

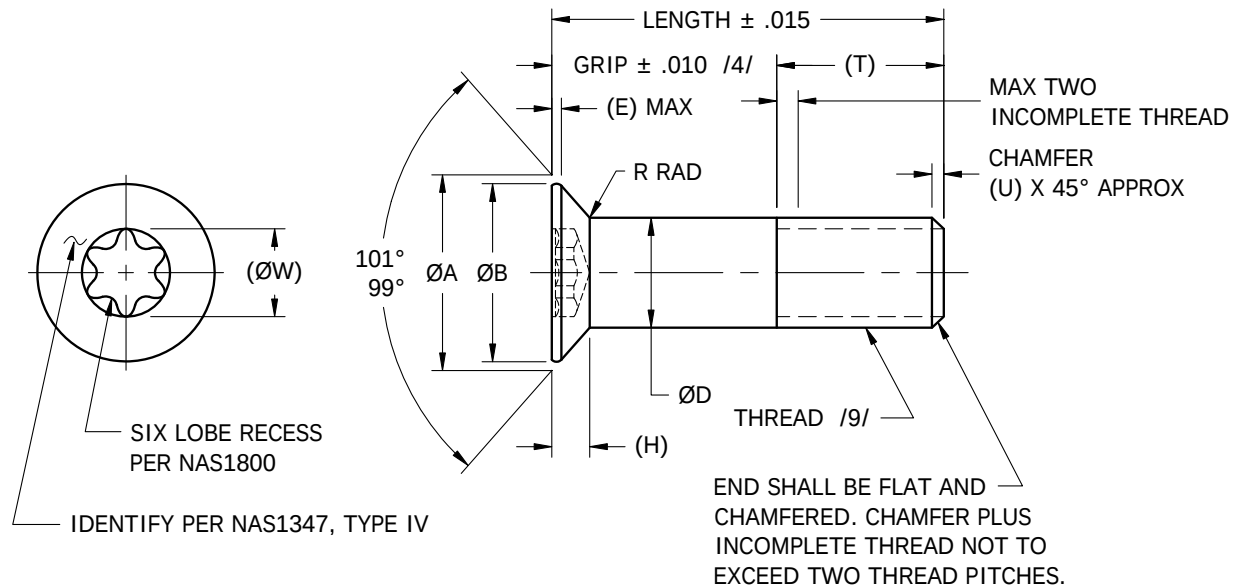


FIGURE 1 – SCREW

TABLE I – DIMENSIONS

DIA DASH NO.	THREAD /9/	RECESS SIZE	(ØA) MAX /13/ /15/	ØB MIN	ØD		(E) MAX /15/	(H) /15/	R RAD	(T)	(U)	(ØW)
					AFTER PLATING OR COATING	UNPLATED						
3	.1900-32 UNJF-3A	T20	.3047	.2578	.1895 .1885	.1895 .1890	.015	.049	.020 .010	.363	.050	.155
4	.2500-28 UNJF-3A	T20	.3988	.3504	.2495 .2485	.2495 .2490	.015	.063	.020 .010	.403	.050	.155
5	.3125-24 UNJF-3A	T30	.4787	.4289	.3120 .3110	.3120 .3115	.015	.070	.025 .010	.501	.060	.221
6	.3750-24 UNJF-3A	T30	.5662	.5149	.3745 .3735	.3745 .3740	.015	.081	.030 .015	.594	.060	.221
8	.5000-20 UNJF-3A	T50	.7611	.6901	.4995 .4985	.4995 .4990	.022	.111	.030 .015	.768	.080	.352
10	.6250-18 UNJF-3A	T55	.9329	.8518	.6240 .6230	.6240 .6235	.025	.130	.030 .015	.981	.090	.446

① COMPLETELY REVISED

FORM 09-01	THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
	PROCUREMENT SPECIFICATION		CLASSIFICATION PART STANDARD
	NOTED	TITLE SCREW, SHEAR, 100 DEG FLUSH REDUCED HEAD, CLOSE TOLERANCE, NAS1800 SIX LOBE RECESS, 95 KSI FSU	NAS5320 SHEET 1 OF 5

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 FTU. PRECIPITATION HARDENING PER AMS5853 OR AMS2759. /12/
TITANIUM – 160 KSI FTU MIN.

FINISH:

CRES – PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, TYPE 2 OR TYPE 8, CLASS 1 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 MIL-L-87132 AS87132, TYPE III, GRADE B.

CODE:

BASIC PART NUMBER = SCREW, 100 DEG REDUCED 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).

EXAMPLES OF PART NUMBERS:

NAS5320E3-10 = SCREW, .1900-32 THREAD, PASSIVATED CRES, .625 GRIP.
NAS5320V5-15 = SCREW, .3125-24 THREAD, TITANIUM ALLOY, .938 GRIP.
NAS5320V5A15 = SCREW, .3125-24 THREAD, ALUMINUM PIGMENTED COATED TITANIUM, .938 GRIP.
NAS5320E8P10 = SCREW, .5000-20 THREAD, CADMIUM PLATED CRES, .625 GRIP.

NOTES:

- (1) CONCENTRICITY: CONICAL SURFACE OF HEAD TO "ØD" WITHIN .003 FIM. "ØD" TO THREAD PITCH DIAMETER WITHIN .0045 FIM FOR DASH NO. "3" THRU "5", AND WITHIN .006 FIM FOR DASH NO "6" AND LARGER. RECESS TO "ØD" WITHIN .016 FIM THRU .2500 SIZE; WITHIN .024 FIM ABOVE .2500 SIZE.
- /2/ SHANK STRAIGHTNESS: WITHIN "Z" VALUES FIM PER INCH OF LENGTH.
- /3/ RECESS GAGING IN ACCORDANCE WITH NAS1800.

① COMPLETELY REVISED

REVISION
1
NAS5320
SHEET 2



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