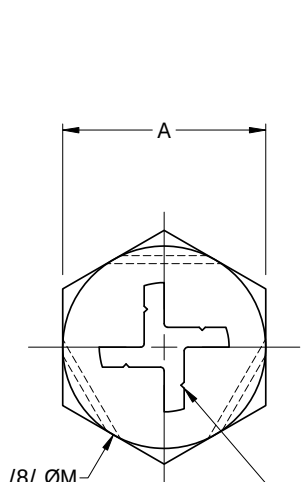
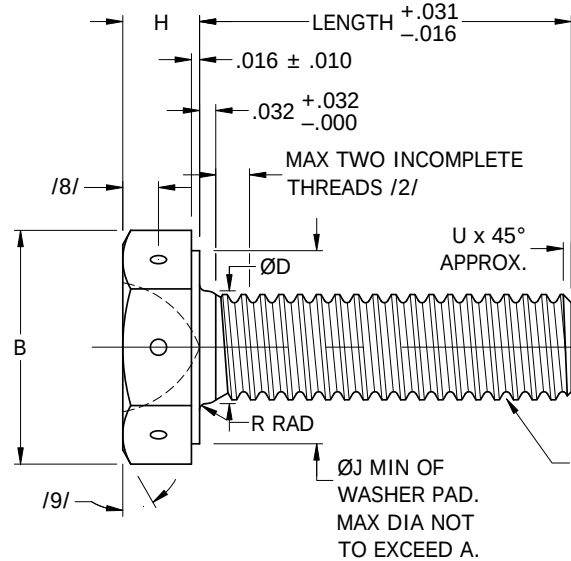


FED. SUPPLY CLASS

5306



OFFSET CRUCIFORM-RIBBED
RECESS PER NASM14191 /5/ /6/



POINT SHALL BE FLAT
AND CHAMFERED.
CHAMFER PLUS
INCOMPLETE THREADS
NOT TO EXCEED
TWO PITCHES.

THREADS PER AS8879
(ROLLED AFTER HEAT TREAT)

TABLE I – DIMENSIONS

BASIC NUMBER /13/	THREAD SIZE	A HEX	B MIN	ØD	H	ØJ /1/	ØM ±.005	R RAD	U MAX	RECESS PERFORMANCE /10/	RECESS SIZE
NAS9101	.1380-32 UNJC-3A	.251 .243	.277	.138 .115	.093 .080	.210	–	.015 .005	.039	17	6
NAS9102	.1640-32 UNJC-3A	.251 .243	.277	.164 .141	.110 .096	.210	–	.015 .005	.039	35	8
NAS9103	.1900-32 UNJF-3A	.314 .305	.348	.190 .167	.120 .105	.272	.051	.020 .010	.039	50	10
NAS9104	.2500-28 UNJF-3A	.376 .367	.410	.250 .224	.140 .125	.335	.051	.020 .010	.045	125	1/4
NAS9105	.3125-24 UNJF-3A	.439 .429	.480	.312 .282	.171 .156	.398	.075	.020 .010	.052	250	5/16
NAS9106	.3750-24 UNJF-3A	.502 .492	.552	.375 .345	.203 .188	.460	.075	.025 .015	.052	450	3/8

② COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NAS4003	TITLE SCREW, HEX HEAD, OFFSET CRUCIFORM-RIBBED RECESS, FULL THREAD, A286 CRES, 160,000 PSI TENSILE	CLASSIFICATION PART STANDARD
		NAS9101 THRU NAS9106 SHEET 1 OF 3

MATERIAL:

CRES - A286 (UNS S66286) PER AMS5731 OR AMS5732.

HEAT TREAT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759.

CRES: 160-190 KSI Ft_u

FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

CODE:

NO LETTER AFTER DASH NUMBER INDICATES UNDRILLED HEAD.
LETTER "H" AFTER DASH NUMBER INDICATES DRILLED HEAD. /8/
DASH NUMBER INDICATES LENGTH IN .0625 INCH INCREMENTS.

EXAMPLE OF PART NUMBER:

NAS9104-16 = .2500-28 UNJF-3A SCREW, ONE INCH LONG.
NAS9104-16H = .2500-28 UNJF-3A SCREW, ONE INCH LONG WITH DRILLED HEAD.

NOTES:

- /1/ CONCENTRICITY: "ØJ" TO THREAD PITCH DIAMETER WITHIN .005 FIM.
- /2/ COMPLETE THREAD LENGTH FOR SCREWS LONGER THAN 2 INCHES SHALL BE 1.75 INCHES MINIMUM.
INCOMPLETE THREADS PER NAS4003.
- (3) SURFACE ROUGHNESS: HEAD TO SHANK FILLET, THREAD FLANKS AND THREAD ROOT:
32 MICROINCHES Ra; BEARING SURFACE OF HEAD: 63 MICROINCHES Ra; ALL OTHER SURFACES:
125 MICROINCHES Ra PER ASME B46.1.
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /5/ GAGING OF THE OFFSET CRUCIFORM-RIBBED RECESS SHALL BE IN ACCORDANCE WITH NASM14191
TABLE III.
- /6/ ORIENTATION OF RECESS SLOTS TO HEX IS OPTIONAL.
- (7) SCREWS SHALL BE FREE FROM BURRS AND SLIVERS.
- /8/ DRILL "ØM" (3) HOLES WITHIN .010 OF CENTER OF HEX FLAT WHEN SPECIFIED BY PART
NUMBER .1900-32 THRU .3750-24 SIZES ONLY.
- /9/ HEAD CHAMFER ANGLE OPTIONAL, NOT TO EXCEED 30° MAXIMUM.
- /10/ MINIMUM TORQUE VALUES (INCH POUNDS) WHICH RECESS MUST DEVELOP DURING INSTALLATION
AND REMOVAL MODE WITH APPROPRIATE DRIVER PER NASM14191 USING 5 POUNDS END LOAD.
CAMOUT OF DRIVER OR EXCESSIVE DEFORMATION OF THE RECESS SHALL BE CAUSE FOR REJECTION
OF THE LOT.

REVISION

2

NAS9101 THRU
NAS9106
SHEET 2

② COMPLETELY REVISED



Documents

Document Sharing Hub