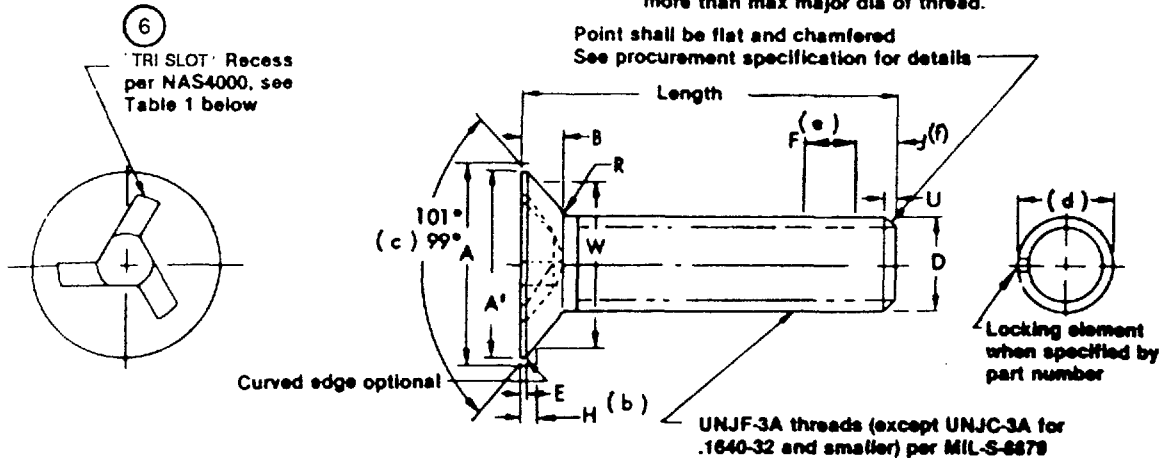




Head marking shall be depressed (.010 max) and arranged as follows:

First Sector - Mark with basic number ("NAS" optional) except mark .1120-40 size with "4", .1380-32 size with "6", .1640-32 size with "8", and (optional) .1900-32 size with "10".

Second Sector - Mark with manufacturer's symbol (symbol location optional in any sector), length dash number and "L" or "P" when applicable. "L" identifies screw with optional locking element. "P" identifies screw with patch type locking element only.

Third Sector - Mark with recess dash number encircled. Recess number should be approximately 25% larger than other numerals in head marking.

THREAD LENGTH: Screws less than 2 dies in length - complete threads shall extend to within 2 pitches of bearing surface of head and incomplete threads may extend up to bearing surface. Screws 2 dies thru 2" in length - complete threads shall extend to within 2 pitches of tangency of "R" and incomplete threads may extend up to "R" fillet area. Screws longer than 2" - complete threads shall extend 1.75 min from end of screw and incomplete threads may extend up to "R" fillet area.

INCOMPLETE THREADS: See NAS4002.
(a), (b) etc: See notes on Sheet 2

TABLE I DIMENSIONS (CONTINUED ON SHEET 2)

Basic Number ..	Nom Thread	A Dia Max (a)	A' Abso- lute Min Dia (a)	B Max (a)	D Dia Max	E Max	F ^(e)	Tri-Wing ^a Recess Number
NAS5600	.1120-40	.226	.193	.044	.112	.010	.125	NAS4000-2
NAS5601	.1380-32	.280	.246	.061	.138	.010	.156	NAS4000-3
NAS5602	.1640-32	.331	.296	.072	.164	.012	.156	NAS4000-4
NAS5603	.1900-32	.381	.338	.082	.190	.015	.156	NAS4000-5
NAS5603J	.1900-32	.381	.338	.082	.190	.015	.156	NAS4000-4J
NAS5604	.2500-28	.508	.456	.111	.250	.018	.178	NAS4000-6
NAS5605	.3125-24	.635	.575	.138	.312	.021	.208	NAS4000-7
NAS5606	.3750-24	.783	.692	.166	.375	.025	.208	NAS4000-8

**The last digit of the basic number designates the size. See Sheet 2 for "B", "L" or "P" code.

MATERIAL: Alloy steel - 4340 per MIL-S-5000 or 8740 per MIL-S-6049 or AMS6322. Locking element - plastic per MIL-F-18240 and QPL18240.

HEAT TREAT: 160 to 180 KSI ultimate tensile.

FINISH: Cadmium plate per QQ-P-416, type II, Class 2. Parts with Class 3 plating may be furnished from supplier's stock until 15 June 1975. Embrittlement requirements per NAS4002. Black screws, code "B" - cadmium plate as described above, with dull black chromate treatment.

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LIST OF CURRENT SHEETS

SHT.	REV.
1	6
2	5

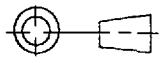
CUSTODIAN **NATIONAL AEROSPACE STANDARDS COMMITTEE**

PROCUREMENT
SPECIFICATION

NOTED ON
SHEET 2

TITLE
**SCREW, 100° HEAD, TRI-SLOT RECESS, ALLOY STEEL,
FULL THREAD, SELF-LOCKING AND NONLOCKING**

THIRD
ANGLE
PROJECTION



CLASSIFICATION
STANDARD PART

NAS5600 THRU 5606
SHEET 1 OF 2

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TABLE I DIMENSIONS (CONTINUED)

BASIC NUMBER	H GAGE PROTRUSION (b)		J ^(f)	R RAD		U	W GAGE DIA + .0002 - .0000
	NOM	± TOL		MAX	MIN	MAX	
NAS5600	.0202	.0010	.075	.012	.002	.031	.1740
NAS5601	.0232	.0011	.094	.012	.002	.039	.2208
NAS5602	.0186	.0012	.094	.020	.010	.039	.2830
NAS5603	.0210	.0013	.094	.020	.010	.039	.3270
NAS5603J	.0210	.0013	.094	.020	.010	.039	.3270
NAS5604	.0299	.0015	.107	.020	.010	.045	.4318
NAS5605	.0354	.0017	.125	.025	.010	.052	.5449
NAS5606	.0414	.0019	.125	.030	.015	.052	.6580

TABLE II PREFERRED LENGTHS

Dash Numbers	*3	*4	*5	6	7	8	9	10	11	12	13	14
Length	.19	.25	.31	.38	.44	.50	.56	.62	.69	.75	.81	.88
Length Tol	+ .00, - .03											

Dash Numbers	15	16	18	20	22	24	26	28	30	32	34 to 96
Length	.94	1.00	1.12	1.25	1.38	1.50	1.62	1.75	1.80	2.00	2.12 to 6.00
Length Tol	+ .00, - .03										

Dash 3 length is not practical for size .1900-32 and larger. Dash 4 length is not practical for size .2500-28 and larger. Dash 5 length is not practical for sizes .3125-24 and .3750-24.

Dash number indicates length in .0625 increments (rounded to two decimal places). Use of .25 inch increments is recommended for screws over 3 inches long. Intermediate or longer lengths may be specified by use of whole dash number only.

CODE. Basic part number indicates nonlocking screw, without black color.
Dash number indicates length. See Table II.
Add "B" after basic number for black screws. May be used with "L" or "P" codes.
Add "L" after basic number for self-locking screw with optional locking element (including patch type); See procurement spec below. Do not use with "P" code.
Add "P" after basic number for self-locking screw with patch type locking element only; see procurement spec below. Do not use with "L" code.
Add "J" as the fifth digit in basic four-digit part number for the deep number 4 recess.

EXAMPLES OF PART NUMBERS:

NAS5603-10 = Screw, .1900-32 thread, .62 long, nonlocking, plated.
NAS5603B10 = Screw, .1900-32 thread, .62 long, nonlocking, plated plus black color.
NAS5603L10 = Screw, .1900-32 thread, .62 long, self-locking (optional type; see procurement spec below), plated.
NAS5603P10 = Screw, .1900-32 thread, .62 long, self-locking (patch type; see procurement spec below), plated.
NAS5603JB10 = Screw, .1900-32 thread, .62 long, nonlocking, plated plus black color, 4J recess.

NOTES:

- Dimensions A, A' and B are included for engineering reference only and are not to be used for inspection. Values A, A' and B are calculated limits resulting from tolerances on W, H, E and head angle.
- Dimensions for H gage protrusion shall be inspected per NAS527.
- Concentricity: Conical surface of head to thread pitch dia within .005 FIM. (5)
- Protrusion of locking element shall be controlled so that it will pass freely, or with finger pressure, through a ring gage with diameter of .010 (+ .001, - .000) greater than max major dia of screw thread.
- "F" min (5 thread pitches) = region of minimum engagement with female thread required to meet MIL-F-18240 requirements. Locking element within "F" region must develop required torque when tested per MIL-F-18240.
- For ease in starting, locking element shall not be effective in "J" area (3 thread pitches).

SURFACE TEXTURE:

- (5) (AA max per ANSI/ASME B46.1) head to shank fillet. Thread flanks and thread root 32; conical surface of head 63; other surfaces 125.

DIMENSIONS TO BE MET AFTER PLATING.

DIMENSIONS IN INCHES.

PROCUREMENT SPECIFICATION:

NAS4002, except as noted. Cold working of head to shank fillet is not required for NAS5600 thru 5606 screws. Locking element for self-locking screws: per MS15981 and MIL-F-18240, any type of configuration including patch type is optional when "L" code is specified. Patch type locking element (with no metal removed) is required when "P" is specified. Locking element must be supplied by a qualified source listed in QPL18240 or approved for listing in QPL18240. Shipping notice should identify supplier of screw and locking element separately.

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NAS5600 THRU 5606

Documents

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