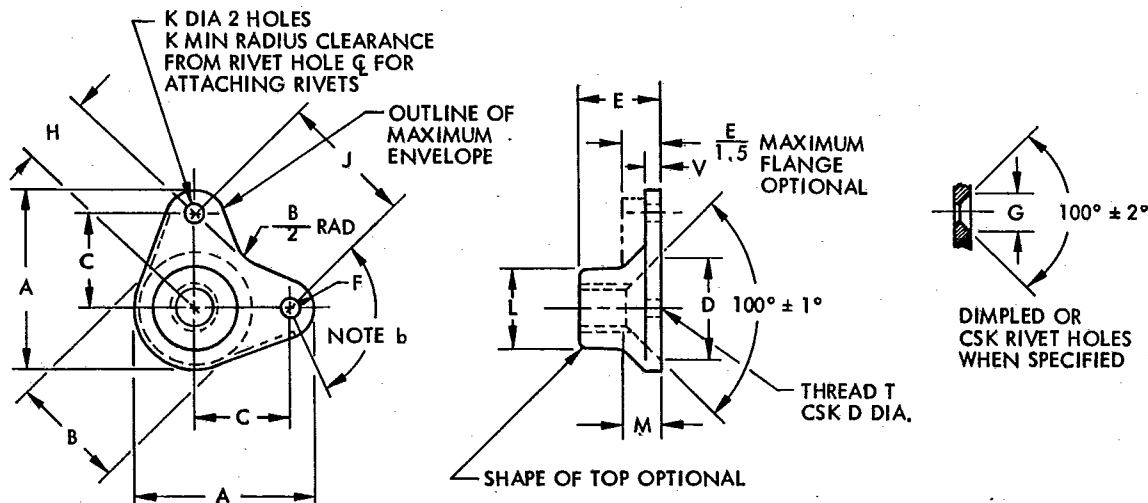


NATIONAL AEROSPACE STANDARD

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



(c) THREAD T	DASH NUMBER			A MAX	B DIA MAX	C ±.005	D DIA ±.005	E(a) MAX
	450°F STEEL	450°F CRES(d)	800°F CRES(d)					
.1640-32 UNJC-3B	A08	C08M	C08	.700	.422	.344	.365	.272
.1900-32 UNJF-3B	A3	C3M	C3	.716	.453	.344	.411	.281
.2500-28 UNJF-3B	A4	C4M	C4	.955	.619	.500	.540	.340
.3125-24 UNJF-3B	A5	C5M	C5	1.044	.766	.500	.686	.422

(c) THREAD T	F RIVET EDGE DISTANCE		G DIA ±.010	H MAX	J ±.002	(e) K DIA +.005 -.000	L DIA MAX	M REF	V MAX	WEIGHT LBS/100	
	MAX(b)	MIN								AVG (REF)	MAX
.1640-32 UNJC-3B	.145	.100	.200	.270	.486	.098	.297	.084	.047	.28	.34
.1900-32 UNJF-3B	.145	.100	.200	.270	.486	.098	.328	.093	.047	.31	.38
.2500-28 UNJF-3B	.145	.100	.200	.383	.707	.098	.414	.121	.055	.60	.78
.3125-24 UNJF-3B	.161	.125	.230	.383	.707	.130	.505	.156	.065	.93	1.06

- (a) MINIMUM "E" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENT OF SPECIFICATION.
 (b) THE CENTER OF THE TAPPED HOLE SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES, BY MORE THAN .005.
 (c) ⑪ THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.
 (d) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT.
 (e) ⑪ FOR DIMPLED RIVET TYPE ONLY, K DIAMETER TOLERANCE +.015 - .000 AFTER FORMING.

CODE: DASH NUMBER SUFFIXED BY K BACK CSK OR DIMPLED RIVET HOLES.
 INSERT "X" IN LIEU OF "A" IN THE 450°F STEEL CODE FOR CADMIUM PLATED STEEL NUTS WITHOUT LUBRICANT.

INACTIVE FOR DESIGN AFTER 15 JUNE 1971, SEE MS21057 & MS21058. FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.

LIST OF CURRENT SHEETS

NO.	REV.
1	11
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CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION

AS NOTED

TITLE

NUT, SELF-LOCKING, PLATE-CORNER,
LOW HEIGHT, CSKCLASSIFICATION
STANDARD PART

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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

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EXAMPLES OF PART NUMBERS:

NAS68544 = .2500-28 PLATE NUT, ALL METAL, PLAIN RIVET HOLES, 450°F MAXIMUM.
 NAS68544M = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION WITH BACK CSK OR DIMPLED RIVET HOLES.
 NAS68544 = .2500-28 PLATE NUT, ALL METAL, A286 CRES, 800°F MAXIMUM.
 NAS68544M = .2500-28 PLATE NUT, ALL METAL, A286 CRES, 450°F MAXIMUM, WITH APPROVED DRY FILM LUBRICANT.
 NAS685X4 = .2500-28 PLATE NUT, ALL METAL, PLAIN RIVET HOLES, 450°F MAXIMUM, WITHOUT LUBRICANT.

MATERIAL: NUT AND BARE: STEEL. SEE PROCUREMENT SPECIFICATION.
 CRES: A286 PER AMS 5550, NON-MAGNETIC.

FINISH: (I) STEEL: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 7, PLUS AN APPROVED DRY FILM LUBRICANT. EXISTING NUTS WITH AN OPTIONAL TYPE AND CLASS OF CADMIUM PLATE PER QQ-P-416, AS PREVIOUSLY PERMITTED, MAY BE FURNISHED UNTIL 16 DEC. 1976.
 (II) CRES: SILVER PLATE FOR 800°F USE PER MIL-N-25027 TO A .0002 MINIMUM THICKNESS ON SURFACES WHICH CAN BE TOUCHED BY A .7500 (3/4-INCH) BALL. THREADS SHALL SHOW COMPLETE COVERAGE, BUT THICKNESS REQUIREMENT ON THREADS IS WAIVED.
 CRES: APPROVED DRY FILM LUBRICANT FOR 450°F USE.

PROCUREMENT SPECIFICATION:

MIL-N-25027 EXCEPT AS NOTED. ALL NUTS SHALL MEET QUALIFICATION AND INSPECTION REQUIREMENTS. MANUFACTURERS SHALL PROVIDE EVIDENCE OF QUALIFICATION WHEN REQUIRED. TESTING SHALL BE PERFORMED BY MANUFACTURER OR INDEPENDENT LABORATORY. PROCURING AGENCY MAY CONDUCT CONFIRMING QUALIFICATION TESTS. NO QPL SHALL BE ESTABLISHED.

(II) NOTE: AXIAL STRENGTH REQUIREMENTS PER MIL-N-25027 TABLE I VALUES FOR REGULAR STEEL NUTS. DIMENSIONS IN INCHES.

INACTIVE FOR DESIGN AFTER 15 JUNE 1971. SEE MS21057 & MS21058.
 FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.

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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

APPROVAL DATE JULY 1956 REVISION (8) 15 APRIL 1968 (9) 31 DEC. 1968 (10) 15 JUNE 1971 (11) 15 DEC. 1974



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