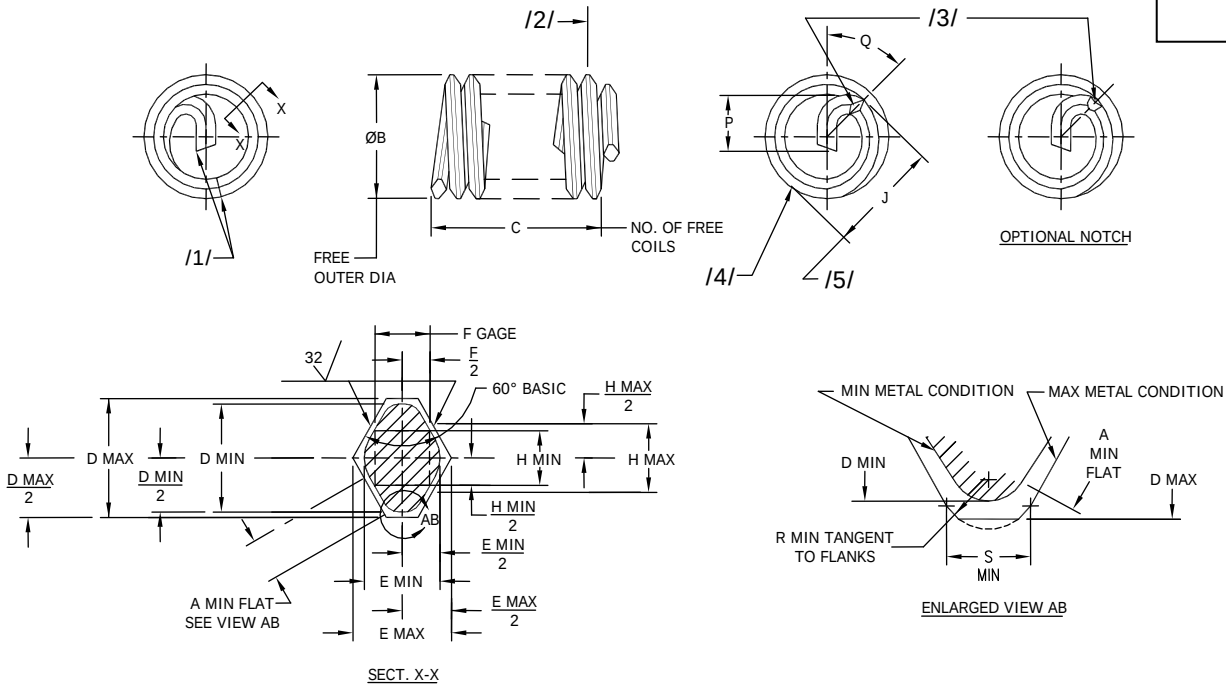


FED. SUPPLY CLASS

5325



②

TABLE I - DIMENSIONS

THREAD SIZE	NOMINAL LENGTH /6/	A MIN	ØB		C ±.250 COIL /8/	D		E		F GAGE	H	
			MIN	MAX		MIN	MAX	MIN	MAX		MIN	MAX
.0860-56	.086	.0027	.110	.119	3.000	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.0990-48	.099	.0043	.128	.139	2.875	.0196	.0226	.0152	.0182	.01042	.01313	.01353
.1120-40	.112	.0068	.144	.159	2.750	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.1250-40	.125	.0068	.158	.173	3.250	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.1380-32	.138	.0076	.178	.193	2.750	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.1640-32	.164	.0076	.205	.220	3.500	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.1900-24	.190	.0120	.244	.259	2.875	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.2500-20	.250	.0164	.310	.330	3.375	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.3125-18	.312	.0176	.380	.400	4.000	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.3750-16	.375	.0215	.452	.472	4.375	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.4375-14	.438	.0267	.526	.551	4.500	.0730	.0770	.0545	.0625	.03571	.04589	.04639
.5000-13	.500	.0273	.597	.622	4.875	.0758	.0829	.0593	.0673	.03846	.04946	.04996
.5625-12	.562	.0334	.669	.694	5.125	.0861	.0900	.0649	.0729	.04167	.05363	.05413
.6250-11	.625	.0351	.742	.767	5.250	.0909	.0980	.0715	.0795	.04545	.05855	.05905
.7500-10	.750	.0402	.881	.906	5.875	.1007	.1079	.0795	.0875	.05000	.06445	.06495
.8750-9	.875	.0466	1.022	1.052	6.250	.1124	.1199	.0892	.0972	.05556	.07167	.07217
1.0000-8	1.000	.0544	1.166	1.196	6.375	.1264	.1350	.1004	.1094	.06250	.08069	.08119
1.1250-7	1.125	.0645	1.315	1.355	6.125	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.2500-7	1.250	.0645	1.443	1.483	7.000	.1451	.1546	.1160	.1250	.07143	.09229	.09279
1.3750-6	1.375	.0775	1.598	1.643	6.500	.1695	.1799	.1368	.1458	.08333	.10775	.10825
1.5000-6	1.500	.0775	1.727	1.772	7.250	.1695	.1799	.1368	.1458	.08333	.10775	.10825

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS122076 THRU 122115, REVISION D. PART NUMBERS REMAIN MS122076 THRU 122115.



THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
2

PROCUREMENT
SPECIFICATION
NASM8846

TITLE
**INSERT, CRES, HELICAL COIL, COARSE THREAD,
1 DIA NOMINAL LENGTH**

②

CLASSIFICATION
PART STANDARD

**NASM122076 THRU
NASM122115**



SHEET 1 OF 3
Document Sharing Hub

②

TABLE I – DIMENSIONS (CONTINUED)

THREAD SIZE	J		P		Q	R MIN	S MIN	APPROX. WEIGHT LB/100	PART NUMBERS	
	MIN	MAX	MIN	MAX					NOTCHED	UNNOTCHED /15/
.0860-56	.103	.111	.062	.080	75° - 150°	.0032	.0056	.0051	MS122095	
.0990-48	.120	.131	.070	.090	75° - 150°	.0038	.0065	.0077	MS122115	
.1120-40			.070	.095	25° - 100°	.0045	.0078	.0121	MS122076	~~MS122096~~
.1250-40			.078	.108	25° - 100°	.0045	.0078	.0154	MS122077	~~MS122097~~
.1380-32			.091	.121	25° - 100°	.0056	.0098	.0243	MS122078	~~MS122098~~
.1640-32			.118	.153	20° - 100°	.0056	.0098	.0355	MS122079	~~MS122099~~
.1900-24			.141	.176	15° - 90°	.0075	.0130	.0573	MS122080	~~MS122100~~
.2500-20			.182	.233	20° - 80°	.0090	.0156	.145	MS122081	~~MS122101~~
.3125-18	.375	.390	.214	.286	20° - 80°	.0100	.0174	.232	MS122082	~~MS122102~~
.3750-16	.445	.462	.269	.348	20° - 80°	.0113	.0195	.391	MS122083	~~MS122103~~
.4375-14	.518	.536	.313	.411	20° - 80°	.0129	.0223	.667	MS122084	~~MS122104~~
.5000-13	.586	.606	.348	.458	20° - 80°	.0139	.0240	.794	MS122085	~~MS122105~~
.5625-12	.656	.676	.390	.520	20° - 80°	.0150	.0260	1.235	MS122086	~~MS122106~~
.6250-11	.727	.747	.421	.567	20° - 80°	.0164	.0284	1.515	MS122087	~~MS122107~~
.7500-10	.840	.885	.453	.640	60° - 120°	.0180	.0312	2.778	MS122088	~~MS122108~~
.8750-9	.991	1.026	.500	.734	60° - 120°	.0200	.0347	4.545	MS122089	~~MS122109~~
1.0000-8	1.135	1.170	.526	.781	60° - 120°	.0226	.0391	5.882	MS122090	~~MS122110~~
1.1250-7	1.260	1.315	.557	.843	60° - 120°	.0258	.0446	8.392	MS122091	~~MS122111~~
1.2500-7	1.366	1.416	.679	.937	60° - 120°	.0258	.0446	10.487	MS122092	~~MS122112~~
1.3750-6	1.545	1.598	.689	1.093	60° - 120°	.0301	.0521	14.505	MS122093	~~MS122113~~
1.5000-6	1.676	1.727	.811	1.187	60° - 120°	.0301	.0521	17.563	MS122094	~~MS122114~~

MATERIAL: STEEL, CORROSION RESISTANT, ~~AMS7245~~ AS7245 (MATERIAL AND MFG.).

NOTES:

- /1/ ENDS OF COIL MAY BE SQUARE OR ANGULAR.
- /2/ CENTERLINE OF WIRE SECTION TO BE SQUARE WITH COIL AXIS WITHIN 5°.
- /3/ NOTCH TO BE ON TOP FACE OR EDGE OF FIRST COIL.
- /4/ FIRST COIL DIAMETER TO MEET FREE DIAMETER 210° FROM TANG WITHIN 20°.
- /5/ TO BE MEASURED 30° FROM TANG.
- /6/ NOMINAL LENGTH EQUALS BASIC THICKNESS OF PLATE FOR INSERT ASSEMBLY.
- (7) ASSEMBLED LENGTH OF INSERT TO BE AS SPECIFIED ON NASM33537.
- /8/ NUMBER OF FREE COILS TO BE COUNTED AND ASSEMBLED LENGTH OF INSERT TO BE MEASURED 90° FROM TANG.
- (9) SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH ASME B46.1 AND SURFACE TEXTURE SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36M.
- (10) INSERT, WHEN ASSEMBLED IN TAPPED HOLE AS SPECIFIED IN NASM33537, SHALL PRODUCE A FINISHED THREAD MEETING ALL REQUIREMENTS OF MIL-S-7742 AND SHALL ACCEPT EXTERNAL AS8879 THREADS.
- (11) DIMENSIONS IN INCHES.

REVISION

2

NASM122076 THRU
NASM122115

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. This document is the property of AIA and is loaned to you under license. 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 02:48:37 MST. TRADEMARKS RIGHTS.

Full document details: AIA NASM122076-122115 2014