

FED. SUPPLY CLASS

5306

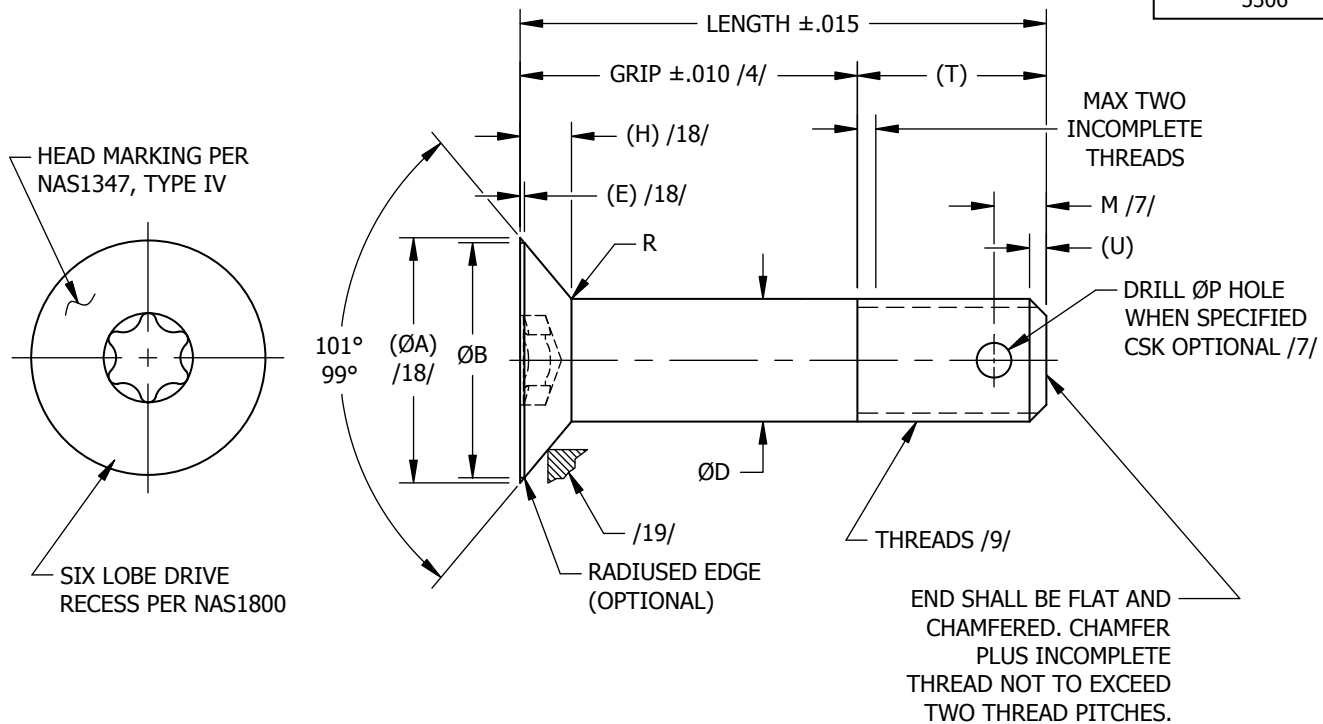


FIGURE 1 – BOLT CONFIGURATION

TABLE I – DIMENSIONS

DIA DASH NO.	THREAD UNJF-3A /9/	RECESS SIZE	(ØA) /18/	ØB MIN	ØD		E /18/	(H) /18/	M ±.010 /7/	ØP /7/	R RAD	(T)	(U)
					AFTER PLATING OR COATING	UNPLATED							
3	.1900-32	T20	.385 .377	.328	.1895 .1885	.1895 .1890	.020 .010	.080	.163	.080 .070	.030 .015	.338	.016
4	.2500-28	T30	.507 .498	.449	.2495 .2485	.2495 .2490	.020 .010	.106	.178	.086 .076	.030 .015	.425	.018
5	.3125-24	T30	.635 .625	.577	.3120 .3110	.3120 .3115	.020 .010	.133	.181	.086 .076	.030 .015	.469	.021
6	.3750-24	T40	.762 .751	.704	.3745 .3735	.3745 .3740	.020 .010	.160	.197	.116 .106	.030 .015	.578	.021
8	.5000-20	T55	1.017 1.005	.959	.4995 .4985	.4995 .4990	.020 .010	.215	.216	.116 .106	.030 .015	.735	.025
10	.6250-18	T60	1.272 1.258	1.214	.6240 .6230	.6240 .6235	.020 .010	.270	.249	.151 .141	.030 .015	.902	.028

① COMPLETELY REVISED

THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
1

PROCUREMENT
SPECIFICATION

TITLE

CLASSIFICATION
PART STANDARD

NOTED

**BOLT, SHEAR, 100 DEGREE FLUSH HEAD, CLOSE
TOLERANCE, NAS1800 SIX LOBE RECESS, 108 KSI Fsu**

NAS5321
SHEET 1 OF 5

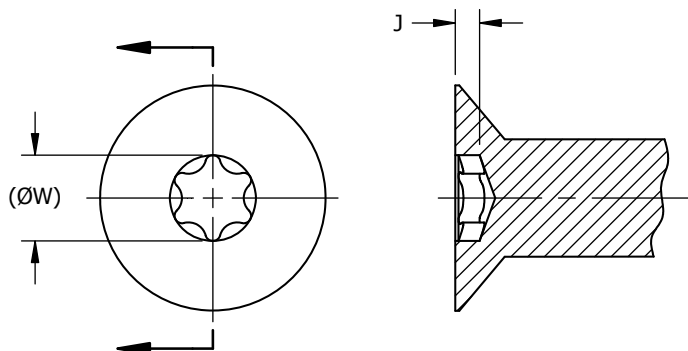


FIGURE 2 – RECESS CONFIGURATION

TABLE II – RECESS DIMENSIONS

DIA DASH NO.	TOLERANCES		MIN TENSILE STRENGTH, LBF /14/	DOUBLE SHEAR STRENGTH LBF MIN /13/	J RECESS GAGING PENETRATION		TORQUE MIN LBF-IN /5/	RAISED METAL MAX /5/	(ØW)
	Y /1/	Z /2/			MAX	MIN			
3	.005	.0040	3,600	6,100	.055	.044	75	.005	.155
4	.006	.0030	6,500	10,600	.065	.054	175	.005	.221
5	.007	.0030	10,400	16,600	.075	.064	300	.005	.221
6	.009	.0025	15,800	23,900	.080	.069	500	.006	.266
8	.010	.0020	28,700	42,400	.117	.103	1500	.008	.446
10	.010	.0020	46,000	66,300	.147	.133	3000	.010	.529

MATERIAL: CRES – A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.

HEAT TREATMENT: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 OR AMS2759.

CRES – 180 - 210 KSI Ft_u, 108 KSI F_{su} AT ROOM TEMPERATURE. PRECIPITATION HARDENING PER AMS5853 OR AMS2759.

FINISH: CRES – PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4 OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

CODE: BASIC PART NUMBER = BOLT, 100 DEGREE FLUSH HEAD, SIX LOBE RECESS.
MATERIAL CODE AFTER BASIC NUMBER:
ADD "E" FOR CRES.
DIAMETER DASH NUMBER DESIGNATES DIAMETER AND THREAD PER TABLE I.
FINISH CODE AFTER DIAMETER DASH NUMBER:
ADD "-" FOR PASSIVATION.
ADD "P" FOR CADMIUM PLATING.
GRIP DASH NUMBER DESIGNATES GRIP IN .0625 INCREMENTS PER TABLE III.
TYPE CODE AFTER GRIP DASH NUMBER:
NO CODE = UNDRILLED
ADD "D" FOR DRILLED THREAD.

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REVISION

1

NAS5321
SHEET 2



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