

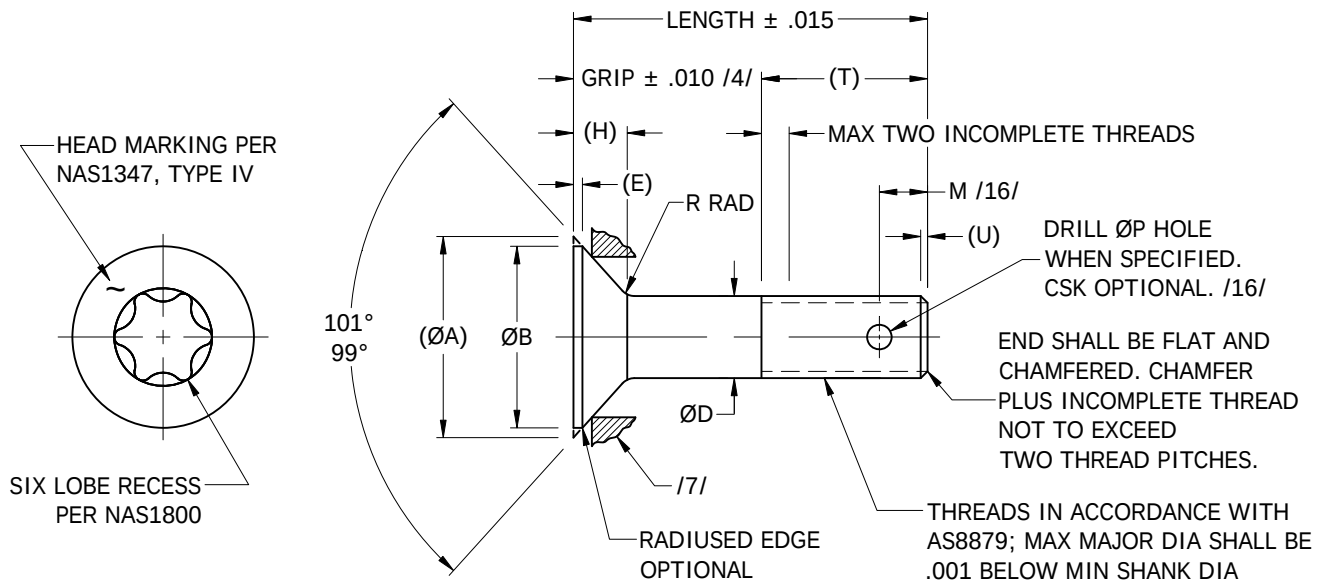


FIGURE 1 – SCREW CONFIGURATION

TABLE I – SCREW DIMENSIONS

DIA DASH NO.	THREAD /9/	RECESS SIZE	(ØA) /15/	ØB MIN	ØD		(E) /15/	(H) /15/	M ±.010 /16/	ØP +.010 -.000 /16/	R RAD	(T)	(U)
					AFTER PLATING OR COATING	UNPLATED							
08	.1640-32 UNJC-3A	T20	.332	.294	.1635 .1625	.1635 .1630	.013	.072	—	—	.020 .010	.338	.039
3	.1900-32 UNJF-3A	T20	.3813	.339	.1895 .1885	.1895 .1890	.015	.083	.116	.070	.035 .015	.363	.050
4	.2500-28 UNJF-3A	T30	.5066	.464	.2495 .2485	.2495 .2490	.015	.111	.116	.076	.035 .015	.403	.050
5	.3125-24 UNJF-3A	T30	.6335	.578	.3120 .3110	.3120 .3115	.015	.140	.120	.076	.045 .025	.501	.060
6	.3750-24 UNJF-3A	T40	.7604	.717	.3745 .3735	.3745 .3740	.015	.167	.120	.106	.045 .025	.594	.060
8	.5000-20 UNJF-3A	T55	1.0139	.951	.4995 .4985	.4995 .4990	.022	.222	.124	.106	.055 .035	.768	.080
10	.6250-18 UNJF-3A	T60	1.2723	1.201	.6240 .6230	.6240 .6235	.025	.280	.124	.141	.055 .035	.981	.090

③ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 3
PROCUREMENT SPECIFICATION NOTED	TITLE SCREW, SHEAR, 100 DEG FLUSH HEAD, CLOSE TOLERANCE, NAS1800 SIX LOBE RECESS, 95 KSI Fsu	CLASSIFICATION PART STANDARD
		NAS5319 SHEET 1 OF 5

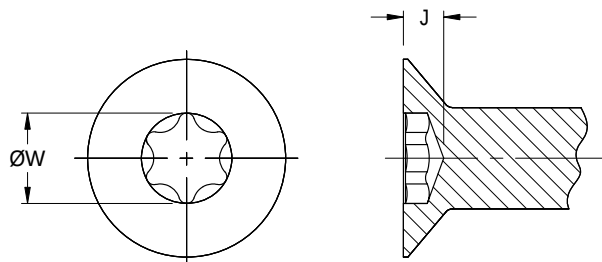


FIGURE 2 – RECESS DIMENSIONS

TABLE II – TOLERANCES, RECESS AND STRENGTH DATA

DIA DASH NO.	TOLERANCES		MIN TENSILE STRENGTH, LBF /12/	MIN DOUBLE SHEAR STRENGTH, LBF	J RECESS GAGING PENETRATION		(ØW)	TORQUE MIN IN-LBF /5/	RAISED METAL MAX /5/
	Y /13/	Z /2/			MAX /3/	MIN /3/			
08	.0045	.0040	2,240	4,010	.040	.034	.155	42	.005
3	.005	.0040	3,180	5,380	.055	.044	.155	75	.005
4	.006	.0030	5,820	9,300	.065	.054	.221	175	.005
5	.007	.0030	9,200	14,600	.075	.064	.221	300	.005
6	.008	.0025	14,600	21,000	.080	.069	.266	500	.006
8	.010	.0020	25,600	37,300	.117	.103	.446	1500	.008
10	.010	.0020	40,900	58,300	.147	.133	.529	3000	.010

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 TREAT: 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 /12/
TITANIUM: 160 KSI Ft_u MIN

FINISH: CRES - PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, TYPE 2 OR TYPE 8, 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 HEAD, 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 (TABLE III). /20/

ADD "D" AFTER GRIP DASH NUMBER FOR DRILLED THREAD.

REVISION

3

③ COMPLETELY REVISED



Documents

SHEET 2

Document Sharing Hub