

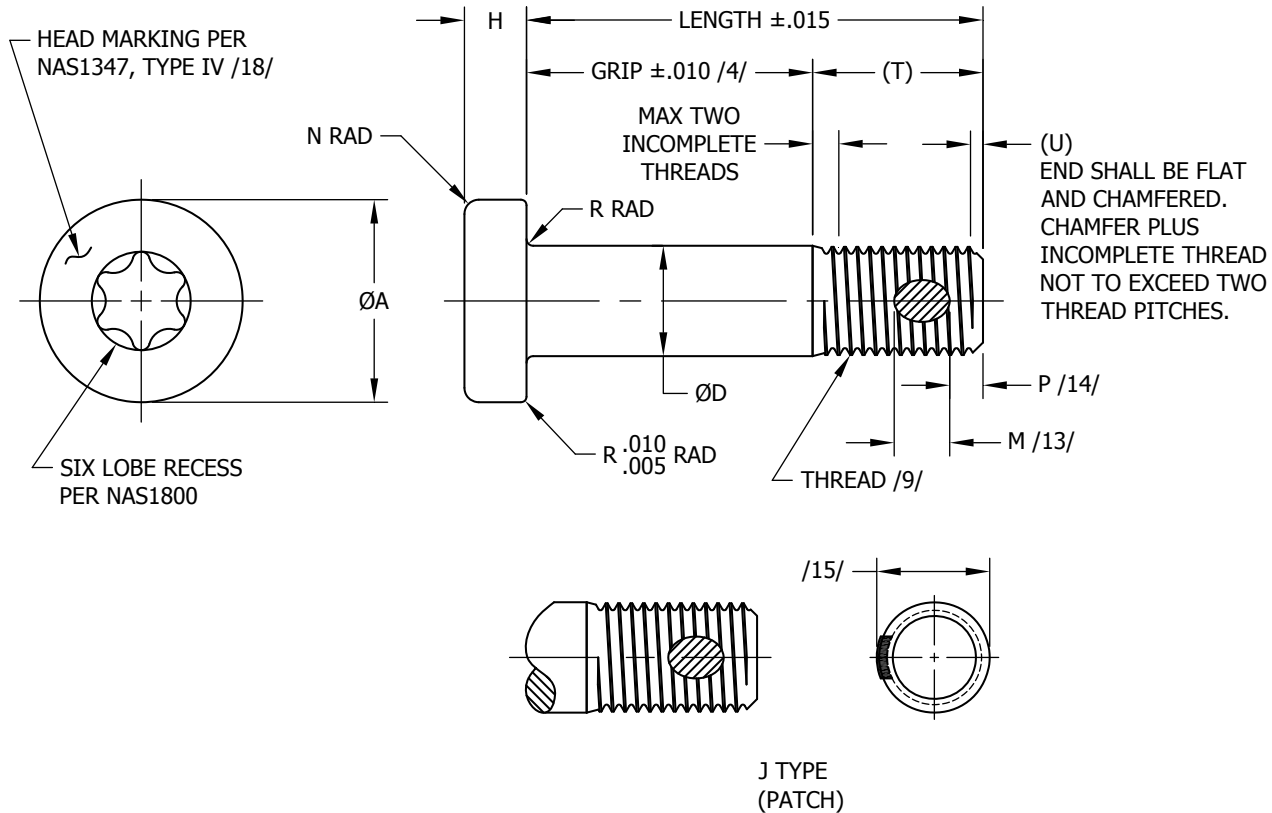


FIGURE 1 – BOLT CONFIGURATION

TABLE I – DIMENSIONS

DIA DASH NO.	THREAD UNJF-3A /9/	RECESS SIZE	ØA	ØD		H	N RAD	R RAD	(T)	(U)
				UNPLATED	PLATED OR COATED					
3	.1900-32	T20	.374	.1895	.1895	.125	.035	.020	.363	.050
			.360	.1890	.1885	.115	.025	.010		
4	.2500-28	T30	.492	.2495	.2495	.150	.040	.020	.403	.050
			.477	.2490	.2485	.140	.025	.010		
5	.3125-24	T30	.612	.3120	.3120	.188	.050	.025	.501	.060
			.597	.3115	.3110	.176	.035	.010		
6	.3750-24	T40	.740	.3745	.3745	.220	.050	.025	.594	.060
			.722	.3740	.3735	.206	.035	.015		
8	.5000-20	T55	.925	.4995	.4995	.280	.065	.030	.768	.080
			.905	.4990	.4985	.262	.045	.020		

① COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, SHEAR, FLAT PAN HEAD, CLOSE TOLERANCE, LONG THREAD, NON-LOCKING AND SELF-LOCKING, NAS1800 SIX LOBE RECESS, 95 KSI FSU	CLASSIFICATION PART STANDARD
		NAS5318 SHEET 1 OF 6

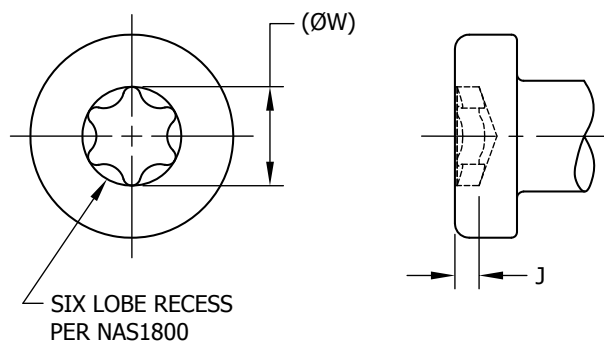


FIGURE 2 – RECESS CONFIGURATION

TABLE II – DIMENSIONS, TOLERANCES & STRENGTH VALUES

DIA DASH NO.	FIM VALUES			J RECESS GAGE PENETRATION /3/	(ØW)	TENSILE STRENGTH MIN, LBF /12/	DOUBLE SHEAR STRENGTH MIN, LBF	MIN TORQUE LBF-IN /5/	RAISED METAL MAX /5/
	X /1/	Y /1/	Z /2/						
3	.005	.0045	.0040	.065 .054	.155	3,180	5,380	75	.005
4	.006	.0045	.0030	.065 .054	.221	5,790	9,300	175	.005
5	.008	.006	.0030	.075 .064	.221	9,260	14,600	300	.005
6	.009	.006	.0025	.080 .069	.266	14,000	21,000	500	.006
8	.011	.006	.0020	.117 .102	.446	25,600	37,300	1,500	.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.

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

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} /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.

LUBRICATION:

TITANIUM ALLOY – FOR ALUMINUM PIGMENTED COATING OPTION, ADD CETYL ALCOHOL LUBRICANT PER AS87132, TYPE III, GRADE B.

① COMPLETELY REVISED

REVISION
1
NAS5318
SHEET 2



Documents

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