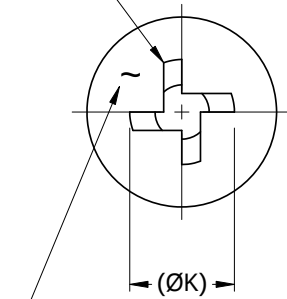


OFFSET CRUCIFORM RECESS
PER NASM33781 /3/



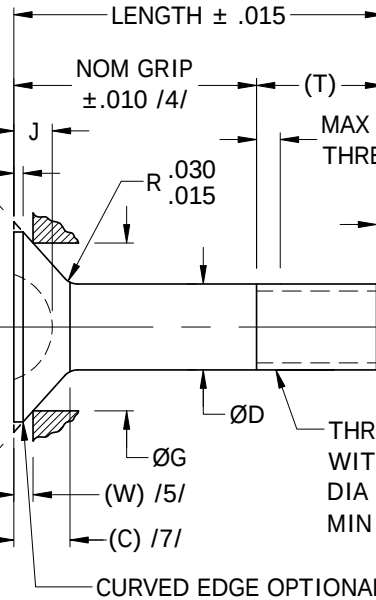
HEAD MARKING PER
NAS1347, TYPE IV

101°
99°

.020 MAX

(ØA)
/7/

ØB



THREADS IN ACCORDANCE
WITH AS8879; MAX MAJOR
DIA SHALL BE .001 BELOW
MIN SHANK DIA

FED. SUPPLY CLASS

5306

TABLE I - DIMENSIONS AND INSPECTION DATA

BASIC PART NUMBER	THREAD UNJF-3A	ØD	(ØA) /7/ MAX	ØB MIN	(C) /7/	HEAD GAGING		(T)	(U)	J DEPTH MAX	(ØK) MAX	RECESS GAGE PENETRATION /3/	FIM VALUES	
						(W) HEAD PROTRUSION	ØG GAGE CIRCLE						Y /1/	Z /2/
NAS2803	.1900-32	.1895 .1885	.385	.328	.080	.0290 .0263	.3147 .3143	.338	.016	.090	.248	.0685 .0560	.0045	.0040
NAS2804	.2500-28	.2495 .2485	.507	.449	.106	.0342 .0316	.4245 .4241	.456	.018	.118	.325	.0890 .0750	.0045	.0030
NAS2805	.3125-24	.3120 .3110	.635	.577	.133	.0395 .0370	.5389 .5385	.530	.021	.122	.357	.0860 .0700	.0045	.0030
NAS2806	.3750-24	.3745 .3735	.762	.704	.160	.0450 .0426	.6532 .6528	.577	.021	.145	.427	.1030 .0850	.0060	.0025
NAS2807	.4375-20	.4370 .4360	.890	.832	.188	.0503 .0481	.7676 .7672	.656	.025	.169	.498	.1205 .1005	.0060	.0025
NAS2808	.5000-20	.4995 .4985	1.017	.959	.215	.0557 .0537	.8820 .8816	.703	.025	.193	.568	.1375 .1155	.0060	.0020
NAS2809	.5625-18	.5615 .5605	1.145	1.087	.242	.0611 .0592	.9964 .9960	.776	.028	.217	.638	.1545 .1305	.0060	.0020
NAS2810	.6250-18	.6240 .6230	1.272	1.214	.270	.0665 .0647	1.1108 1.1104	.823	.028	.241	.708	.1710 .1450	.0060	.0020

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.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759:

180-200 KSI Ft_u.

⑦ COMPLETELY REVISED

THIRD ANGLE PROJECTION		CUSTODIAN	REVISION
		NATIONAL AEROSPACE STANDARDS COMMITTEE	7
PROCUREMENT SPECIFICATION		TITLE	CLASSIFICATION PART STANDARD
NOTED		BOLT, 100° HEAD, OFFSET CRUCIFORM, CLOSE TOLERANCE, 180,000 PSI	NAS2803 THRU NAS2810 SHEET 1 OF 3

FINISH: 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.

CODE: DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE TABLE II).

EXAMPLE OF PART NUMBER:

NAS2804-8 = Ø.250 BOLT, .500 GRIP
NAS2805-10 = Ø.312 BOLT, .625 GRIP

NOTES:

- /1/ CONCENTRICITY: "ØD" AND THREAD PITCH DIAMETER WITHIN "Y" VALUES FIM. CONICAL SURFACE OF HEAD AND "ØD" WITHIN .005 FIM. RECESS TO "ØD" WITHIN .016 FIM THRU .250 SIZE, WITHIN .024 FIM ABOVE .250 SIZE.
- /2/ SHANK STRAIGHTNESS: WITHIN "Z" VALUES FIM PER INCH OF LENGTH.
- /3/ RECESS GAGING IN ACCORDANCE WITH NASM33781.
- /4/ GRIP LENGTH: FROM THE TOP OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
- /5/ REFER TO NAS518 AND NAS519 FOR FLUSHNESS GAGING DETAILS.
- (6) ~~FASTENER SUPPLIERS MAY FURNISH FASTENERS WITH MIL-S-7742 THREAD UNTIL 30 JULY 1988.~~
FASTENERS WITH MIL-S-7742 THREADS MAY BE USED UNTIL STOCK IS DEPLETED.
- /7/ "(ØA)" AND "(C)" ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION. VALUES "(ØA)" AND "(C)" ARE CALCULATED LIMITS RESULTING FROM TOLERANCES ON "ØD", "ØG", "(W)" AND HEAD ANGLE.
- /8/ POINT SHALL BE FLAT AND CHAMFERED. "(U)" PLUS INCOMPLETE THREADS SHALL NOT EXCEED TWO THREAD PITCHES.
- (9) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (10) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (11) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (12) 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.
- (13) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

PROCUREMENT SPECIFICATION:

~~MIL-B-87114~~ NAS9925 EXCEPT AS NOTED.
FORMED HEADS OPTIONAL FOR PARTS MANUFACTURED PRIOR TO DEC 31, 1994.
FORMED HEADS REQUIRED ON ALL PARTS MANUFACTURED AFTER DEC 31, 1994.
FLUSHNESS GAGING DETAILS AS NOTED HEREIN.
PACKAGING PER NAS498.
FATIGUE TESTS DO NOT APPLY.

REVISION

7

NAS2803-2810
SHEET 2

7 COMPLETELY REVISED