

FED. SUPPLY CLASS

5306

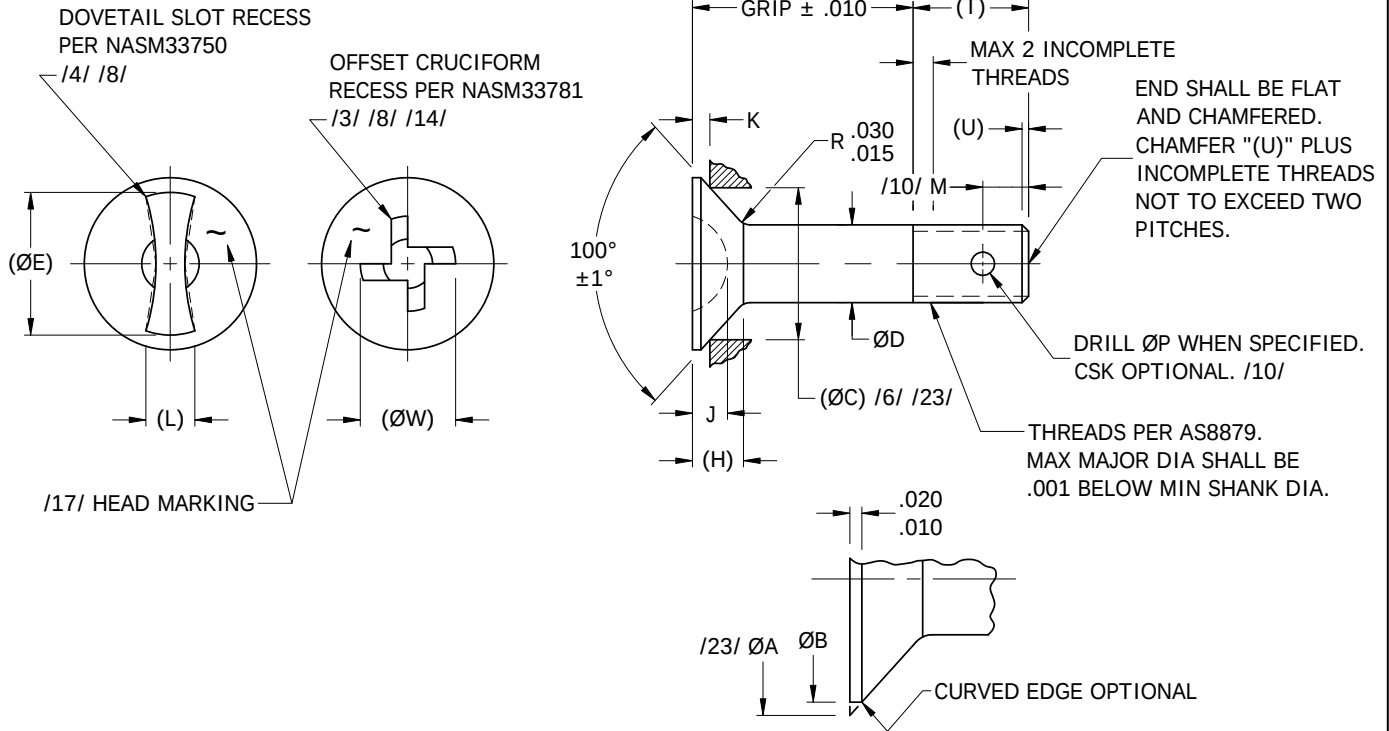


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /13/	ØA /23/	ØB MIN	(ØC) GAGE CIRCLE /6/ /23/	ØD /11/	(ØE) /4/	(H)	J DEPTH		K GAGE PROTRUSION /6/	(L) /4/
								OFFSET CRUCIFORM /3/	DOVETAIL SLOT /4/		
NAS1992	.1640-32 UNJC-3A	.2612 .2534	.2083	.2028 .2026	.1635 .1625	.187	.042	.066 .056	.029 .026	.0242 .0216	.088
NAS1993	.1900-32 UNJF-3A	.3047 .2965	.2516	.2440 .2438	.1895 .1885	.224	.048	.078 .068	.039 .036	.0251 .0224	.100
NAS1994	.2500-28 UNJF-3A	.3988 .3902	.3457	.3314 .3312	.2495 .2485	.300	.063	.090 .080	.045 .042	.0279 .0251	.110
NAS1995	.3125-24 UNJF-3A	.4787 .4696	.4256	.4047 .4045	.3120 .3110	.394	.070	.118 .108	.049 .046	.0306 .0277	.134
NAS1996	.3750-24 UNJF-3A	.5662 .5575	.5131	.4854 .4852	.3745 .3735	.484	.081	.122 .112	.064 .061	.0339 .0308	.160
NAS1997	.4375-20 UNJF-3A	.6741 .6632	.6200	.5698 .5696	.4370 .4360	.571	.100	.145 .135	.070 .066	.0431 .0399	.198
NAS1998	.5000-20 UNJF-3A	.7611 .7498	.7070	.6500 .6498	.4995 .4985	.660	.110	.169 .159	.086 .082	.0459 .0426	.224
NAS1999	.5625-18 UNJF-3A	.8449 .8326	.7908	.7200 .7198	.5615 .5605	.731	.119	.193 .183	.098 .094	.0516 .0481	.256
NAS2000	.6250-18 UNJF-3A	.9329 .9201	.8788	.8011 .8009	.6240 .6230	.819	.130	.217 .207	.104 .100	.0544 .0508	.300

⑦ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE		REVISION 7
	TITLE BOLT, FLAT, 100° REDUCED HEAD, OFFSET CRUCIFORM AND DOVETAIL SLOT, 108 KSI Fsu		CLASSIFICATION PART STANDARD
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, FLAT, 100° REDUCED HEAD, OFFSET CRUCIFORM AND DOVETAIL SLOT, 108 KSI Fsu		CLASSIFICATION PART STANDARD

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	M ± .010 /10/	ØP + .010 – .000 /10/	(T)	(U)	(ØW) /3/	RECESS NUMBER		DOUBLE SHEAR STRENGTH LBF MIN /16/	FIM VALUE		RECESS TORQUE IN-LBF MIN /8/
						OFFSET CRUCIFORM	DOVETAIL SLOT		Y /1/	Z /2/	
NAS1992	–	–	.338	.016	.182 .172	6	1	4,600	.005	.0040	–
NAS1993	.163	.070	.338	.016	.215 .205	8	2	6,100	.005	.0040	37
NAS1994	.178	.076	.425	.018	.248 .238	10	3	10,600	.006	.0030	50
NAS1995	.181	.076	.469	.021	.325 .315	1/4	4	16,600	.007	.0030	125
NAS1996	.197	.106	.578	.021	.357 .347	5/16	5	23,900	.009	.0025	250
NAS1997	.201	.106	.594	.025	.427 .417	3/8	6	32,500	.009	.0025	430
NAS1998	.216	.106	.735	.025	.498 .488	7/16	7	42,400	.010	.0020	925
NAS1999	.218	.141	.840	.028	.568 .558	1/2	8	53,700	.010	.0020	1210
NAS2000	.249	.141	.902	.028	.638 .628	9/16	9	66,300	.010	.0020	1760

MATERIAL:

- ALLOY STEEL - 4140 (UNS G41400) PER MIL-S-5626 AMS6382, 4340 (UNS G43406) PER MIL-S-5000 AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER MIL-S-6049 AMS6327, AMS6322 OR AMS6325.
- CRES - A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.
- TITANIUM ALLOY - 6AL-6V-2SN (UNS R56620) PER AMS4971.

HEAT TREATMENT:

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: 180-200 KSI Ft_u. 39 - 43HRC.

CRES: 180-210 KSI Ft_u

TITANIUM ALLOY: 180 KSI Ft_u MIN

- FINISH: ALLOY STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. BOLTS ARE NOT TO BE PICKLED. IMMEDIATELY AFTER PLATING (WITHIN 1 HOUR) BAKE AT 375 ± 25 °F FOR A MINIMUM OF 23 HOURS.
- CRES - CLEAN AND PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
- TITANIUM ALLOY - NONE.
- 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 DOVETAIL SLOT RECESS.
ADD "T" TO DASH NUMBER FOR OFFSET CRUCIFORM RECESS.
ADD "P" TO DASH NUMBER ON CRES OR TITANIUM BOLTS FOR ALUMINUM COAT.
"T" IN LIEU OF DASH DESIGNATES TITANIUM ALLOY (FORMER "Y" CODE).
"C" IN LIEU OF DASH DESIGNATES CORROSION RESISTANT STEEL.
IF MORE THAN ONE CODE LETTER IS USED IN SEQUENCE IN PART NUMBER, ARRANGE LETTERS ALPHABETICALLY.

REVISION

7

NAS1992 THROUGH NAS2000
SHEET 2

⑦ COMPLETELY REVISED