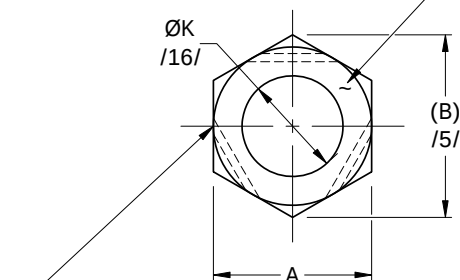


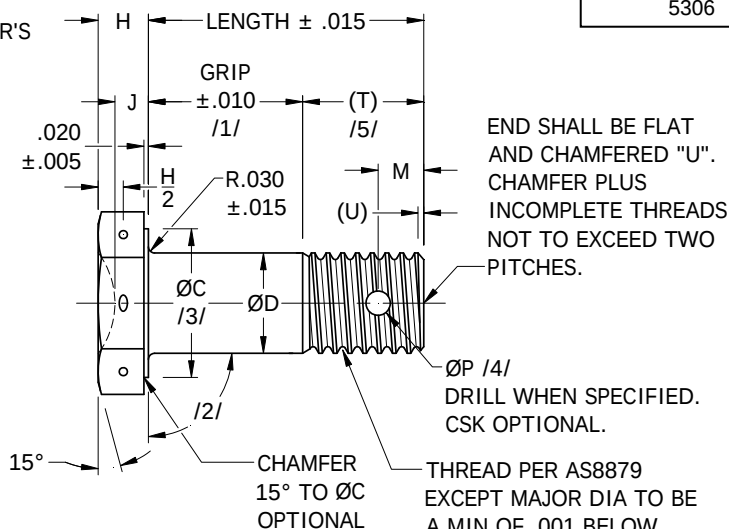
FED. SUPPLY CLASS

5306

HEAD MARKING: BASIC PART NUMBER, APPLICABLE DASH NUMBER, MANUFACTURER'S TRADE MARK, AND THE MATERIAL CODE WHERE APPLICABLE TO INDICATE CRES OR TITANIUM. RAISED OR DEPRESSED .010 MAX. LOCATION OPTIONAL.



3 x ØN
DRILL WITHIN .010 OF CENTER OF HEX FLAT WHEN SPECIFIED BY PART NUMBER. LOCK WIRE HOLES MUST BE FREE FROM BURRS AND SHARP EDGES.



END SHALL BE FLAT AND CHAMFERED "U". CHAMFER PLUS INCOMPLETE THREADS NOT TO EXCEED TWO PITCHES.

ØP /4/
DRILL WHEN SPECIFIED. CSK OPTIONAL.

THREAD PER AS8879 EXCEPT MAJOR DIA TO BE A MIN OF .001 BELOW MIN SHANK DIA.

7 TABLE I - DIMENSIONS

BASIC PART NUMBER	THREAD UNJF-3A	A	(B) /5/	ØC /3/ MIN	ØD /11/		H	J	ØK /16/	M	ØN	ØP /4/ +.010 - .000	(T) /5/	(U)
					BEFORE PLATING OR COATING	AFTER PLATING OR COATING								
NAS1953	.1900-32	.376 .367	.43	.335	~~.1885~~ ~~.1881~~	.1895 .1885	.110	.073	.19	.163	.046	.070	.338	.016
NAS1954	.2500-28	.439 .430	.51	.398	~~.2485~~ ~~.2481~~	.2495 .2485	.125	.083	.25	.178	.046	.076	.425	.018
NAS1955	.3125-24	.502 .492	.58	.460	~~.3110~~ ~~.3106~~	.3120 .3110	.156	.104	.31	.181	.070	.076	.469	.021
NAS1956	.3750-24	.564 .553	.65	.523	~~.3735~~ ~~.3731~~	.3745 .3735	.188	.125	.38	.197	.070	.106	.578	.021
NAS1957	.4375-20	.690 .679	.79	.648	~~.4360~~ ~~.4356~~	.4370 .4360	.219	.146	.44	.201	.070	.106	.594	.025
NAS1958	.5000-20	.752 .741	.87	.710	~~.4985~~ ~~.4981~~	.4995 .4985	.250	.167	.50	.216	.070	.106	.735	.025
NAS1959	.5625-18	.877 .865	1.01	.835	~~.5605~~ ~~.5601~~	.5615 .5605	.281	-	-	.218	.070	.141	.840	.028
NAS1960	.6250-18	.940 .928	1.09	.898	~~.6230~~ ~~.6226~~	.6240 .6230	.312	-	-	.249	.070	.141	.902	.028
NAS1962	.7500-16	1.064 1.052	1.23	1.023	~~.7480~~ ~~.7476~~	.7490 .7480	.375	-	-	.252	.070	.141	1.041	.031
NAS1964	.8750-14	1.252 1.239	1.44	1.210	~~.8730~~ ~~.8726~~	.8740 .8730	.438	-	-	.257	.070	.141	1.184	.036
NAS1966	1.0000-12	1.440 1.427	1.66	1.398	~~.9980~~ ~~.9976~~	.9990 .9980	.500	-	-	.264	.070	.141	1.309	.042
NAS1968	1.1250-12	1.627 1.614	1.88	1.585	~~1.1230~~ ~~1.1221~~	1.1240 1.1225	.562	-	-	.357	.070	.141	1.458	.042
NAS1970	1.2500-12	1.815 1.801	2.10	1.772	~~1.2480~~ ~~1.2471~~	1.2490 1.2475	.625	-	-	.389	.070	.141	1.646	.042

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 7
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, SHEAR, HEXAGON HEAD, 108 KSI SHEAR, LONG THREAD	CLASSIFICATION PART STANDARD
		NAS1953 THRU NAS1970 SHEET 1 OF 6

MATERIAL:

ALLOY STEEL - 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6382 OR AMS6349, 4340 (UNS G43406) PER ~~MIL-S-5000~~ AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER ~~MIL-S-6049~~ AMS6322, AMS6325 OR AMS6327.

TITANIUM ALLOY - 6Al-6V-2Sn (UNS R56620) PER AMS4971.

CRES - A286 (UNS S66286) PER AMS5731, AMS5732, AMS5737 OR AMS5853 EXCEPT ⑦
HEAT TREAT TO 180 KSI MIN.

HEAT TREATMENT:

⑦ DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759 FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM:

ALLOY STEEL - 180 TO 200 KSI ULTIMATE TENSILE; 108 KSI MIN ULTIMATE SHEAR.

TITANIUM ALLOY - 180 KSI MIN ULTIMATE TENSILE; 108 KSI MIN ULTIMATE SHEAR.

CRES - 180 KSI MIN ULTIMATE TENSILE; 108 KSI MIN ULTIMATE SHEAR AT ROOM TEMPERATURE. PRECIPITATION HARDEN PER AMS5853.

HARDNESS:

ALLOY STEEL - 39 - 43 HRC.

FINISH:

ALLOY STEEL - CADMIUM PLATING PER AMS-QQ-P-416, TYPE II, CLASS 2. BOLTS ARE NOT TO BE PICKLED. IMMEDIATELY AFTER PLATING (WITHIN 1 HOUR) BAKE AT 375 °F ± 25 °F FOR A MINIMUM OF 23 HOURS. /22/ ⑦

TITANIUM ALLOY - NONE.

CRES - CLEAN AND PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

CRES AND TITANIUM ALLOY - OPTIONAL ALUMINUM COAT PER NAS4006, DESIGNATED BY CODE "P". INCLUDE A HALOGEN FREE CETYL ALCOHOL LUBRICANT ON ALL TITANIUM BOLTS.

CODE:

NO LETTER CODE = BOLT, ALLOY STEEL, UNDRILLED.

ADD "D" TO DASH NUMBER FOR DRILLED SHANK.

ADD "H" TO DASH NUMBER FOR DRILLED HEAD.

ADD "P" TO DASH NUMBER ON CRES AND TITANIUM BOLTS FOR ALUMINUM COAT.

ADD "T" IN LIEU OF DASH DESIGNATES TITANIUM ALLOY (FORMER "V" CODE).

ADD "C" IN LIEU OF DASH DESIGNATES CRES.

⑦ ADD "X" FOLLOWING LENGTH DASH NUMBER FOR .0156 OVERSIZE SHANK DIAMETER.

ADD "Y" FOLLOWING LENGTH DASH NUMBER FOR .0312 OVERSIZE SHANK DIAMETER.

IF MORE THAN ONE CODE LETTER IS USED IN PART NUMBER, ARRANGE LETTERS ALPHABETICALLY.

EXAMPLE OF PART NUMBER:

NAS1958-10 = BOLT, .5000-20 THREAD, .625 GRIP, ALLOY STEEL, UNDRILLED.

NAS1958T10D = BOLT, .5000-20 THREAD, .625 GRIP, TITANIUM ALLOY, DRILLED SHANK.

NAS1958C10H = BOLT, .5000-20 THREAD, .625 GRIP, CRES, DRILLED HEAD.

NAS1958C10P = BOLT, .5000-20 THREAD, .625 GRIP, CRES, ALUMINUM COAT.

NAS1958T10DP = BOLT, .5000-20 THREAD, .625 GRIP, TITANIUM ALLOY, DRILLED SHANK, ALUMINUM COAT.

REVISION

7

NAS1953 THRU
NAS1970

SHEET 2



Documents

Document Sharing Hub