

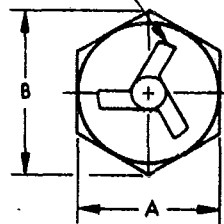
NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N.W., WASHINGTON, D. C. 20036

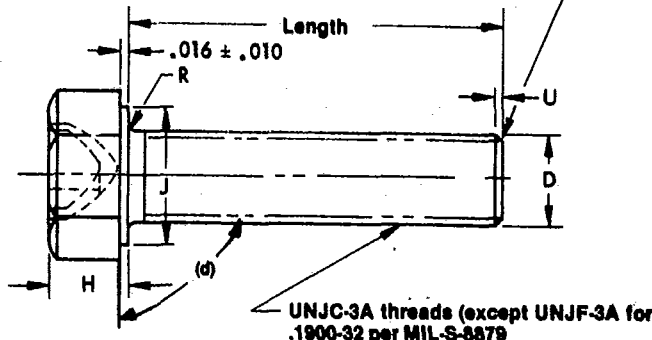
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FED. SUP CLASS

Tri-Wing® Recess
per NAS4000, see
Table 1 below



Point shall be flat and chamfered
See procurement specification for details



Diameter of unthreaded portion of shank
shall not be less than min pitch dia nor
more than max major dia of thread.

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

First Sector - Mark .1120-40 size with "4",
.1380-32 size with "8", .1640-32 size with "8" and
.1900-32 size with "10". Mark "C" for A286.(c)

Second Sector - Mark with length dash number
plus manufacturer's symbol.

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

THREAD LENGTH: Screws less than 2 dias 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 dias 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 THREAD: See NAS4003.

TABLE 1 DIMENSIONS

Basic Number ..	Nom Thread	A Hex		B Min	D Dia Max	H		J Dia Min (b)(c)	R Rad		U Max	Recess Number
		Max	Min			Max	Min		Max	Min		
NAS6000	.1120-40	.189	.181	.207	.112	.060	.049	.156	.010	.005	.031	NAS4000-2
NAS6001	.1380-32	.251	.243	.268	.138	.093	.080	.215	.010	.005	.039	NAS4000-3
NAS6002	.1640-32	.251	.243	.268	.164	.110	.086	.215	.020	.010	.039	NAS4000-4
NAS6003	.1900-32	.313	.305	.339	.190	.120	.105	.275	.020	.010	.039	NAS4000-5
NAS6003J	.1900-32	.313	.305	.339	.190	.120	.105	.275	.020	.010	.039	NAS4000-4J

**The last digit of the basic number designates the size.

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LIST OF CURRENT SHEETS

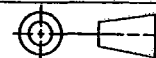
NO.	REV.
1	4
2	4

(a) & (b) etc: See notes on Sheet 2.

TRI-WING® IS A REGISTERED TRADEMARK OF THE PHILLIPS SCREW COMPANY.

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE

THIRD
ANGLE
PROJECTION



PROCUREMENT
SPECIFICATION

TITLE

SCREW, HEX HEAD, TRI-WING® RECESS,
A286 CRES, FULL THREAD,
NONLOCKING

CLASSIFICATION
STANDARD PART

NOTED ON
SHEET 2

NAS 6000 THRU 6003
SH-OF-2

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FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

APPROVAL DATE Dec. 1988 REVISION ① 18 March 1970 ② 15 Feb. 1972 ③ 17 Dec. 1979 ④ 15 August 1985

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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	1.88	2.00	2.12 to 6.00	
Length Tol	+.00, -.03		+.00, -.06								+.00, -.09	

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.

MATERIAL: A286 corrosion resistant steel with composition per AMS5731 or AMS5737.

HEAT TREAT: 160 KSI minimum ultimate tensile.

FINISH: Unplated Screws - Passivate to meet requirements of NAS4003.
Plated Screws - Cadmium plate per QQ-P-416, Type II, Class 2. Parts plated to Class 3 may be used until stock depleted. Embrittlement test per QQ-P-416 does not apply.
Coated Screws - Aluminum coating per NAS4006.
Cadmium plated A286 CRES screws shall be identified with green dye or paint on the thread end.
Maximum coverage may include the chamfer plus one incomplete thread.

CODE: Basic part number indicates plated, nonlocking screw. See Table I.
Dash number indicates length. See Table II.
Add "A" after basic number for aluminum coated screws.
Add "U" after basic number for unplated screws.
Add "J" as the fifth digit in basic four-digit part number for the deep number 4 recess.

EXAMPLE OF PART NUMBERS:

NAS6003-10 = Screw, .1900-32 thread, .62 long, cadmium plated.
NAS6003A10 = Screw, .1900-32 thread, .62 long, aluminum coated.
NAS6003U10 = Screw, .1900-32 thread, .62 long, unplated.
NAS6003JA10 = Screw, .1900-32 thread, .62 long, aluminum coated, 4J recess.

NOTES:

- Concentricity: "J" dia to thread pitch dia within .005 TIR.
- Max J dia shall not exceed actual "A" dimension.
- "A" aluminum coated and "U" unplated codes need not appear on the head of the screw.
- Bearing surface squareness: within .003 TIR of shank diameter.
- Magnetic permeability shall be less than 2.0 (Air = 1.0) for a field strength H = oersteds using a magnetic permeability indicator per MIL-I-17214 or equivalent.

SURFACE TEXTURE:

(AA max per ANSI B46.1) head to shank fillet, thread flanks and thread root 32; bearing surface of head 63; other surfaces 125.

DIMENSIONS TO BE MET AFTER PLATING OR COATING.

DIMENSIONS IN INCHES.

PROCUREMENT SPECIFICATION:

NAS4003, except as noted. Cold working of head to shank fillet is not required for NAS6000 thru 6003 screws.

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NAS Documents



SH 2
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