

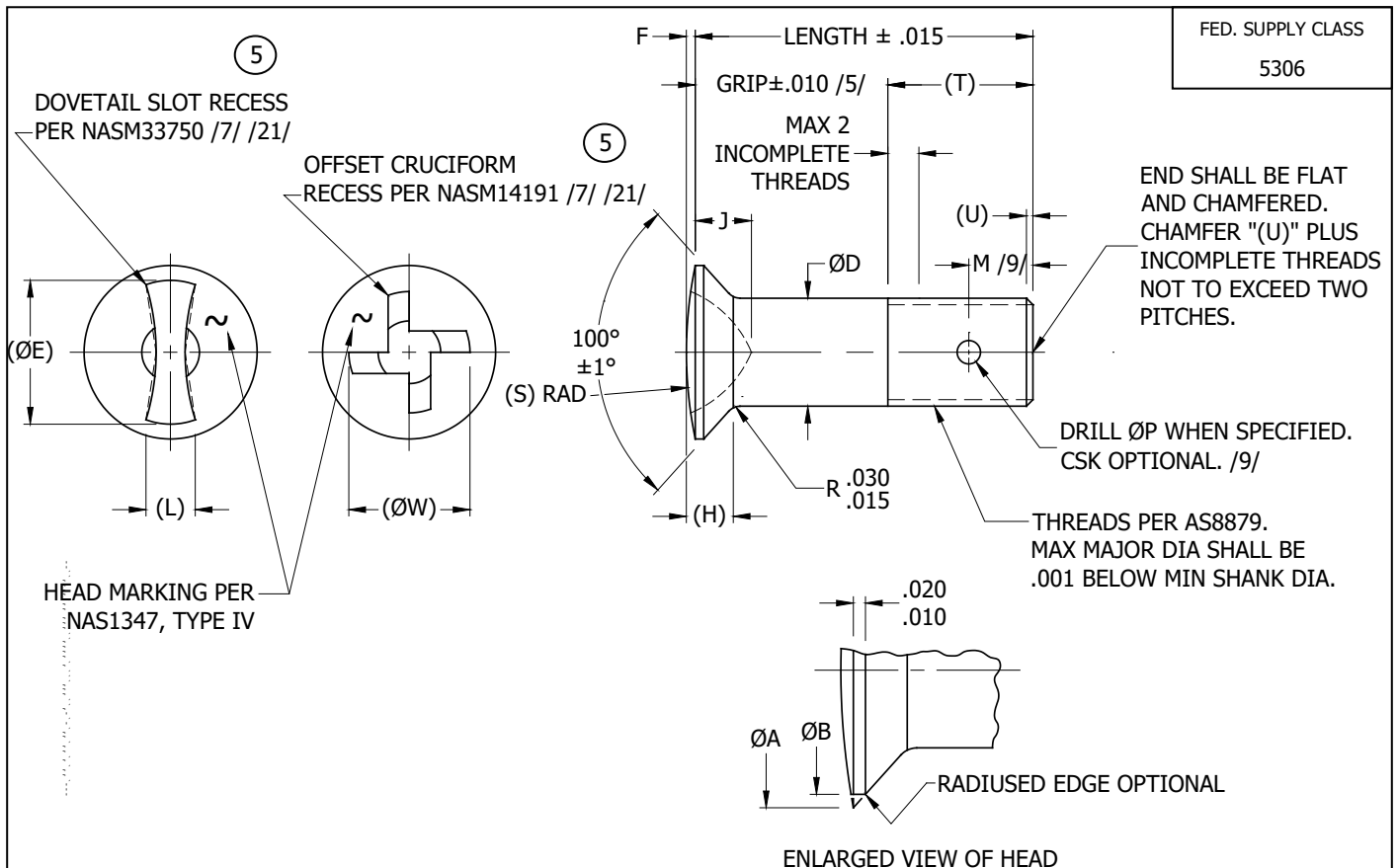


TABLE I – DIMENSIONS AND STRENGTH VALUES

BASIC PART NUMBER	THREAD /19/	ØA	ØB MIN	ØD /10/	(ØE) /4/	F ±.002	(H)	J		(L) /4/	M ±.010 /9/
								OFS CRUCI- FORM /3/	DVTL SLOT /4/		
NAS2852	.1640-32 UNJC-3A	.2612 .2534	.2083	.1635 .1625	.187	.008	.050	.074 .064	.037 .034	.088	–
NAS2853	.1900-32 UNJF-3A	.3047 .2965	.2516	.1895 .1885	.224	.009	.057	.087 .077	.048 .045	.100	.164
NAS2854	.2500-28 UNJF-3A	.3988 .3902	.3457	.2495 .2485	.300	.013	.076	.103 .093	.058 .055	.110	.170
NAS2855	.3125-24 UNJF-3A	.4787 .4696	.4256	.3120 .3110	.394	.016	.086	.134 .124	.065 .062	.134	.182
NAS2856	.3750-24 UNJF-3A	.5662 .5575	.5131	.3745 .3735	.484	.019	.100	.141 .131	.083 .080	.160	.183
NAS2857	.4375-20 UNJF-3A	.6741 .6632	.6200	.4370 .4360	.571	.022	.122	–	.092 .088	.198	.199
NAS2858	.5000-20 UNJF-3A	.7611 .7498	.7070	.4995 .4985	.660	.025	.135	–	.111 .107	.224	.198
NAS2859	.5625-18 UNJF-3A	.8449 .8326	.7908	.5615 .5605	.731	.028	.147	–	.126 .122	.256	.207
NAS2860	.6250-18 UNJF-3A	.9329 .9201	.8788	.6240 .6230	.819	.031	.161	–	.135 .131	.300	.207

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 5
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, 100° CROWN REDUCED HEAD, OFFSET CRUCIFORM AND DOVETAIL SLOT, 108 KSI Fsu	CLASSIFICATION PART STANDARD NAS 2852-2860 SHEET 1 OF 7

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5 TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

BASIC PART NUMBER	ØP +.010 -.000 /9/	(S) RAD	(T)	(U)	(ØW) /3/	RECESS NUMBER		DOUBLE SHEAR STRENGTH LBF MIN	TENSILE STRENGTH LBF MIN /11/	FIM VALUE		RECESS TORQUE IN-LBF MIN /7/
						OFS CRUCI- FORM	DVTL SLOT			Y /1/	Z /2/	
NAS2852	–	1.04	.323	.016	.182 .172	6	1	4,600	964	.005	.0040	–
NAS2853	.070	1.24	.323	.016	.215 .205	8	2	6,100	1,400	.005	.0040	50
NAS2854	.076	1.60	.370	.018	.248 .238	10	3	10,600	2,570	.006	.0030	95
NAS2855	.076	1.84	.438	.021	.325 .315	1/4	4	16,600	4,120	.007	.0030	165
NAS2856	.106	2.15	.454	.021	.357 .347	5/16	5	23,900	6,290	.009	.0025	250
NAS2857	.106	2.67	.528	.025	–	–	6	32,500	8,490	.009	.0025	430
NAS2858	.106	2.91	.528	.025	–	–	7	42,400	11,500	.010	.0020	925
NAS2859	.141	3.19	.594	.028	–	–	8	53,700	14,600	.010	.0020	1,210
NAS2860	.141	3.50	.626	.028	–	–	9	66,300	18,500	.010	.0020	1,760

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. 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.

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CODE:

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NAS2855 T 10 D N P T

T = OFFSET CRUCIFORM RECESS; PART NUMBERS NAS2852, NAS2853,
NAS2854, NAS2855, NAS2856 ONLY /21/
H = DOVETAIL SLOT RECESS /21/

FINISH:

ALLOY STEEL:

NO CODE = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II,
CLASS 2

CRES:

P = ALUMINUM COAT

NO CODE = PASSIVATE PER AMS2700, METHOD 1, CLASS 4

TITANIUM:

P = ALUMINUM COAT

NO CODE = NO FINISH

N = BOLTS WITHOUT CETYL ALCOHOL LUBRICANT

D = DRILLED SHANK /20/
NO CODE = UNDRILLED SHANK

GRIP DASH NUMBER PER TABLE II

MATERIAL:

T = TITANIUM ALLOY

C = CRES

"-" = ALLOY STEEL

BASIC PART NUMBER

AFTER THE GRIP DASH NUMBER, WHERE MORE THAN ONE CODE LETTER IS USED IN PART NUMBER,
ARRANGE LETTERS ALPHABETICALLY

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