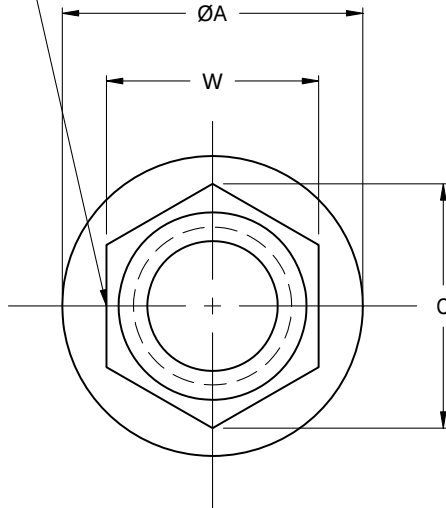


FED. SUPPLY CLASS

5310

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

DESIGN OF WRENCHING PAD FACES BETWEEN WRENCHING CORNERS IS OPTIONAL IF THE WRENCHING CORNERS ARE WITHIN THE LIMITS OF E, W, AND C, AND THE LIMIT OF THE AREA BETWEEN THE CORNERS IS WITHIN THE MAXIMUM LIMIT OF W FOR THE "E" LENGTH OF WRENCHING CORNERS



CONCAVED OR CONICAL SURFACE BETWEEN TOP OF RING BASE WRENCHING CORNERS, AND AREA BETWEEN CORNERS.

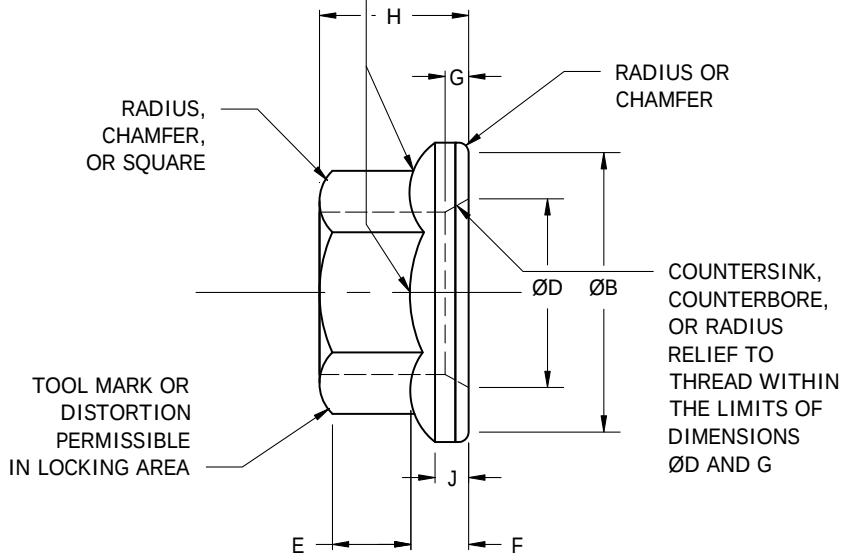


TABLE I – DIMENSIONS

SIZE DASH NO	THREAD /4/	ØA MAX	ØB MIN	C MIN	ØD		E MIN /7/	F MIN /4/	G		H		J MIN	W /6/		X /5/	WRENCHING TORQUE IN LBF /9/	AXIAL STRENGTH LBF MIN /10/	WT LBS/100 MAX
					MAX	MIN			MAX	MIN	MAX	MIN		MAX	MIN				
04	.1120-40 UNJC-3B	.206	.176	.171	.142	.112	.050	.028	.027	.005	.125	.103	.010	.158	.150	.003	11	755	.050
06	.1380-32 UNJC-3B	.244	.214	.207	.168	.138	.055	.039			.141	.115		.190	.181		17	1,136	.080
08	.1640-32 UNJC-3B	.290	.260	.244	.194	.164	.060	.041	.031	.006	.125	.103	.015	.221	.213		23	1,720	.150
3	.1900-32 UNJF-3B	.330	.290	.277	.220	.190	.065	.043			.154	.125		.252	.243		46	2,460	.180
4	.2500-28 UNJF-3B	.420	.386	.347	.280	.250	.090	.057	.036	.007	.219	.204	.019	.316	.304		115	4,580	.350
5	.3125-24 UNJF-3B	.520	.482	.419	.342	.312	.120	.077			.266	.251	.023	.378	.367	.004	260	7,390	.600
6	.3750-24 UNJF-3B	.620	.575	.491	.405	.375	.125	.089	.042	.008	.282	.267	.030	.440	.430		450	11,450	.800

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS14222. PART NUMBERS REMAIN MS14222.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NASM25027	TITLE NUT, SELF-LOCKING, 450 °F, HEXAGON, REDUCED HEAD HEIGHT, RING BASE, CRES	CLASSIFICATION PART STANDARD NASM14222

SHEET 1 OF 3

Document Sharing Hub

MATERIAL:

CRES: A286 (UNS S66286) PER AMS5525 OR AMS5732.

FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4, FOLLOWED BY CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

LUBRICATION:

DRY FILM LUBRICANT PER ~~MIL-L-8937~~ AS5272.

EXAMPLE OF PART NUMBER:

MS14222-4 = NUT, SELF-LOCKING, .2500-28 UNJF-3B THREAD
 └───┬─── SIZE DASH NUMBER
 └───┬─── BASIC PART NUMBER

NOTES:

- (1) REMOVE ALL BURRS AND SHARP EDGES.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (3) DESIGN AND LIMITATIONS SHALL BE IN ACCORDANCE WITH NASM33588.
- /4/ THREADS PER AS8879.
- /5/ BEARING SURFACE SHALL BE SQUARE WITH PITCH DIAMETER WITHIN "X" WHEN MEASURED IN ACCORDANCE WITH NASM25027.
- /6/ DIMENSIONS ACROSS FLATS INCLUDE DEFORMATION OF SELF-LOCKING ELEMENT.
- /7/ MINIMUM LENGTH OF EACH WRENCHING CORNER.
- (8) MINIMUM DISTANCE FROM THE WASHER FACE OF THE NUT TO THE BEGINNING OF THE MINIMUM LENGTH OF "E" OF EACH WRENCHING CORNER.
- /9/ NUTS SHALL BE TESTED FOR WRENCHING TORQUE BY USING A BOX OR SOCKET WRENCH.
- /10/ TEST BOLTS SHALL BE 180 KSI MINIMUM.
- (11) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, TEST METHOD 3.
- (12) SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICROINCHES Ra PER ASME B46.1.

① COMPLETELY REVISED

REVISION
1