

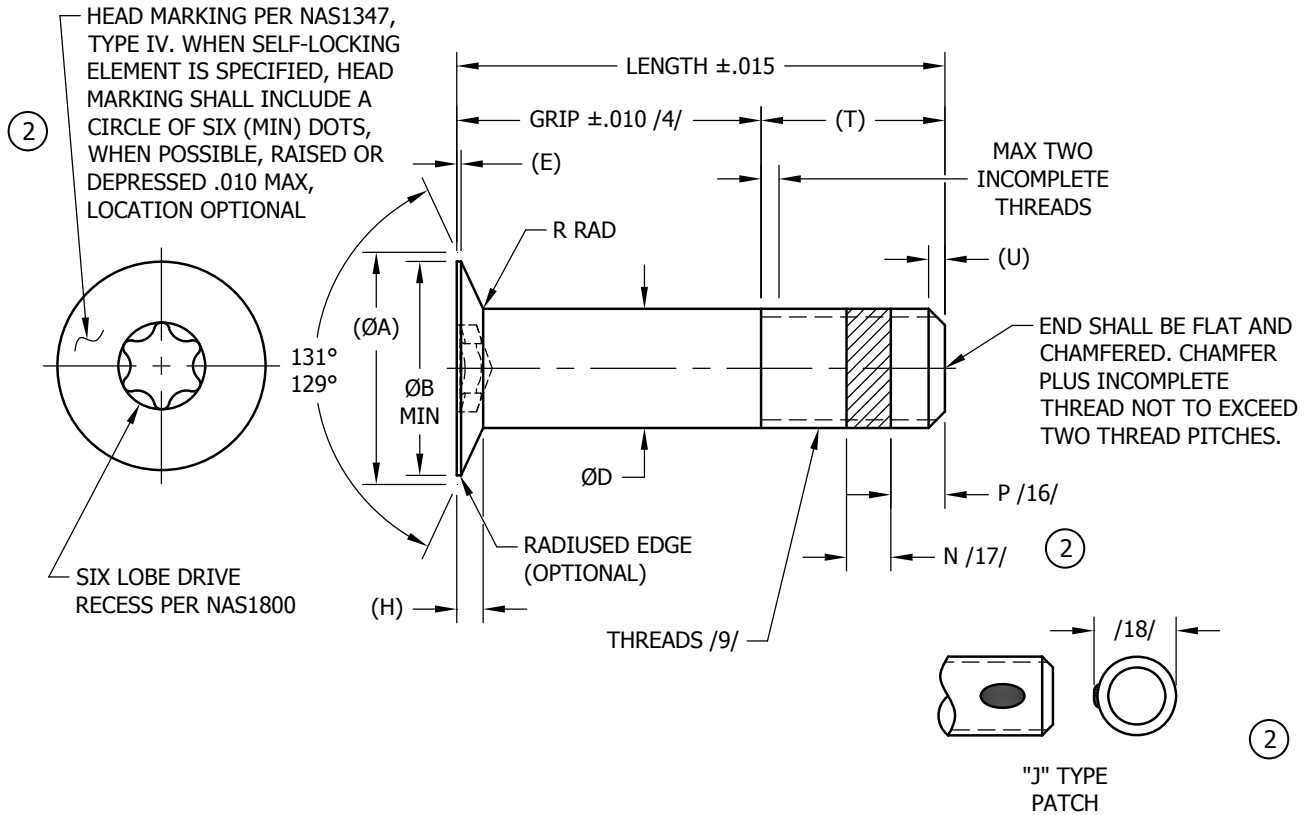


FIGURE 1 – SCREW CONFIGURATION

TABLE I – DIMENSIONS

DIA DASH NO.	THREAD UNJF-3A /9/	RECESS SIZE	(ØA) /14/	ØB MIN	ØD		(E) /14/	(H) /14/	R RAD	(T)	(U)	TOLERANCES	
					AFTER PLATING OR COATING	UNPLATED						Y /1/	Z /2/
3	.1900-32	T20	.4045	.3206	.1895 .1885	.1895 .1890	.013	.049	.020 .010	.363	.050	.0045	.0040
4	.2500-28	T20	.5260	.4421	.2495 .2485	.2495 .2490	.015	.063	.020 .010	.403	.050	.0045	.0030
5	.3125-24	T30	.6192	.5353	.3120 .3110	.3120 .3115	.018	.070	.025 .010	.501	.060	.0045	.0030
6	.3750-24	T30	.7300	.6461	.3745 .3735	.3745 .3740	.021	.081	.030 .015	.594	.060	.0060	.0025

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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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.

REVISION DATE: OCTOBER 31, 2012

ISSUE DATE: JULY 2006

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, SHEAR, 130 DEG FLUSH HEAD, CLOSE TOLERANCE, SELF-LOCKING AND NON-LOCKING, NAS1800 SIX LOBE RECESS, 95 KSI Fsu	CLASSIFICATION PART STANDARD
		NAS5310 SHEET 1 OF 6

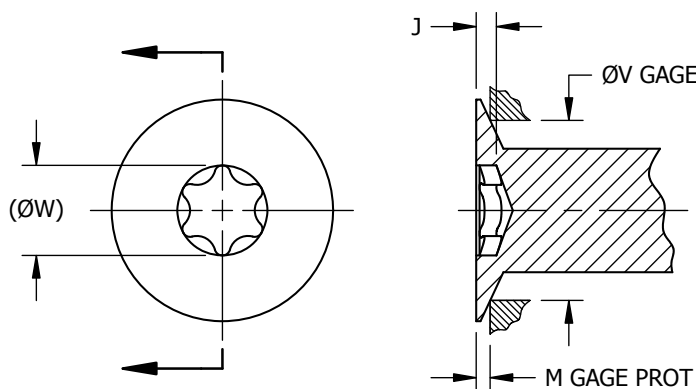


FIGURE 2 – RECESS AND GAGING DIMENSIONS

TABLE II – RECESS, GAGING DIMENSIONS AND STRENGTH VALUES

DIA DASH NO	J RECESS GAGING PENETRATION /3/	HEAD GAGING		TORQUE MIN LBF-IN /5/	RAISED METAL MAX /5/	TENSILE STRENGTH LBF MIN /12/	DOUBLE SHEAR LBF MIN	(ØW)
		M HEAD PROTRUSION /7/	ØV GAGE CIRCLE /7/					
3	.045 .039	.0362 .0324	.2441 .2439	45	.005	2,000	5,380	.155
4	.055 .049	.0435 .0390	.3315 .3313	75	.005	3,700	9,300	.155
5	.060 .049	.0479 .0429	.4047 .4045	175	.005	5,000	14,600	.221
6	.065 .059	.0546 .0490	.4854 .4852	300	.006	7,200	21,000	.221

MATERIAL:

CRES – A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.

TITANIUM ALLOY – 6AL-4V (UNS R56400) PER AMS4928 OR AMS4967.

②

LOCKING ELEMENT – POLYETHYLENE TEREPHTHALATE (POLYESTER) PER AMS3612, OR POLYAMIDE-IMIDE PER AMS3670, COLOR OPTIONAL, 400 DEG F MAX. LOCKING TORQUE APPLICABLE FOR 5 TORQUE CYCLES.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 OR AMS2759 FOR CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM.

CRES – 160-190 KSI F_{TU}. PRECIPITATION HARDENING PER AMS5853 OR AMS2759. /12/

TITANIUM (6AL-4V) – 160 KSI F_{TU} MIN

FINISH:

CRES – PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2

TITANIUM ALLOY – NONE OR OPTIONAL ALUMINUM PIGMENTED COATING PER NAS4006 WITH CETYL ALCOHOL LUBRICANT PER AS87132, TYPE III, GRADE B.

REVISION

2

NAS5310
SHEET 2



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