

FED. SUPPLY CLASS

5306

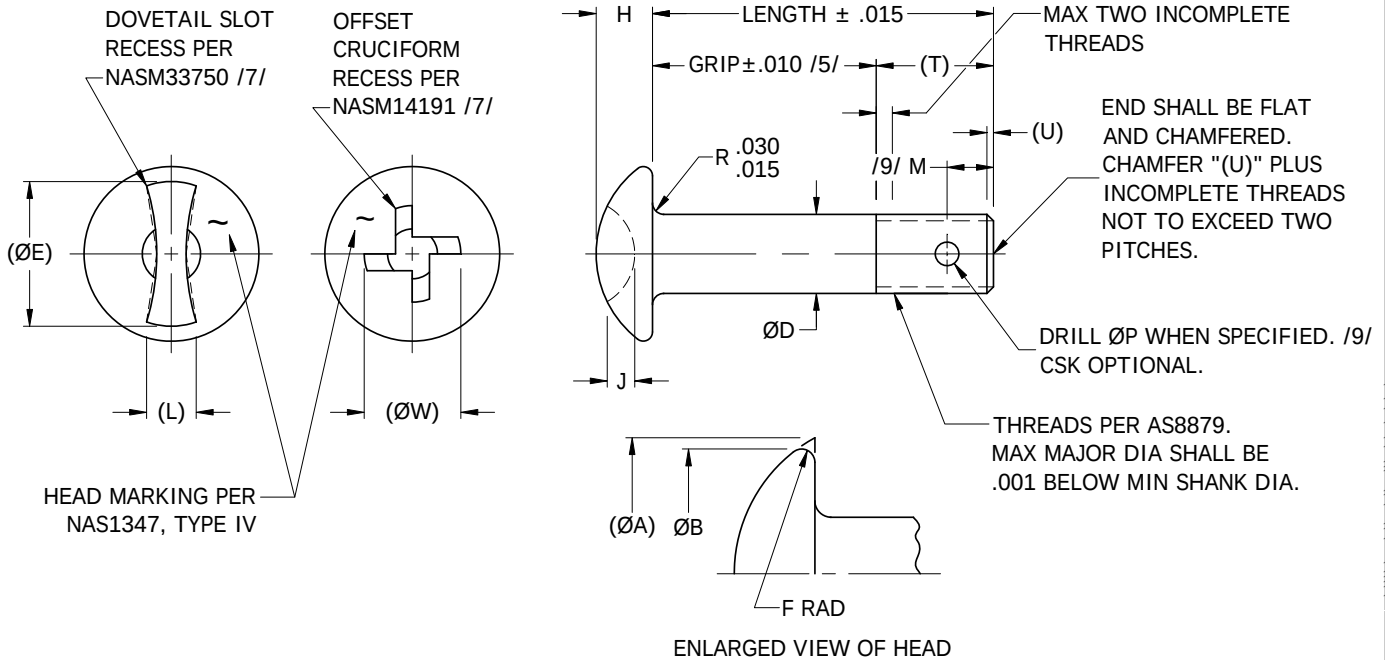


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /22/	(ØA)	ØB MIN	ØD #10/	(ØE) /4/	F RAD	H	J DEPTH		(L) /4/	M ±.010 /9/	ØP +.010 -.000 /9/	(T)	(U)	(ØW)
								OFS CRUC- FORM /3/	DVTL SLOT /4/						
NAS2842	.1640-32 UNJC-3A	.326	.309	.1635 .1625	.216	.010 .005	.102 .088	.065 .055	.061 .055	.090	-	-	.323	.016	.190 .180
NAS2843	.1900-32 UNJF-3A	.381	.361	.1895 .1885	.250	.015 .007	.118 .103	.075 .065	.061 .055	.094	.164	.070	.323	.016	.219 .209
NAS2844	.2500-28 UNJF-3A	.488	.464	.2495 .2485	.330	.020 .010	.150 .133	.098 .088	.078 .072	.119	.170	.076	.370	.018	.286 .276
NAS2845	.3125-24 UNJF-3A	.593	.568	.3120 .3110	.392	.025 .012	.183 .162	.122 .112	.093 .087	.133	.182	.076	.438	.021	.357 .347
NAS2846	.3750-24 UNJF-3A	.698	.671	.3745 .3735	.505	.030 .015	.215 .191	.145 .135	.129 .121	.164	.183	.106	.454	.021	.427 .417
NAS2847	.4375-20 UNJF-3A	.803	.774	.4370 .4360	.565	.034 .016	.248 .221	.169 .159	.144 .136	.188	.199	.106	.528	.025	.498 .488
NAS2848	.5000-20 UNJF-3A	.908	.877	.4995 .4985	.640	.038 .018	.280 .250	.193 .183	.164 .156	.227	.198	.106	.528	.025	.568 .558
NAS2849	.5625-18 UNJF-3A	1.013	.980	.5615 .5605	.773	.043 .021	.312 .279	.217 .207	.182 .174	.265	.207	.141	.594	.028	.638 .628
NAS2850	.6250-18 UNJF-3A	1.118	1.083	.6240 .6230	.821	.048 .024	.344 .308	.241 .231	.213 .205	.292	.207	.141	.626	.028	.708 .698

⑤ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 5
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, BRAZIER HEAD, OFFSET CRUCIFORM AND DOVETAIL SLOT, 180 KSI	CLASSIFICATION PART STANDARD
		NAS2842 THROUGH 2850 SHEET 1 OF 6

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	RECESS NUMBER		DOUBLE SHEAR STRENGTH LBF MIN	TENSILE STRENGTH LBF MIN /11/	FIM VALUE		RECESS TORQUE IN-LBF MIN	RAISED METAL IN MAX	FATIGUE LOADING, LBF			
	OFS CRUC- FORM	DVTL SLOT			ALLOY STEEL AND CRES /15/				TITANIUM /16/			
					HIGH TENSION LOAD	LOW TENSION LOAD			HIGH TENSION LOAD	LOW TENSION LOAD		
NAS2842	8	2	4,600	2,520	.005	.0040	50	.005	950	95	840	84
NAS2843	10	3	6,100	3,600	.005	.0040	60	.005	1,350	135	1,200	120
NAS2844	1/4	4	10,600	6,550	.006	.0030	140	.005	2,460	246	2,180	218
NAS2845	5/16	5	16,600	10,400	.007	.0030	220	.005	3,900	390	3,460	346
NAS2846	3/8	6	23,900	15,800	.009	.0025	520	.006	5,930	593	5,260	526
NAS2847	7/16	7	32,500	21,400	.009	.0025	750	.007	8,030	803	7,130	713
NAS2848	1/2	8	42,400	28,800	.010	.0020	900	.008	10,800	1,080	9,590	959
NAS2849	9/16	9	53,700	36,500	.010	.0020	1,300	.009	13,700	1,370	12,200	1,220
NAS2850	5/8	10	66,300	46,000	.010	.0020	2,100	.010	17,300	1,730	15,300	1,530

MATERIAL:

- ALLOY STEEL - 4140 (UNS G41400) PER 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. OPTIONAL ALUMINUM COAT PER NAS4006 DESIGNATED BY CODE "P". EXCEPT ON PARTS CODED "N", INCLUDE A HALOGEN FREE CETYL ALCOHOL LUBRICANT ON ALL CRES BOLTS BOTH WITH AND WITHOUT THE NAS4006 COATING. APPLY THE LUBRICANT ON "P" CODE BOLTS ONLY AFTER THE NAS4006 COATING IS APPLIED.
- TITANIUM ALLOY - NONE. OPTIONAL ALUMINUM COAT PER NAS4006 DESIGNATED BY CODE "P". EXCEPT ON PARTS CODED "N", INCLUDE A HALOGEN FREE CETYL ALCOHOL LUBRICANT ON ALL TITANIUM ALLOY BOLTS BOTH WITH AND WITHOUT THE NAS4006 COATING. APPLY THE LUBRICANT ON "P" CODE BOLTS ONLY AFTER THE NAS4006 COATING IS APPLIED.

- CODE: ADD "-" BETWEEN BASIC PART NUMBER AND DASH NUMBER FOR BOLTS, ALLOY STEEL, UNDRILLED.
- ADD "C" IN LIEU OF DASH TO DESIGNATE CORROSION RESISTANT STEEL.
- ADD "D" TO DASH NUMBER FOR DRILLED SHANK. /14/
- ADD "H" TO DASH NUMBER FOR DOVETAIL SLOT RECESS.
- ADD "N" TO DASH NUMBER FOR BOLTS WITHOUT CETYL ALCOHOL LUBRICANT.
- ADD "P" TO DASH NUMBER FOR BOLTS WITH ALUMINUM COAT.
- ADD "T" IN LIEU OF DASH TO DESIGNATE TITANIUM ALLOY.
- ADD "T" TO DASH NUMBER FOR OFFSET CRUCIFORM RECESS.
- IF MORE THAN ONE CODE LETTER IS USED IN SEQUENCE IN PART NUMBER, ARRANGE LETTERS ALPHABETICALLY.

REVISION

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NAS2842 THROUGH NAS2850
SHEET 2

⑤ COMPLETELY REVISED