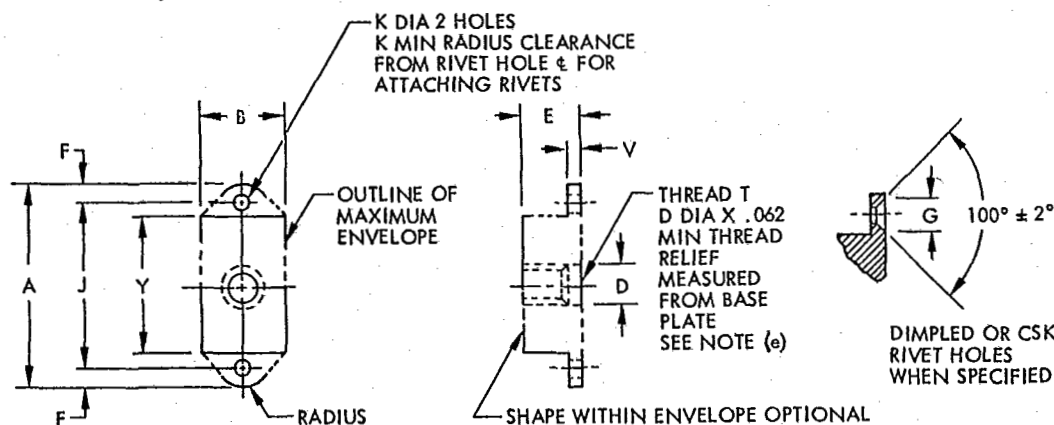


NATIONAL AEROSPACE STANDARD

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

AIA AND ITS COMMITTEES WILL NOT INVESTIGATE THE APPLICABILITY OF THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

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(c) THREAD T	DASH NUMBER			A MAX	B MAX	D DIA
	450°F STEEL	450°F CRES (f)	800°F CRES (f)			
.1120-40 UNJC-3B	A04	C04M	C04	.948	.416	.116
.1380-32 UNJC-3B	A06	C06M	C06	.948	.416	.142
.1640-32 UNJC-3B	A08	C08M	C08	.948	.416	.168
.1900-32 UNJF-3B	A3	C3M	C3	.948	.416	.194
.2500-28 UNJF-3B	A4	C4M	C4	1.292	.516	.254
.3125-24 UNJF-3B	A5	C5M	C5	1.292	.609	.317
.3750-24 UNJF-3B	A6	C6M	C6	1.292	.680	.379

(c) THREAD T	E(a) MAX	F MIN	G DIA ±.010	J(b) ±.002	(g) K DIA +.005 -.000	V MAX	Y MAX	WEIGHT LBS/100	
								AVG (REF)	MAX
.1120-40 UNJC-3B	.175	.100	.200	.688	.098	.032	.590	.31	.38
.1380-32 UNJC-3B	.203	.100	.200	.688	.098	.032	.590	.32	.39
.1640-32 UNJC-3B	.250	.100	.200	.688	.098	.032	.590	.33	.40
.1900-32 UNJF-3B	.250	.100	.200	.688	.098	.032	.590	.34	.41
.2500-28 UNJF-3B	.281	.100	.200	1.000	.098	.032	.870	.69	.90
.3125-24 UNJF-3B	.328	.125	.230	1.000	.130	.045	.870	1.02	1.26
.3750-24 UNJF-3B	.344	.125		1.000	.130	.055	.870	1.37	1.55

- (a) MINIMUM "E" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENT OF SPECIFICATION
- (b) FLOAT OF NUT PORTION OF ASSEMBLY SHALL NOT BE LESS THAN .030 NOR MORE THAN .040 INCHES Laterally AND LONGITUDINALLY FROM CENTERED POSITION. NUT BODY SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNED POSITION. MAXIMUM AXIAL FLOAT .020 INCHES.
- (c) THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.
- (d) THE ASSEMBLY SHALL PROVIDE A BEARING SURFACE FOR THE NUT WITHIN THE HOUSING.
- NOTE: THE NUT AND BASE PORTION OF THE ASSEMBLY SHALL FORM ONE INTEGRAL UNIT.
- (e) ON SIZE .1380 AND SMALLER CSK TO D DIA.
- (f) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FILED STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT.
- (g) FOR DIMPLED RIVET TYPE ONLY, "K" DIAMETER TOLERANCE +.015 - .000 AFTER FORMING.

INACTIVE FOR DESIGN AFTER 15 JUNE 1971, SEE MS21059 &
MS21060. FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.

LIST OF CURRENT SHEETS

NO.	REV.
1	13
2	12

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION
AS NOTED

TITLE
NUT, SELF-LOCKING, PLATE-TWO LUG,
LOW HEIGHT, C'BORE, FLOATING

CLASSIFICATION
STANDARD PART

NAS Documents
SHEET 1 OF 2

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AIA AND ITS COMMITTEES WILL NOT INVESTIGATE THE APPLICABILITY OF PATENTS TO THE SUBJECT MATTER OF NAS STANDARDS AND IN RESPECT THEREOF DO NOT ASSUME ANY LIABILITY TO PATENT OWNERS OR TO PROSPECTIVE USERS.

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.

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.

EXAMPLES OF PART NUMBERS:

NAS686A4 = .2500-28 PLATE NUT, ALL METAL, PLAIN RIVET HOLES, 450°F MAXIMUM.
NAS686A4K = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION WITH BACK CSK OR DIMPLED RIVET HOLES.
NAS686C4 = .2500-28 PLATE NUT, ALL METAL, A286 CRES, 800°F MAXIMUM.
NAS686C4M = .2500-28 PLATE NUT, ALL METAL, A286 CRES, 450°F MAXIMUM, WITH APPROVED DRY FILM LUBRICANT.
NAS686X4 = .2500-28 PLATE NUT, ALL METAL, PLAIN RIVET HOLES, 450°F MAXIMUM, WITHOUT LUBRICANT.

MATERIAL: NUT AND BASE: STEEL. SEE PROCUREMENT SPECIFICATION.

CRES. A286 PER AMS 5525, NON-MAGNETIC.

FINISH: ⑫ STEEL: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, 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.

⑫ 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. MANUFACTURER 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.

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 MS21059 & MS21060.
FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.