

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST REVISION DATE.

FORM 12-01

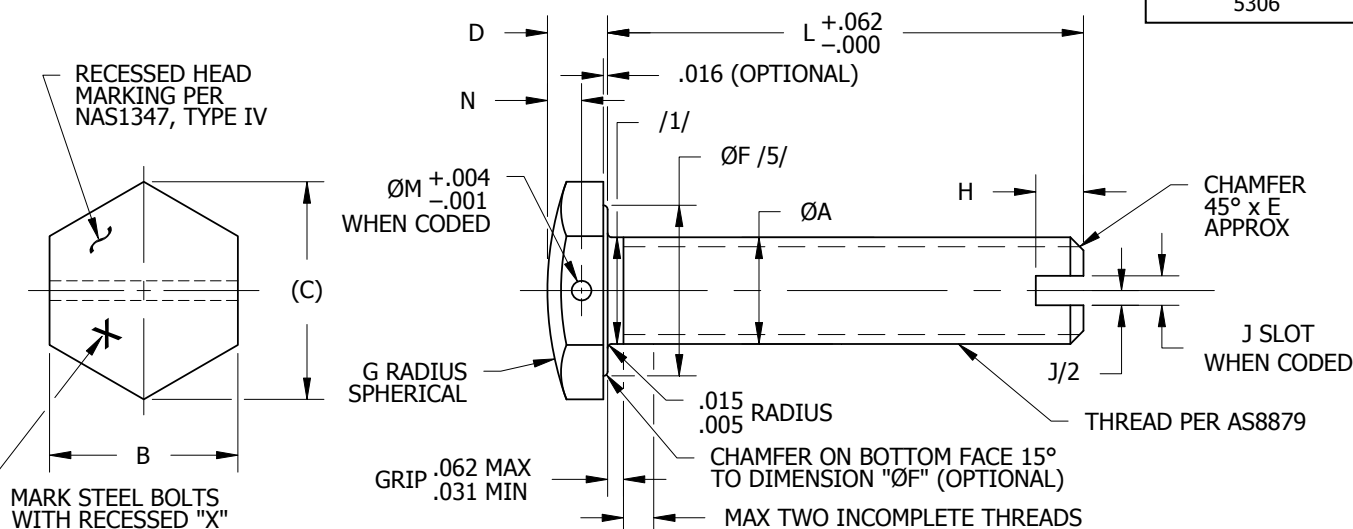


TABLE I – DIMENSIONS

DIA DASH NO.	THREAD /6/	ØA MAX	B +.002 -.010	(C)	D	E	ØF MIN /5/	G	H	J	ØM	N
~~3~~ 3A	~~.1900-32 UNF-3A~~ .1900-32 UNJF-3A	.1900	.375	.430	.109	.031	.335	.750	.067 .047	.047 .031	.035	.063 .053
~~4~~ 4A	~~.2500-28 UNF-3A~~ .2500-28 UNJF-3A	.2500	.438	.510	.141	.031	.398	.750	.130 .097	.077 .061	.046	.090 .070
~~5~~ 5A	~~.3125-24 UNF-3A~~ .3125-24 UNJF-3A	.3125	.500	.580	.172	.047	.460	1.000	.130 .097	.077 .061	.070	.104 .084
~~6~~ 6A	~~.3750-24 UNF-3A~~ .3750-24 UNJF-3A	.3750	.563	.650	.203	.047	.523	1.000	.130 .097	.077 .061	.070	.114 .094

MATERIAL: ALLOY STEEL: SEE PROCUREMENT SPECIFICATION
CRES: A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.

FINISH:	ALLOY STEEL:	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
	CRES:	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
		OR PASSIVATE PER AMS2700, METHOD 1, CLASS 4
	(11)	OR PASSIVATE PER AMS2700, METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT
		OR PASSIVATE PER AMS2700, METHOD 2 - NO POST TREATMENT

ISSUE DATE: OCTOBER 1948 REVISION DATE: DECEMBER 19, 2014

THIRD ANGLE PROJECTION 	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 11
PROCUREMENT SPECIFICATION NASM6812 EXCEPT AS NOTED	TITLE BOLT, MACHINE, CROWNED HEXAGON HEAD, ADJUSTING	CLASSIFICATION PART STANDARD NAS 428 SHEET 1 OF 3

CODE:

- (11) DIAMETER DASH NUMBER INDICATES THREAD SIZE PER TABLE I
- (11) ADD "B" FOR CRES PASSIVATED BOLT PER AMS2700, METHOD 2 - NO POST TREATMENT
- (11) ADD "C" FOR CRES PASSIVATED BOLT PER AMS2700, METHOD 1, CLASS 4
- ADD "H" FOR BOLT WITH DRILLED HEAD
- ADD "K" FOR BOLT WITH SLOTTED SHANK
- (11) ADD "M" FOR CRES PASSIVATED BOLT PER AMS2700, METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT
- ADD "P" FOR CADMIUM PLATED CRES BOLT
- LENGTH DASH NUMBER PER TABLE II: SINGLE DIGIT INDICATES LENGTH IN .125 INCREMENTS. DOUBLE DIGIT INDICATES LENGTH IN WHOLE INCHES AND .125 INCREMENTS. LENGTHS OTHER THAN TABULATED MAY BE SPECIFIED.
- AFTER THE DASH NUMBER, WHERE MORE THAN ONE CODE LETTER IS USED IN PART NUMBER, ARRANGE LETTERS ALPHABETICALLY.

EXAMPLE OF PART NUMBER:

- ~~NAS428-4-14 = .2500-28 UNF-3A, ALLOY STEEL, ADJUSTING BOLT, CADMIUM PLATED, 1.500 LONG~~
- NAS428-4A14 = .2500-28 UNJF-3A, ALLOY STEEL, ADJUSTING BOLT, CADMIUM PLATED, 1.500 LONG
- (11) NAS428CK4A14 = .2500-28 UNJF-3A, CRES, ADJUSTING BOLT, PASSIVATED PER AMS2700, METHOD 1, CLASS 4, 1.500 LONG WITH SLOTTED SHANK
- (11) NAS428KM4A14 = .2500-28 UNJF-3A, CRES, ADJUSTING BOLT, PASSIVATED PER AMS2700, METHOD 1, TYPE 8, CLASS 4 - NO POST TREATMENT, 1.500 LONG WITH SLOTTED SHANK
- NAS428HK4A51 = .2500-28 UNJF-3A, ALLOY STEEL, ADJUSTING BOLT, CADMIUM PLATED, 5.125 LONG WITH SLOTTED SHANK AND DRILLED HEAD

NOTES:

- /1/ THE DIAMETER OF THE UNTHREADED PORTION SHALL NOT BE LESS THAN THE MINIMUM PITCH DIAMETER NOR MORE THAN THE MAXIMUM MAJOR DIAMETER OF THE THREAD.
- (2) REMOVE ALL BURRS AND SHARP EDGES.
- (3) SLOT IN SHANK NEED NOT BE IN ANY DEFINITE RELATION TO THE BOLT HEAD.
- (4) DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED. TOLERANCES: DECIMALS $\pm .010$, ANGLES $\pm 1^\circ$.
- /5/ WASHER FACE DIAMETER MAX NOT TO EXCEED ACTUAL WIDTH ACROSS FLATS.
- /6/ UNF-3A THREAD FORM INACTIVE FOR DESIGN AFTER MAY 1994.
- (7) DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (8) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (9) 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.
- (10) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (11) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

11

NAS428ents

SHEET 2



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