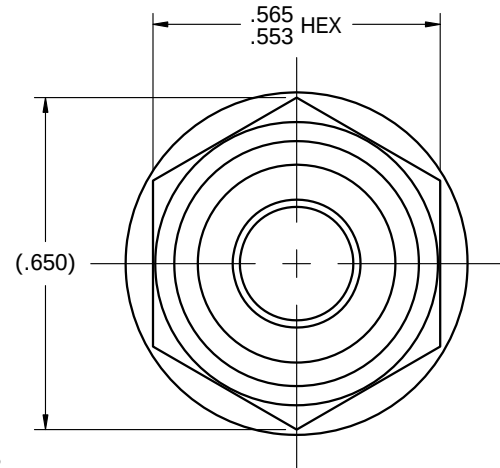
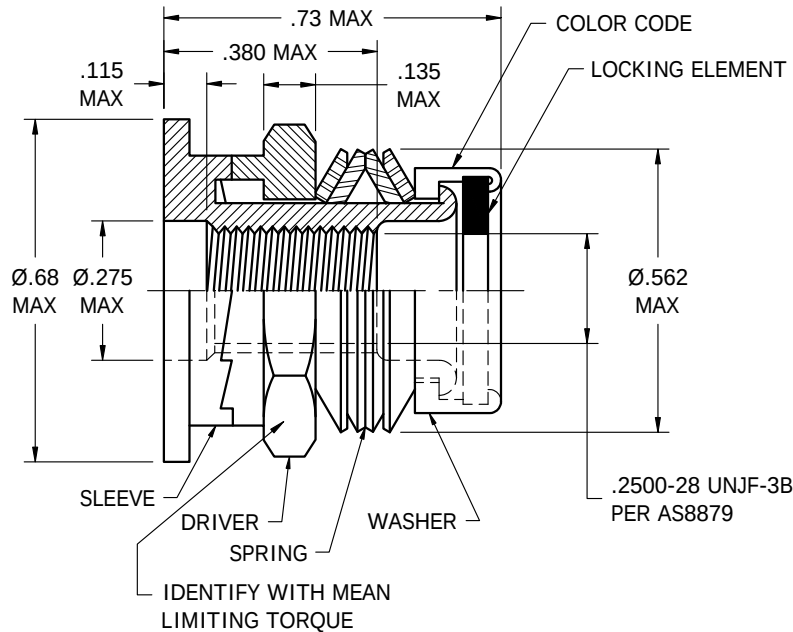


FED. SUPPLY CLASS

5310



MATERIAL:

SLEEVE, THREADED: A286 CRES (UNS S66286) PER AMS5737.
 DRIVER, HEX: A286 CRES (UNS S66286) PER AMS5737.
 SPRING, BELLEVILLE: 17-7 PH CRES (UNS S17700) PER AMS5528 OR CUSTOM 455 (UNS S45500) PER AMS5617
 WASHER: A286 CRES (UNS S66286) PER AMS5737 OR 303A STAINLESS STEEL (UNS S30300) PER AMS-QQ-S-763, ~~QQ-S-764~~ ASTM A484/A484M OR ASTM A582/A582M.
 LOCKING ELEMENT: DUPONT VESPEL GRADE SP-1 HIGH TEMPERATURE POLYIMIDE.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759:
 SLEEVE, THREADED: 140 KSI MIN
 DRIVER, HEX: 140 KSI MIN
 SPRING, BELLEVILLE: 44-50 HRC
 WASHER: NONE
 LOCKING ELEMENT: NONE

INACTIVE FOR DESIGN AFTER 15 APRIL 1994. NO SUPERSEDING STANDARD.
 FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

③ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 3
PROCUREMENT SPECIFICATION NASM25027	TITLE NUT ASSEMBLY, TORQUE LIMITING, 600 °F APPLICATION, .2500-28 UNJF-3B THREAD	CLASSIFICATION PART STANDARD NAS1871 SHEET 1 OF 2

FINISH:

SLEEVE, THREADED: SILVER PLATE PER AMS2411 (.0002-.0005 THICK).
 DRIVER, HEX: PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
 SPRING, BELLEVILLE: DRY FILM LUBRICANT GRAPHITE FREE (LUBECO 2029-3) OR EQUIVALENT.
 WASHER: PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
 LOCKING ELEMENT: NONE.

CODE:

NAS1871-(), DASH NUMBER INDICATES LIMITING TORQUE IN LBF-IN FORCE.
 LIMITING TORQUE HAS ± 10 LBF-IN TOLERANCE FROM MEAN VALUE AFTER 15 CYCLE TEST PER NASM25027.

EXAMPLE OF PART NUMBER:

NAS1871-40 = NUT, TORQUE LIMITING, 600 °F APPLICATION, 40 $\pm$ 10 LBF-IN LIMITING TORQUE.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) LOCKING TORQUE PER NASM25027.
- (3) THREAD APPLICATION: MATING BOLT THREAD SHALL BE A MINIMUM OF .75 INCHES LONG, AND A MAXIMUM OF 2.00 INCHES LONG.
- (4) LIMITING TORQUE: VALUES IN LBF-IN AFTER 15 CYCLES PER NASM25027.
- (5) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (6) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (7) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (8) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /9/ 1st CYCLE MAXIMUM LIMIT TORQUE MAY BE 10% ABOVE TABULATED VALUES.

TABLE II – TORQUE DASH NUMBERS

DASH NO. MEAN TORQUE LBF-IN	MAX TORQUE LBF-IN /9/	MIN TORQUE LBF-IN	COLOR CODE
40	50	30	WHITE
50	60	40	NONE
60	70	50	YELLOW
70	80	60	NONE
80	90	70	NONE
90	100	80	BLACK
100	110	90	NONE
110	120	100	NONE

REVISION

3

NAS1871
 SHEET 2



Document Sharing Hub

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