

FED. SUPPLY CLASS

5310

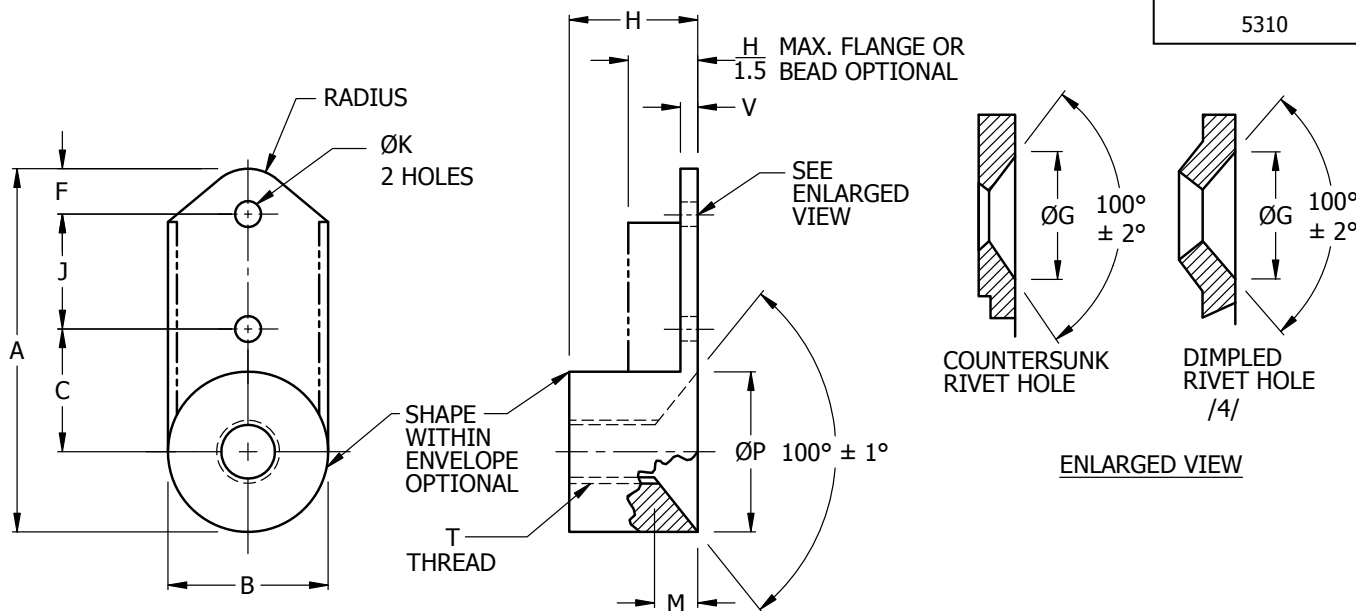


TABLE I – DIMENSIONS

T THREAD SIZE /1/	A MAX	B MAX MIN	C ± .005	F MIN	ØG ± .010	H MAX /2/	J ± .002 /3/	ØK + .005 - .000	(M)	ØP ± .005	V MAT'L MAX	AXIAL STRENGTH LBF MIN	WEIGHT LBS/100 MAX
.1640-32 UNJC-3B	.997	.442 .360	.344	.100	.200	.272	.312	.098	.084	.365	.047	1,720	.43
.1900-32 UNJF-3B	1.013	.453 .406	.344	.100	.200	.281	.312	.098	.093	.411	.047	2,460	.44
.2500-28 UNJF-3B	1.252	.619 .535	.500	.100	.200	.340	.312	.098	.121	.540	.055	4,580	.86
.3125-24 UNJF-3B	1.340	.766 .681	.500	.125	.230	.422	.312	.130	.156	.686	.065	7,390	1.17

MATERIAL:

CARBON STEEL – 1035 (UNS G10350), 1040 (UNS G10400), AND 1050 (UNS G10500), PER ASTM A 827/A 827M OR AMS-QQ-S-700; 1042 (UNS G10420) PER ASTM A29/A29M.
ALLOY STEEL – 4130 (UNS G41300), 4340 (UNS G43400) AND 8740 (UNS G87400) PER ASTM A 29/A 29M, FE-PL43S CONFORMING TO CHEMISTRY OF EN 2543.

FINISH:

CADMIUM PLATE IN ACCORDANCE WITH AMS-QQ-P-416 TYPE II, CLASS 2.
FOR DRY FILM LUBRICATED NUTS, THE TYPE AND CLASS ARE OPTIONAL IF THE NUTS MEET THE SALT SPRAY REQUIREMENT OF AMS-QQ-P-416, TYPE II.

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS21053, REVISION D. PART NUMBERS REMAIN MS21053.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NASM25027	TITLE NUT, SELF-LOCKING, PLATE, ONE LUG, 100° CSK, LOW HEIGHT, ALLOY STEEL, 125 KSI Ft_u, 450 °F	CLASSIFICATION PART STANDARD MSM21053

LUBRICATION:

DRY FILM LUBRICANT APPROVED IN ACCORDANCE WITH NASM25027.
NON-DRY FILM LUBRICANTS SHALL BE SOLUBLE IN THE CLEANER SPECIFIED IN AMS-S-8802.

EXAMPLE OF PART NUMBER:

MS21053 L4K = .2500-28 UNJF-3B NUT, SELF-LOCKING, ONE LUG, STEEL, 125 KSI, 450 °F, DRY
FILM LUBRICATED WITH COUNTERSUNK OR DIMPLED RIVET HOLES

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NUT DASH NUMBER
BASIC PART NUMBER

NOTES:

- /1/ THREADS BEFORE LUBRICATION PER AS8879.
- /2/ MINIMUM "H" NOT SPECIFIED, LIMITED ONLY BY THE STRENGTH REQUIREMENTS.
- /3/ CENTER OF THE TAPPED HOLE SHALL NOT DEVIATE IN ANY DIRECTION FROM THE CENTER OF THE PLATE NUT AS DETERMINED BY THE RIVET HOLES BY MORE THAN .005.
- /4/ DIMPLED HOLE TOLERANCE FOR "ØK" IS +.015/-.000 AFTER FORMING.
- (5) HARDNESS: 49 HRC MAXIMUM.
- (6) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (7) SURFACE ROUGHNESS: 125 MICROINCHES Ra PER ASME B46.1.
- (8) DESIGN AND USAGE LIMITATIONS: THESE NUTS ARE DESIGNED TO DEVELOP THE TENSILE STRENGTH OF BOLTS AND SCREWS WITH AN ULTIMATE TENSILE STRENGTH OF 125 KSI BASED ON A CROSS SECTIONAL AREA AT THE BASIC ROOT DIAMETER OF THE THREAD. THESE NUTS ARE DESIGNED TO BE USED ON 3A EXTERNAL THREADS. THESE NUTS SHALL BE USED IN ACCORDANCE WITH THE LIMITATIONS OF NASM33588. ~~ONLY NUTS FOR WHICH THERE ARE QUALIFIED PRODUCTS LISTED ON QPL25027 SHALL BE USED.~~
- (9) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (10) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (11) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (12) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (13) CONFIGURATION OF NUT OPTIONAL WITHIN THE LIMITATIONS IMPOSED BY DIMENSIONS AND REQUIREMENTS SPECIFIED HEREIN.

② COMPLETELY REVISED

REVISION
2
NASM21053
SHEET 2

