



NATIONAL AEROSPACE STANDARD

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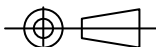
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ISSUE DATE: MARCH 1958 REVISION DATE: JUNE 29, 2012

THIRD ANGLE PROJECTION		CUSTODIAN ENGINEERING MANAGEMENT COMMITTEE	REVISION 3
PROCUREMENT SPECIFICATION NONE	TITLE DRILLS -THREADED HEXAGONAL SHANK SIZES #40 THRU LETTER 'F'	CLASSIFICATION PART STANDARD NAS932 SHEET 1 OF 2	

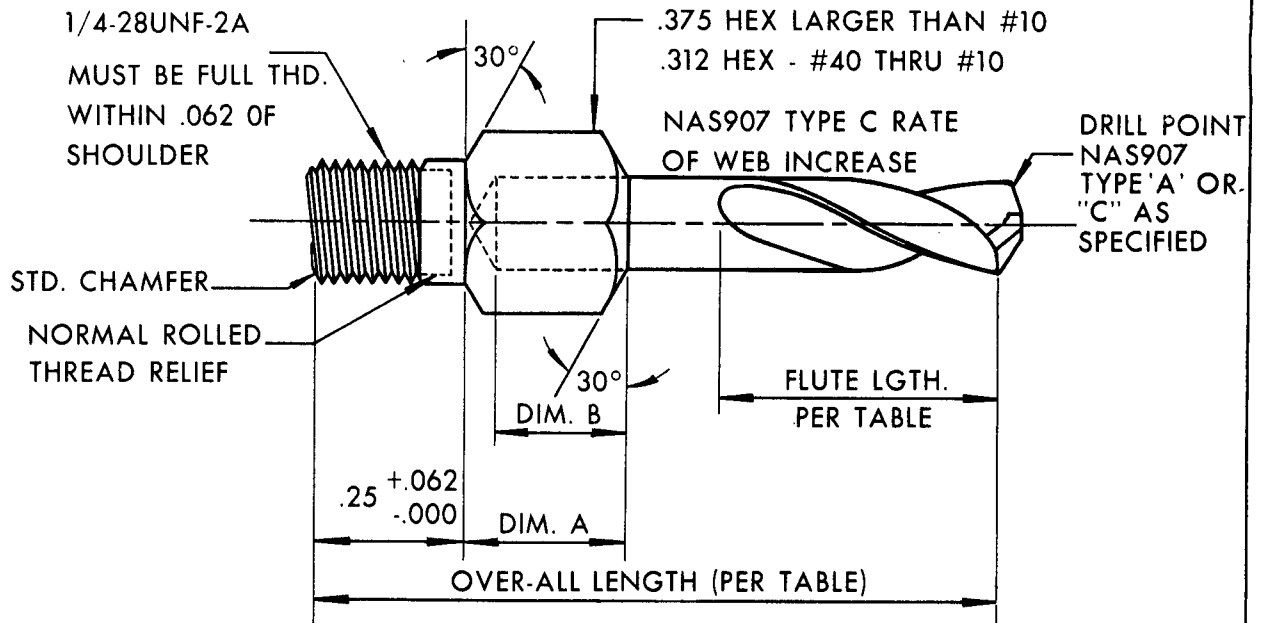
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	DRILL SIZE	FLUTE LENGTH	OVER-ALL LENGTH	② DIM. A	② DIM. B
SHORT SERIES	#40 THRU 1/8	.562 $\pm$.125 -.062	1.250 $\pm$.125 -.062	.312 $\pm$.031 -.000	.250 $\pm$.000 -.010
	#30 THRU #10	.562 $\pm$.125 -.062	1.250 $\pm$.125	.312 $\pm$.031 -.000	.250 $\pm$.000 -.010
	#9 THRU LTR. "F"	.562 $\pm$.125 -.062	1.312 $\pm$.125	.375 $\pm$.031 -.000	.290 $\pm$.000 -.010
LONG SERIES	#40 THRU 1/8	.875 $\pm$.125 -.062	2.125 $\pm$.125 -.062	.312 $\pm$.031 -.000	.250 $\pm$.000 -.010
	#30 THRU 11/64	1.000 $\pm$.125	2.125 $\pm$.125	.312 $\pm$.031 -.000	.250 $\pm$.000 -.010
	#17 THRU #10	1.125 $\pm$.125	2.125 $\pm$.125	.312 $\pm$.031 -.000	.250 $\pm$.000 -.010
	#9 THRU LTR. "F"	1.125 $\pm$.125	2.187 $\pm$.125	.375 $\pm$.031 -.000	.290 $\pm$.000 -.010

- NOTES:
1. HARDNESS OF THREADED BODY - ROCKWELL C-35 MAX., ROCKWELL C-25 MIN.
 2. DRILL SIZE AND MANUFACTURER'S TRADEMARK TO BE MARKED ON FACES OF HEX.
 3. EXAMPLE OF CODING: (A) NAS932-SS TYPE A POINT - THREADED HEX SHANK
DRILL - SHORT SERIES
NAS 907 TYPE A POINT
(B) NAS932-LS TYPE C POINT - THREADED HEX SHANK
DRILL - LONG SERIES
NAS907 TYPE C POINT.
 4. GENERAL: WITH THE EXCEPTION OF LENGTH DIMENSIONS AND OPTION OF DRILL POINT TYPES, THE DRILL SPECIFICATIONS ARE TO BE PER NAS907 TYPE C.
 5. DRILL MUST BE CONCENTRIC WITH THREADED BODY WITHIN .005 T.I.R.

CUSTODIAN: Aerospace Manufacturing Engineering Committee ②

PROCUREMENT SPECIFICATION

②

**DRILLS - THREADED HEXAGONAL SHANK
SIZES #40 THRU LETTER 'F'**

CLASSIFICATION
SECRET

NAS 932