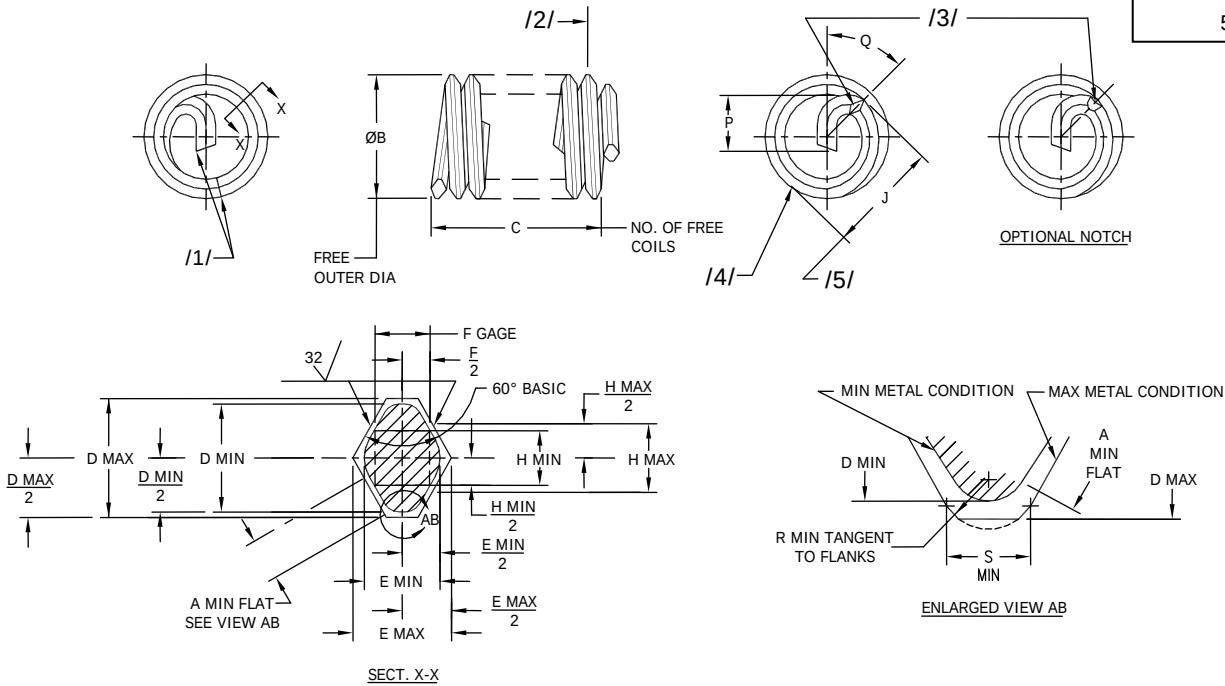


FED. SUPPLY CLASS

5325



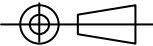
2

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
.0990-56	.148	.0027	.131	.146	5.625	.0163	.0193	.0126	.0156	.00893	.0112	.0116
.1120-48	.168	.0043	.147	.162	5.625	.0190	.0226	.0152	.0182	.01042	.01313	.01353
.1380-40	.207	.0068	.173	.193	6.000	.0241	.0271	.0189	.0219	.01250	.01584	.01624
.1640-36	.246	.0059	.204	.224	6.500	.0261	.0301	.0203	.0243	.01389	.01764	.01804
.1900-32	.285	.0076	.236	.256	6.875	.0295	.0338	.0233	.0273	.01563	.01985	.02030
.2500-28	.375	.0085	.306	.326	8.250	.0347	.0387	.0253	.0313	.01786	.02270	.02320
.3125-24	.469	.0120	.380	.400	8.875	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.3750-24	.562	.0120	.448	.468	11.000	.0410	.0449	.0305	.0365	.02083	.02656	.02706
.4375-20	.656	.0164	.524	.549	10.625	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.5000-20	.750	.0164	.592	.617	12.375	.0500	.0540	.0378	.0438	.02500	.03198	.03248
.5625-18	.844	.0176	.666	.691	12.500	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.6250-18	.938	.0176	.733	.758	14.125	.0560	.0600	.0416	.0486	.02778	.03558	.03608
.7500-16	1.125	.0215	.876	.901	15.125	.0636	.0677	.0477	.0547	.03125	.04009	.04059
.8750-14	1.312	.0267	1.021	1.051	15.500	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.0000-12	1.500	.0334	1.169	1.199	15.000	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.0000-14 /9/	1.500	.0267	1.156	1.186	17.875	.0730	.0770	.0545	.0625	.03571	.04589	.04639
1.1250-12	1.688	.0334	1.304	1.334	17.250	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.2500-12	1.875	.0334	1.439	1.469	19.375	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.3750-12	2.062	.0334	1.575	1.610	21.375	.0861	.0900	.0649	.0729	.04167	.05363	.05413
1.5000-12	2.250	.0334	1.710	1.745	23.500	.0861	.0900	.0649	.0729	.04167	.05363	.05413

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS124691 THRU 124730, REVISION E. PART NUMBERS REMAIN MS124691 THRU 124730.

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

2

PROCUREMENT
SPECIFICATION

NASM8846

TITLE

**INSERT, CRES, HELICAL COIL, FINE THREAD
1-1/2 DIA NOMINAL LENGTH**

CLASSIFICATION
PART STANDARD

**NASM124691 THRU
NASM124730**

SHEET 1 OF 3

(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/
.0990-56	.124	.146	.072	.090	75°-150°	.0032	.0056	.0084	MS124710	
.1120-48	.134	.150	.060	.095	75°-150°	.0038	.0065	.0160	MS124711	
.1380-40	N/A	N/A	.100	.130	25°-100°	.0045	.0078	.0304	MS124693	MS124713
.1640-36	N/A	N/A	.117	.147	20°-100°	.0050	.0087	.0502	MS124694	MS124714
.1900-32	N/A	N/A	.130	.176	15°-90°	.0056	.0098	.0784	MS124695	MS124715
.2500-28	N/A	N/A	.173	.239	15°-70°	.0064	.0112	.155	MS124696	MS124716
.3125-24	.359	.377	.203	.291	15°-55°	.0075	.0130	.284	MS124697	MS124717
.3750-24	.422	.439	.235	.353	15°-75°	.0075	.0130	.420	MS124698	MS124718
.4375-20	.494	.514	.281	.416	15°-75°	.0090	.0156	.699	MS124699	MS124719
.5000-20	.556	.576	.313	.478	15°-75°	.0090	.0156	.909	MS124700	MS124720
.5625-18	.625	.645	.344	.541	15°-75°	.0100	.0174	1.266	MS124701	MS124721
.6250-18	.688	.708	.375	.588	15°-75°	.0100	.0174	1.562	MS124702	MS124722
.7500-16	.820	.840	.453	.562	15°-75°	.0113	.0195	2.564	MS124703	MS124723
.8750-14	.955	.980	.500	.640	15°-75°	.0129	.0223	4.000	MS124704	MS124724
1.0000-12	1.094	1.119	.526	.728	15°-75°	.0150	.0260	6.063	MS124691	
1.0000-14 /9/	1.080	1.105	.526	.750	15°-75°	.0129	.0223	5.263	MS124705	MS124725
1.1250-12	1.219	1.244	.557	.819	10°-70°	.0150	.0260	7.572	MS124706	MS124726
1.2500-12	1.344	1.369	.679	.941	10°-70°	.0150	.0260	9.502	MS124707	MS124727
1.3750-12	1.469	1.499	.689	1.001	10°-70°	.0150	.0260	11.276	MS124708	MS124728
1.5000-12	1.594	1.624	.811	1.123	10°-70°	.0150	.0260	13.650	MS124709	MS124729

MATERIAL: STEEL, CORROSION RESISTANT PER AS7245 AMS7245 (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/ MS124705 INACTIVE FOR DESIGN AFTER 15 OCT 1969. NO SUPERSEDING STANDARD.
- (10) SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH ASME B46.1 AND SURFACE TEXTURE SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36M.
- (11) 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.

REVISION

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NASM124691 THRU
NASM124730

SHEET 2



Documents

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