANCE WITH AS5272, TYPE I SHALL BE APPLIED IN LIEU OF SILVER PLATE. OPTIONAL DRY FILM LUBRICANT ON NUT RETAINING CAGE.

**EXAMPLE OF PART NUMBER:**



**NOTES:**

- /1/ MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENT.
- (2) FLOAT OF NUT PORTION OF ASSEMBLY SHALL NOT BE LESS THAN .030 RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- (3) MAGNETIC PERMEABILITY OF CRES STEEL NUTS SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A 342/A 342M, TEST METHOD 3.
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- /5/ CONFIGURATION OF NUT OPTIONAL WITHIN THE LIMITATIONS IMPOSED BY DIMENSIONS AND REQUIREMENTS AS SPECIFIED HEREIN.
- /6/ THREAD PORTION DEFORMED AT INDICATED END TO PRODUCE SELF-LOCKING ACTION.

③ COMPLETELY REVISED

REVISION

3

**NAS1870**  
SHEET 2



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