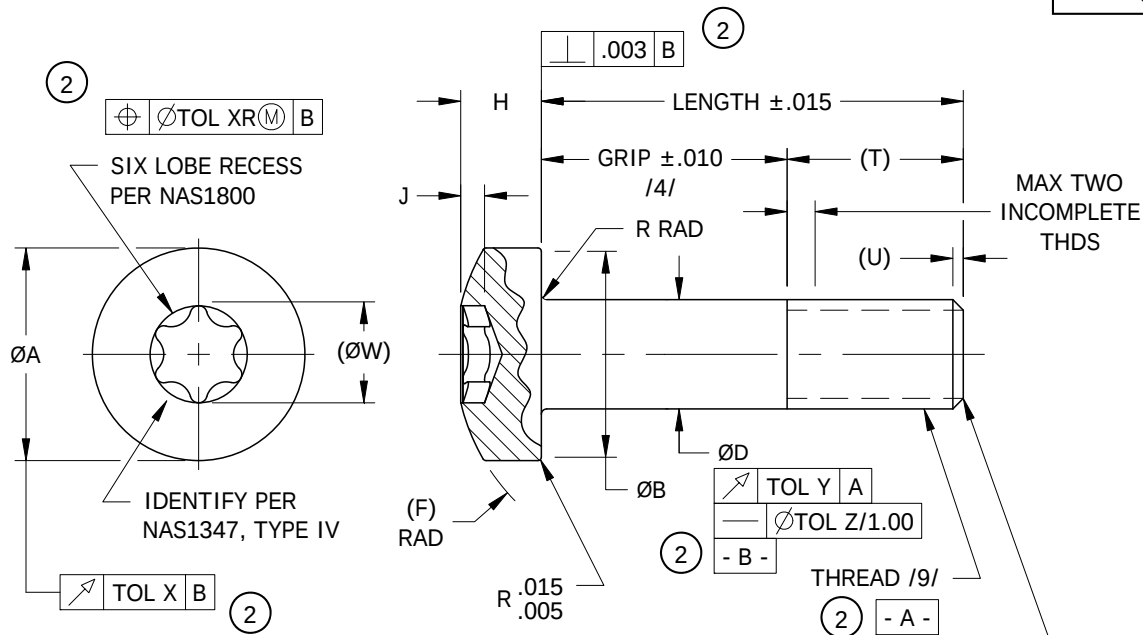


FED. SUPPLY CLASS

5305



END SHALL BE FLAT AND CHAMFERED.
CHAMFER PLUS INCOMPLETE THREAD
NOT TO EXCEED TWO THREAD PITCHES.

TABLE I – DIMENSIONS

DIA DASH NO.	THREAD /9/	RECESS SIZE	ØA	ØB MIN	ØD		H	R RAD	(T)	(U)	(F) RAD	(ØW)
					PLATED OR COATED	UNPLATED						
06	.1380-32 UNJC-3A	T10	.270 .256	.242	.1375 .1365	.1375 .1370	.097 .087	.010 .005	.276	.016	.20	.111
08	.1640-32 UNJC-3A	T20	.322 .306	.289	.1635 .1625	.1635 .1630	.115 .105	.020 .010	.276	.016	.24	.155
3	.1900-32 UNJF-3A	T20	.373 .357	.331	.1895 .1885	.1895 .1890	.133 .122	.020 .010	.276	.016	.28	.155
4	.2500-28 UNJF-3A	T30	.492 .473	.424	.2495 .2485	.2495 .2490	.175 .162	.020 .010	.316	.018	.37	.221
5	.3125-24 UNJF-3A	T30	.615 .594	.518	.3120 .3110	.3120 .3115	.218 .203	.020 .010	.375	.021	.53	.221
6	.3750-24 UNJF-3A	T40	.740 .716	.611	.3745 .3735	.3745 .3740	.261 .244	.025 .015	.391	.021	.65	.266
8	.5000-20 UNJF-3A	T55	.987 .958	.801	.4995 .4985	.4995 .4990	.348 .327	.030 .020	.453	.025	.90	.446

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, SHEAR, PAN HEAD, CLOSE TOLERANCE, SHORT THREAD, NAS1800 SIX LOBE RECESS, 95 KSI Fsu	CLASSIFICATION PART STANDARD



NAS5314
SHEET 1 OF 4
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(2)

TABLE II – DIMENSIONS, TOLERANCES AND STRENGTH VALUES

DIA DASH NO.	FIM VALUES				MIN TENSILE STRENGTH, LBF /12/	MIN DOUBLE SHEAR STRENGTH, LBF	J RECESS GAGE PENETRATION /3/		MIN TORQUE LBF-IN /5/	RAISED METAL MAX /5/
	X /1/	Y /1/	Z /2/	XR /1/			MAX	MIN		
06	.005	.0045	.0040	.016	1,450	2,850	.050	.044	27	.005
08	.005	.0045	.0040	.016	2,240	4,010	.050	.044	42	.005
3	.005	.0045	.0040	.016	3,180	5,380	.065	.054	75	.005
4	.006	.0045	.0030	.016	5,820	9,300	.065	.054	175	.005
5	.008	.006	.0030	.024	9,200	14,600	.075	.064	300	.005
6	.009	.006	.0025	.024	14,000	21,000	.080	.069	500	.006
8	.010	.006	.0020	.024	25,600	37,300	.117	.102	1500	.008

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.

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

CRES – 160 - 190 KSI Ft_u. PRECIPITATION HARDENING PER AMS5853 OR AMS2759. /12/

TITANIUM (6AL-4V) – 160 KSI Ft_u 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 ALUMINUM PIGMENTED COATING PER NAS4006 WITH CETYL ALCOHOL LUBRICANT PER AS87132, TYPE III, GRADE B.

CODE: BASIC PART NUMBER = SCREW, PAN HEAD, NAS1800 SIX LOBE RECESS.

MATERIAL CODE AFTER BASIC PART NUMBER:

ADD "E" FOR CRES.

ADD "V" FOR TITANIUM.

DIAMETER DASH NUMBER DESIGNATES DIAMETER AND THREAD.

FINISH CODE AFTER DIAMETER DASH NUMBER:

ADD "-" FOR PASSIVATION (CRES ONLY).

ADD "-" FOR BARE TITANIUM

ADD "A" FOR ALUMINUM PIGMENTED COATING (TITANIUM ONLY).

ADD "P" FOR CADMIUM PLATING (CRES ONLY).

GRIP DASH NUMBER DESIGNATES GRIP LENGTH IN .0625 INCREMENTS (SEE TABLE III). /14/

EXAMPLES OF PART NUMBERS:

NAS5314E3-10 = SCREW, .1900-32 THREAD, PASSIVATED CRES, .625 GRIP.

NAS5314V5-15 = SCREW, .3125-24 THREAD, TITANIUM ALLOY, .938 GRIP.

NAS5314V5A15 = SCREW, .3125-24 THREAD, ALUMINUM PIGMENTED COATED TITANIUM, .938 GRIP.

NAS5314E3P10 = SCREW, .1900-32 THREAD, CADMIUM PLATED CRES, .625 GRIP.

NOTES:

/1/ CONCENTRICITY: "ØD" AND THREAD PITCH DIAMETER WITHIN "Y" VALUES FIM. "ØB" AND "ØD" WITHIN "X" VALUES FIM. RECESS TO ØD WITHIN .016 FIM THRU .2500 SIZE; WITHIN .024 FIM ABOVE .2500 SIZE.

REVISION

2

NAS5314

SHEET 2



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