

FED. SUPPLY CLASS

5340

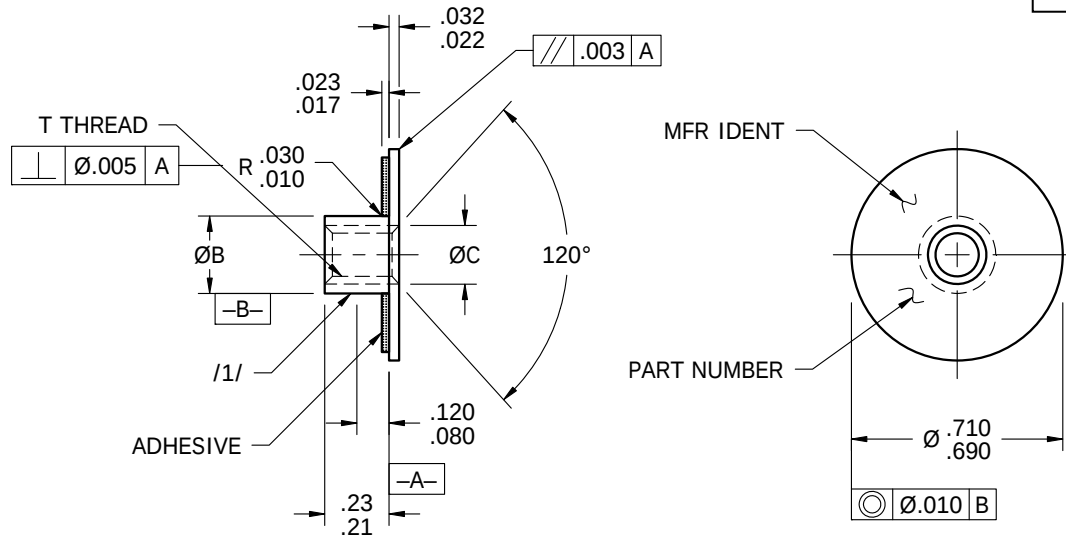


FIGURE 1 – INSERT

TABLE I – DIMENSIONS

DASH NUMBER	T THREAD /3/	ØB /2/	ØC MAX	ØD /10/	APPROX WEIGHT LBS/100
06	.1380-32 UNJC-3B	.167 .157	.156	.175 .169	.33
08	.1640-32 UNJC-3B	.193 .183	.183	.201 .195	.35
3	.1900-32 UNJF-3B	.223 .213	.210	.233 .227	.36

MATERIAL:

ALLOY STEEL 4130 (UNS G41300) PER MIL-S-6758 AMS-S-6758, MIL-S-18729 AMS6345, AMS6350, OR AMS6351.
CARBON STEEL 1035 (UNS G10350), 1040 (UNS G10400), 1042 (UNS G10420), OR 1050 (UNS G10500).
ADHESIVE: POLYAMIDE – MILVEX 1235 (GENERAL MILLS CAGE CODE 24608) OR EQUIVALENT. /12/

FINISH:

DIFFUSED NICKEL CADMIUM PER AMS2416.

② COMPLETELY REVISED

FORM 09-01	THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
	PROCUREMENT SPECIFICATION	TITLE INSERT, SELF-LOCKING, THERMAL BONDED HONEYCOMB PANEL	CLASSIFICATION PART STANDARD
	NOTED		NAS1873 SHEET 1 OF 3

NOTES:

- /1/ DETENTS FOR THREAD LOCKING SHALL BE SPACED SYMMETRICALLY AROUND THE BARREL AND CENTERED AT THE LOCATION INDICATED.
- /2/ DIMENSIONS DO NOT APPLY IN THE AREA OF THE THREAD LOCK.
- /3/ THREADS IN ACCORDANCE WITH AS8879 BEFORE DEFORMING FOR THREAD LOCKING.
- (4) SURFACE ROUGHNESS: 125 MICROINCHES Ra IN ACCORDANCE WITH ASME B46.1.
- (5) ADHESIVE SHALL NOT SEPARATE FROM THE INSERT DURING NORMAL HANDLING AND STORAGE.
- (6) REMOVE ALL BURRS AND SHARP EDGES.
- (7) PULL-OFF AND TORQUE-OFF STRENGTHS ARE DEPENDENT ON THE MATERIAL ONTO WHICH THE INSERT IS INSTALLED. EACH USER SHOULD ESTABLISH DESIGN LOADS FOR HIS MATERIALS BEFORE USING.
- (8) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (9) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /10/ "ØD" IS THE RECOMMENDED INSTALLATION HOLE DIAMETER.
- (11) 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.
- /12/ QUALITY CONFORMANCE TEST AND VERIFICATION: ALL PARTS SHALL BE EXAMINED AND TESTED TO THE EXTENT NECESSARY TO VERIFY THAT ALL REQUIREMENTS OF THIS STANDARD HAVE BEEN MET. THE ADHESIVE TENSILE STRENGTH SHALL BE TESTED AS SHOWN IN THE TEST SETUP BELOW AND AS FOLLOWS:
 - (a) THE INSERT SHALL BE INSTALLED ON A 3 BY 3 BY .125 THICK, GREASE FREE EPOXY FIBERGLASS LAMINATE (NEMA GRADE G10 OR EQUIVALENT).
 - (b) APPLY HEAT TO THE INSERT SO THAT THE TEMPERATURE MEASURED BY THE THERMOCOUPLE AT THE BOND LINE IS 475 TO 490 °F (246 TO 254 °C) FOR 8 TO 10 SECONDS. TOTAL HEATING CYCLE SHOULD TAKE ABOUT 13 SECONDS.
 - (c) REMOVE HEAT AND IMMEDIATELY PLACE A 1.5 TO 5 POUND WEIGHT (BRASS OR EQUIVALENT MATERIAL) HEAT SINK ON THE INSERT FOR A MINIMUM OF 10 SECONDS.
 - (d) AFTER A MINIMUM OF 4 HOURS, APPLY A TENSILE LOAD TO THE INSERT RESISTING THE LOAD WITH A 2 INCH INSIDE DIAMETER RING CENTERED ABOUT THE INSERT AGAINST THE FIBERGLASS.
 - (e) THE AVERAGE ULTIMATE TENSILE LOAD SHALL BE 200 POUNDS OR GREATER WITH NO INDIVIDUAL LOAD LESS THAN 160 POUNDS.
- (13) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (14) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

② COMPLETELY REVISED

REVISION
2
NAS1873
SHEET 2



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