

3. REQUIREMENTS

- 3.1 Material - Miniature Screws shall be made of corrosion resistant steels: classes 303, 416 and 420; brass; nickel silver. Composition, temper and hardness shall be as specified in the standard sheets and in accordance with applicable specifications listed under para. 2.1.
- 3.1.1 Physical Properties - Tensile strength and other physical properties used shall be as specified on applicable drawings and referenced specifications.
- 3.2 Coatings, when required, are limited to those of electroplating or chemical treatment.
- 3.3 Surface Texture - Machined surface finish of heads shall be 63 microinches Ra, in accordance with ASME B46.1 as determined by visual comparison with roughness comparison specimens.
- 3.4 Dimensions and Tolerances -
 - 3.4.1 Thread Form - Threads shall be in conformance with FED-STD-H28/5 and MIL-S-7742.
 - 3.4.1.1 Material Limits - Maximum material limits on the applicable standards apply to both uncoated and coated threads.
 - 3.4.2 Head proportions and dimensions shall be as specified in the applicable NAS721, 722, 723 and 724.
 - 3.4.2.1 Bearing Surface - The bearing surface of fillister, pan and binding head screws shall be at right angles to the axis of the body within 2°.
 - 3.4.2.2 Head Concentricity - Heads shall be concentric with the screw bodies within 2 percent of the maximum head diameter or .001 inch, whichever is the greater.
 - 3.4.2.3 Concentricity - The measurement of concentricity shall be one-half of the full indicator movement.
 - 3.4.2.4 Head Height - The head heights specified in the dimensional tables of the standard sheets represent the metal measurement (after slotting).
 - 3.4.2.5 Slot Locations - Slots in heads shall be centered with axis of screw body within 5% of the nominal body diameter.
 - 3.4.2.6 Unthreaded Diameter - On screws not threaded to the head, the diameter of the unthreaded body shall be not more than the maximum major diameter of the thread or less than the minimum pitch diameter of the thread.
- 3.5 Designation - Screws in conformance with this specification shall be identified by the coding delineated in the standard sheets.
- 3.6 Workmanship - Workmanship shall be first class compatible with the type of product and class of thread and finish specified. The product shall be free from all defects which might affect its serviceability. No burrs shall extend over end of screw.

4. SAMPLING, INSPECTION, AND TEST PROCEDURES

- 4.1 Compliance With ASQ Z1.4 - The requirements under the following subjects contained in ASQ Z1.4 shall be applicable to this specification: scope, purpose, inspection, inspection by attribute, sampling plans, classification of defects, method of classifying defects, critical defects, major defects, and minor defects.

REVISION

4

NAS725
SHEET 2



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America Inc. MS PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS Licensee: www.sepana.ir/5991803002, User=sam, albert
No reproduction or networking permitted without license from IHS Not for Resale, 01/04/2016 02:45:40 MST TRADEMARK RIGHTS.

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

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

FORM 12-01