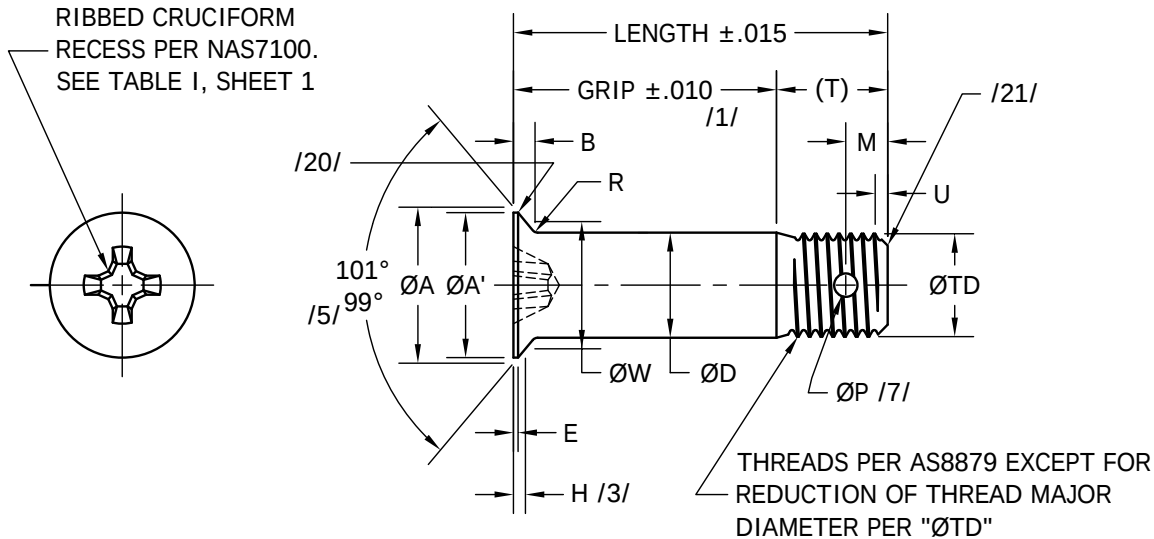




HEAD MARKING SHALL BE DEPRESSED (.010 MAX) AND ARRANGED AS FOLLOWS:

MARK WITH BASIC NUMBER ("NAS" OPTIONAL), EXCEPT MARK .1900-32 SIZE WITH "10" AND MARK .1640-32 SIZE WITH "8". THESE SIZES ALSO TO BE MARKED "V" FOR TITANIUM. MARK WITH MANUFACTURER'S SYMBOL, GRIP DASH NUMBER, "D" WHEN APPLICABLE /8/ AND RECESS NUMBER ENCIRCLED. RECESS NUMBER TO BE APPROXIMATELY 25% LARGER THAN OTHER NUMBERS. "D" IDENTIFIES BOLT WITH DRILLED SHANK.

TABLE I – DIMENSIONS (CONTINUED ON SHEET 2)

BASIC NUMBER **	NOMINAL THREAD SIZE UNJF- 3A EXCEPT AS NOTED	ØA MAX. /2/	ØA' ABSOLUTE MINIMUM /2/	B MAX. /2/	ØD				E MAX	RECESS SIZE
					UNCOATED		COATED			
					MAX	MIN	MAX	MIN		
NAS8802	.1640-32 UNJC-3A	.257	.226	.039	.1635	.1630	.1635	.1625	.010	2
NAS8803	.1900-32	.303	.266	.049	.1895	.1890	.1895	.1885	.012	2
NAS8804	.2500-28	.397	.355	.063	.2495	.2490	.2495	.2485	.014	2
NAS8805	.3125-24	.477	.429	.071	.3120	.3115	.3120	.3110	.016	3
NAS8806	.3750-24	.564	.510	.081	.3745	.3740	.3745	.3735	.018	4
NAS8807	.4375-20	.672	.612	.101	.4370	.4365	.4370	.4360	.020	4
NAS8808	.5000-20	.755	.688	.109	.4995	.4990	.4995	.4985	.022	4
NAS8809	.5625-18	.838	.766	.119	.5615	.5610	.5615	.5605	.024	4
NAS8810	.6250-18	.925	.848	.129	.6240	.6235	.6240	.6230	.026	4
NAS8812	.7500-16	1.099	1.010	.150	.7490	.7485	.7490	.7480	.030	5
NAS8814	.8750-14	1.323	1.219	.192	.8740	.8735	.8740	.8730	.034	5
NAS8816	1.0000-12	1.522	1.406	.224	.9990	.9985	.9990	.9980	.038	6

** THE LAST TWO DIGITS OF THE BASIC NUMBER DESIGNATE THE SIZE. SEE SHEET 2 FOR "A" & "D" CODES /8/, SEE SHEETS 4 AND 5 FOR GRIP DASH NUMBERS.

① COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NOTED	TITLE ① BOLT, SHEAR, 100° REDUCED HEAD, RIBBED CRUCIFORM RECESS, CLOSE TOLERANCE, 6AL-4V TITANIUM ALLOY, SHORT THREAD	CLASSIFICATION PART STANDARD
		NAS8802 THRU NAS8816 SHEET 1 OF 6

TABLE I – DIMENSIONS (CONTINUED)

BASIC NUMBER	H GAGE PROTRUSION /3/		ØW GAGE +.0002 -.0000
	NOM	TOL	
NAS8802	.0213	.0013	.2026
NAS8803	.0230	.0013	.2438
NAS8804	.0255	.0015	.3312
NAS8805	.0280	.0017	.4045
NAS8806	.0305	.0019	.4852
NAS8807	.0400	.0021	.5696
NAS8808	.0408	.0023	.6498
NAS8809	.0463	.0025	.7198
NAS8810	.0400	.0027	.8212
NAS8812	.0500	.0031	.9700
NAS8814	.0832	.0035	1.1122
NAS8816	.0918	.0039	1.2894

TABLE I – DIMENSIONS (CONTINUED)

BASIC NUMBER	M ±.010 /7/ /10/	ØP +.005 -.000 /7/ /10/	R RADIUS		(T) /4/	ØTD		U MAX.	Y /5/	Z /6/
			MAX.	MIN.		MAX.	MIN.			
NAS8802	-	-	.020	.010	.323	.1595	.157	.039	.0045	.0040
NAS8803	.164	.070	.020	.010	.323	.184	.181	.039	.0045	.0040
NAS8804	.170	.076	.020	.010	.370	.244	.241	.045	.0045	.0030
NAS8805	.182	.076	.025	.010	.438	.306	.302	.052	.0045	.0030
NAS8806	.183	.106	.030	.015	.454	.368	.364	.052	.0045	.0025
NAS8807	.199	.106	.030	.015	.528	.431	.426	.062	.006	.0025
NAS8808	.198	.106	.030	.015	.528	.493	.488	.062	.006	.0020
NAS8809	.207	.141	.030	.015	.594	.555	.550	.068	.006	.0020
NAS8810	.207	.141	.030	.015	.626	.618	.612	.068	.006	.0020
NAS8812	.222	.141	.030	.015	.666	.743	.737	.078	.006	.0020
NAS8814	.241	.141	.030	.015	.759	.868	.861	.089	.009	.0020
NAS8816	.264	.141	.030	.015	.895	.993	.986	.104	.009	.0020

TABLE II – RECESS PERFORMANCE

BASIC NUMBER	MINIMUM TORQUE /9/	
	TORQUE INCH POUNDS	RECESS NUMBER
NAS8802	-	2
NAS8803	35	2
NAS8804	50	2
NAS8805	125	3
NAS8806	-	4
NAS8807	-	4
NAS8808	-	4
NAS8809	-	4
NAS8810	-	4
NAS8812	-	5
NAS8814	-	5
NAS8816	-	6

MATERIAL: TITANIUM ALLOY – 6AI-4V (UNS R56400) PER AMS4928 OR AMS4967.

HEAT TREAT: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-81200 OR AMS2801.
TITANIUM (6AI-4V): 160 KSI FTU MIN.; 95 KSI FSU MIN.

FINISH: UNCOATED BOLTS - NONE.
COATED BOLTS - ALUMINUM COATING PER NAS4006.

① COMPLETELY REVISED

REVISION
1
NAS8802 THRU NAS8816
SHEET 2



Documents

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