

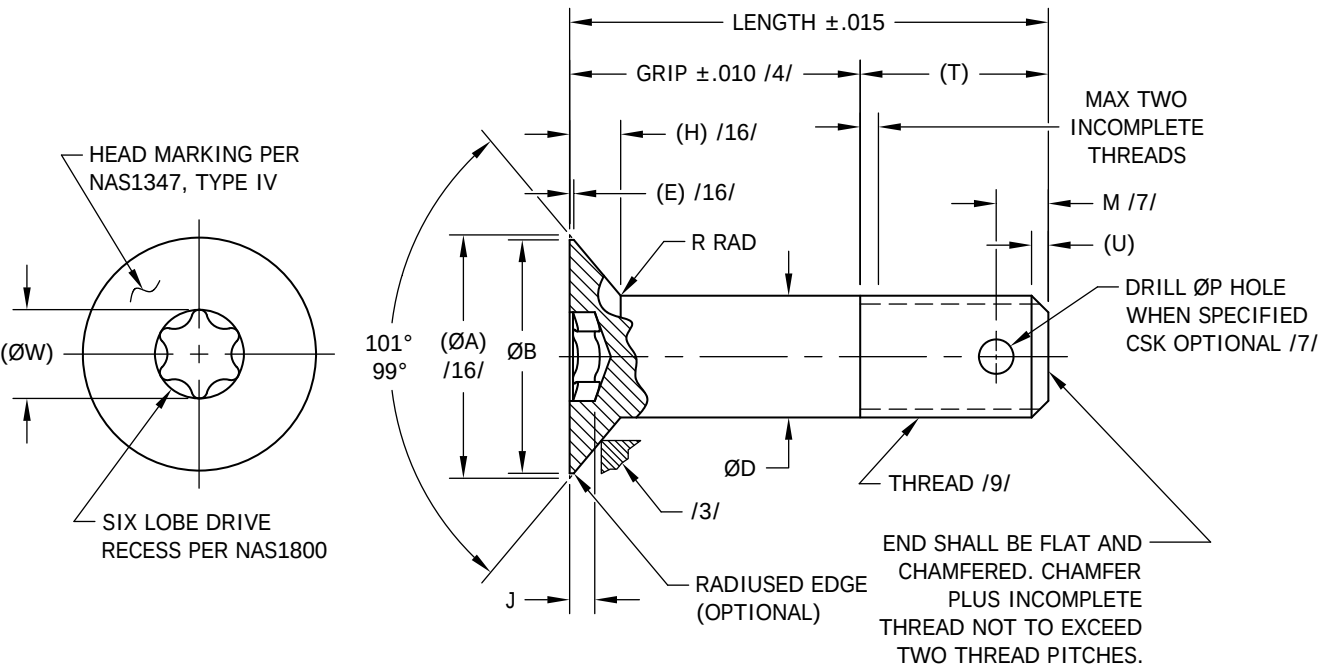


TABLE I – DIMENSIONS

DIA DASH NO.	THREAD /9/	RECESS SIZE	ØD		(ØA) /16/	ØB MIN	(E) /16/	(H) /16/	M /7/	ØP /7/	R RAD	(T)	(U)	(ØW)
			PLATED OR COATED	UNPLATED										
06	.1380-32 UNJC-3A	T10	.1375 .1365	.1375 .1370	.279 .269	.221	.015	.057	--	--	.020 .010	.276	.016	.111
08	.1640-32 UNJC-3A	T20	.1635 .1625	.1635 .1630	.337 .328	.280	.015	.068	--	--	.020 .010	.276	.016	.155
3	.1900-32 UNJF-3A	T20	.1895 .1885	.1895 .1890	.385 .376	.328	.015	.080	.127 .117	.080 .070	.020 .010	.276	.016	.155
4	.2500-28 UNJF-3A	T30	.2495 .2485	.2495 .2490	.507 .497	.449	.015	.106	.126 .116	.086 .076	.020 .010	.316	.018	.221
5	.3125-24 UNJF-3A	T30	.3120 .3110	.3120 .3115	.635 .625	.577	.015	.133	.129 .119	.086 .076	.025 .010	.375	.021	.221
6	.3750-24 UNJF-3A	T40	.3745 .3735	.3745 .3740	.762 .752	.704	.015	.160	.130 .120	.116 .106	.030 .015	.391	.021	.266
8	.5000-20 UNJF-3A	T55	.4995 .4985	.4995 .4990	1.017 1.007	.959	.015	.215	.133 .123	.116 .106	.030 .015	.453	.025	.446

① COMPLETELY REVISED

REVISION DATE: MAY 27, 2011

ISSUE DATE: JULY 2006

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, SHEAR, 100 DEG FLUSH HEAD, CLOSE TOLERANCE, SHORT THREAD, NAS1800 SIX LOBE RECESS, 95 KSI Fsu	CLASSIFICATION PART STANDARD



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TABLE II – DIMENSIONS, TOLERANCES AND STRENGTH VALUES

DIA DASH NO.	TOLERANCES		MIN TENSILE STRENGTH, LBF /12/ /13/	MIN DOUBLE SHEAR STRENGTH, LBF	J RECESS GAGING PENETRATION /3/		TORQUE MIN LBF-IN /5/	RAISED METAL MAX /5/
	Y /1/	Z /2/			MAX	MIN		
06	.0045	.0040	1,450	2,850	.037	.031	27	.005
08	.0045	.0040	2,240	4,010	.040	.034	42	.005
3	.0045	.0040	3,180	5,380	.055	.044	75	.005
4	.0045	.0030	5,820	9,300	.065	.054	175	.005
5	.006	.0030	9,200	14,600	.075	.064	300	.005
6	.006	.0025	14,000	21,000	.080	.069	500	.006
8	.006	.0020	25,600	37,300	.117	.103	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 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 ALUMINUM PIGMENTED COATING PER NAS4006 WITH CETYL ALCOHOL LUBRICANT PER AS87132, TYPE III, GRADE B.

CODE: BASIC PART NUMBER = SCREW, 100 DEG FLUSH 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 INCH INCREMENTS (SEE TABLE III).
TYPE CODE AFTER GRIP DASH NUMBER:
ADD "D" FOR DRILLED THREAD.
NO CODE = UNDRILLED.

EXAMPLES OF PART NUMBERS:

NAS5315E3-10 = SCREW, .1900-32 THREAD, PASSIVATED CRES, .625 GRIP.
NAS5315V5-15 = SCREW, .3125-24 THREAD, TITANIUM ALLOY, .938 GRIP.
NAS5315V5A15 = SCREW, .3125-24 THREAD, ALUMINUM PIGMENTED COATED TITANIUM, .938 GRIP.
NAS5315E3P10 = SCREW, .1900-32 THREAD, CADMIUM PLATED CRES, .625 GRIP.
NAS5315V06A19D = SCREW, .1380-32 THREAD, ALUMINUM PIGMENTED COATED TITANIUM, 1.188 GRIP, DRILLED THREAD.

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REVISION

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