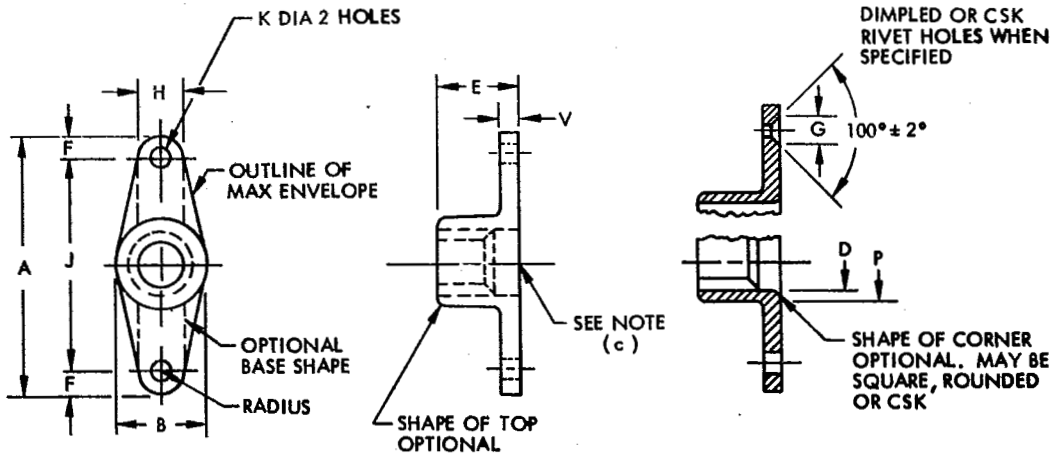




THREAD (c) T	DASH NUMBER			A MAX	B MAX	D DIA MIN	E (a) MAX
	450°F	450°F	800°F				
	STEEL	CRES (e)	CRES (e)				
.0860-56 UNJC-3B	AC2	CO2M	CO2	.410	.162	.090	.110
.0990-48 UNJC-3B	A03	CO3M	CO3	.425	.184	.103	.125
.1120-40 UNJC-3B	A04	CO4M	CO4	.456	.194	.116	.143
.1120-40 UNJC-3B	A04L	CO4LM	CO4L	.630	.260	.116	.143
.1380-32 UNJC-3B	A06	CO6M	CO6	.503	.242	.142	.171
.1380-32 UNJC-3B	A06L	CO6LM	CO6L	.661	.265	.142	.171
.1640-32 UNJC-3B	A08	CO8M	CO8	.692	.297	.168	.250
.1900-32 UNJF-3B	A3	C3M	C3	.724	.328	.194	.250
.2500-28 UNJF-3B	A4	C4M	C4	.786	.414	.254	.281
.3125-24 UNJF-3B	A5	C5M	C5	1.006	.505	.317	.328
.3750-24 UNJF-3B	A6	C6M	C6	1.116	.614	.379	.344

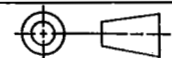
THREAD (c) T	F MIN	G DIA ±.010	H		J (b) ±.002	K (f) +.005 -.000	P MAX	V MAX
			MIN	MAX				
.0860-56 UNJC-3B	.071	(d)	.142	.162	.250	.066	.130	.035
.0990-48 UNJC-3B	.071	(d)	.142	.162	.265	.066	.143	.035
.1120-40 UNJC-3B	.071	(d)	.142	.162	.296	.066	.166	.040
.1120-40 UNJC-3B	.089	.200	.178	.260	.406	.098	.166	.040
.1380-32 UNJC-3B	.071	(d)	.142	.162	.343	.066	.206	.047
.1380-32 UNJC-3B	.089	.200	.178	.260	.437	.098	.206	.047
.1640-32 UNJC-3B	.100	.200	.200	.260	.468	.098	.248	.047
.1900-32 UNJF-3B	.100	.200	.200	.260	.500	.098	.274	.047
.2500-28 UNJF-3B	.100	.200	.200	.260	.562	.098	.344	.055
.3125-24 UNJF-3B	.125	.230	.250	.290	.718	.130	.417	.065
.3750-24 UNJF-3B	.125	.230	.250	.290	.828	.130	.505	.075

⑩ INACTIVE FOR NEW DESIGN AFTER 1 JANUARY 1989 USE MS21069 AND MS21070.
FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

LIST OF CURRENT SHEETS

NO.	REV.
1	10
2	10

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE

THIRD
ANGLE
PROJECTIONPROCUREMENT
SPECIFICATIONMIL-N-25027
EXCEPT AS NOTED

TITLE

NUT, SELF-LOCKING, PLATE-TWO LUG,
LOW HEIGHT, C'BORE, REDUCED
RIVET SPACINGCLASSIFICATION
STANDARD PART

NAS 697
Documents
Document Security Club

- (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) ON SIZE .1640 AND LARGER, COUNTERBORE THREAD D DIA X .062 DEEP MIN. THREAD RELIEF; ON SIZE .1380 AND SMALLER C'SINK TO D DIA. THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE LUBRICATION.
- (d) SPACE WILL NOT PERMIT COUNTERSINK.
- (e) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH OF H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT.
- (f) FOR DIMPLED RIVET TYPE ONLY, "K" DIAMETER TOLERANCE +.015 - .000 AFTER FORMING.

CODE: DASH NO. SUFFIXED BY K = ALL METAL CONSTRUCTION, BACK COUNTERSUNK OR DIMPLED RIVET HOLES. THE CRES DASH NUMBER SUFFIXED BY 'M' DESIGNATES AN APPROVED DRY FILM LUBRICANT FINISH. INSERT "X" IN LIEU OF "A" IN THE 450°F STEEL CODE FOR CADMIUM PLATED STEEL NUTS WITHOUT MOLYBDENUM DISULFIDE OR ANY OTHER LUBRICANT.

EXAMPLES OF PART NUMBERS:

NAS697A4 = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION, PLAIN RIVET HOLES.
 NAS697A4K = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION, BACK COUNTERSUNK OR DIMPLED RIVET HOLES.
 NAS697C4 = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION OF A286 CRES, SILVER PLATED FOR 800°F USE.
 NAS697C4M = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION OF A286 CRES, WITH AN APPROVED DRY FILM LUBRICANT FOR 450°F USE.
 NAS697X4 = .2500-28 PLATE NUT, ALL METAL CONSTRUCTION, PLAIN RIVET HOLES WITHOUT LUBRICANT.

MATERIAL: STEEL - SEE PROCUREMENT SPECIFICATION.

CRES - A286 PER AMS 5525.

FINISH: 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.

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.

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

⑩ INACTIVE FOR NEW DESIGN AFTER 1 JANUARY 1989 USE MS21069 AND MS21070. FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

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 SEPT. 1956 REVISION ⑦ 15 APRIL 1968 ⑧ 31 DEC. 1968 ⑨ 16 DEC. 1974 ⑩ 6 NOV. 1987

NAS 6 Documents

SHEET 2