

FED. SUPPLY CLASS

5306

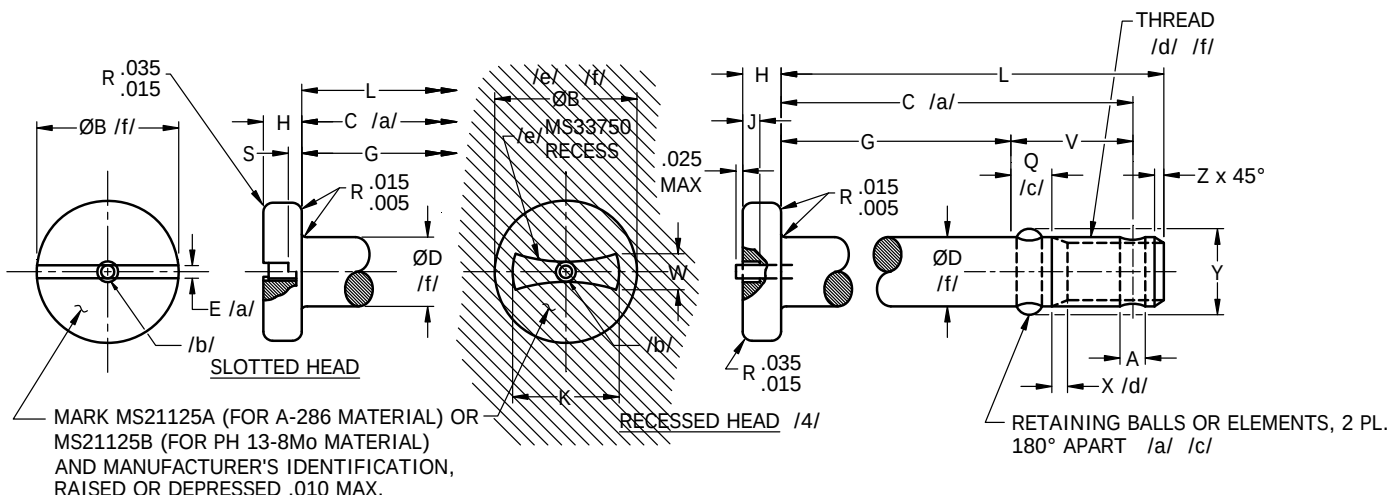


TABLE I – DIMENSIONS

DIA DASH NO	THREAD DESIGNATION AS8879	A		ØB /f/		ØD /f/		E		H		J	
		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN
3	.1900-32 UNJF-3A	.080	.070	.374	.360	.1894	.1889	.057	.047	.110	.095	.057	.054
4	.2500-28 UNJF-3A	.086	.076	.492	.477	.2492	.2487	.073	.063	.141	.126	.072	.069
5	.3125-24 UNJF-3A			.625	.610	.3117	.3112	.088	.078	.172	.157	.097	.094
6	.3750-24 UNJF-3A	.116	.106	.740	.722	.3742	.3737	.104	.094	.204	.189	.111	.107
7	.4375-20 UNJF-3A			.813	.795	.4367	.4362			.235	.220	.118	.114
8	.5000-20 UNJF-3A			.915	.905	.4991	.4986			.266	.251	.134	.130
9	.5625-18 UNJF-3A	.151	.141	1.035	1.015	.5616	.5611	.119	.109	.297	.282	.149	.145

② TABLE I – DIMENSIONS (CONTINUED)

DIA DASH NO	THREAD DESIGNATION AS8879	K	Q /c/		S		V	W		Y		Z		RECESS NO /e/
		MAX	MAX	MIN	MAX	MIN	BASIC	MAX	MIN	MAX	MIN	MAX	MIN	
3	.1900-32 UNJF-3A	.270	.094	.079	.032	.022	.293	.098	.094	.225	.215	.041	.021	2
4	.2500-28 UNJF-3A	.380	.125	.110			.333	.111	.107	.294	.284			3
5	.3125-24 UNJF-3A	.545	.156	.141	.047	.037	.375	.147	.143	.380	.370	.057	.037	4
6	.3750-24 UNJF-3A	.630	.171	.156			.421	.164	.160	.445	.435			5
7	.4375-20 UNJF-3A	.730	.202	.187			.460	.193	.188	.514	.504			6
8	.5000-20 UNJF-3A	.815	.234	.219			.078	.068	.523	.221	.216			.599
9	.5625-18 UNJF-3A	.900	.265	.250	.094	.084	.628	.262	.257	.671	.661	.072	.052	8

/a/ COTTER PIN HOLE SHALL BE WITHIN .010 INCH OF BOLT CENTERLINE FOR BOLTS Ø.312 AND SMALLER: AND WITHIN .015 INCH FOR BOLTS Ø.375 AND LARGER. THE PIN HOLE SHALL BE PERPENDICULAR TO BOLT CENTERLINE WITHIN 2°. LOCATION OF COTTER PIN HOLE FROM TOP OF HEAD IS GIVEN BY "C" – ("G" MIN + "V") ± .010. THE COTTER PIN HOLE SHALL BE PERPENDICULAR TO THE SLOT IN HEAD WITHIN 5°. ORIENTATION OF BALLS OR ELEMENT TO COTTER PIN HOLE SHALL BE IN LINE WITHIN 3°. BALL OR ELEMENT PROTRUSION FROM THE BOLT CENTERLINE SHALL BE EQUAL OR LESS THAN 1/2 "Y" MAX.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS21125, REVISION F. PART NUMBERS REMAIN MS21125.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NASM23964	TITLE BOLT, SELF-RETAINING, POSITIVE LOCKING, CRES, 90 KSI Fsu, 63 KSI FtU, PAN HEAD, 450 °F & 650 °F	CLASSIFICATION PART STANDARD NASM21125

- /b/ THE RETAINING DEVICE SHALL BE RELEASED ONLY BY DEPRESSING THE PLUNGER LOCATED IN THE HEAD OF THE BOLT. MAX DIAMETER OF PLUNGER FOR RECESS HEAD SHALL BE THE MINIMUM VALUE FOR THE "M" DIMENSION ON NASM33750.
- /c/ BALLS OR RETAINING ELEMENTS SHALL BE LOCATED WITHIN THE LIMITS OF "Q" DIMENSION, AND AT MAXIMUM PROTRUSION SHALL FIT WITHIN THE GROOVES OF THE APPROPRIATE SPACER OF MS21126 AND MS21128 WITHOUT INTERFERENCE OR BINDING.
- /d/ THREAD: IN ACCORDANCE WITH AS8879 EXCEPT THAT INCOMPLETE THREAD LENGTH "X" SHALL BE A MAXIMUM OF 1-1/2 AND A MINIMUM OF 1/2 THREAD PITCHES IN LENGTH AND MAJOR DIA SHALL BE .001 LESS THAN THE MEASURED SHANK DIA.
- /e/ RECESS SHALL BE LOCATED AT TRUE POSITION "ØB" WITHIN .010 AND SHALL CONFORM TO NASM33750 EXCEPT THAT RECESS DIMPLE IS OPTIONAL.
- /f/ CONCENTRICITY: "ØD" AND "ØB" TO BE CONCENTRIC TO PITCH DIAMETER OF THREAD WITHIN .002 FIM AT MAXIMUM MATERIAL CONDITION.

MATERIAL:

MAGNETIC:

BOLT AND PLUNGER: CRES PH 13-8Mo CHEMISTRY OF AMS5629 (UNS S13800).
 BALLS OR ELEMENT: CRES PER ~~QQ-S-763 CLASS FSC 440C~~ AMS5630 (UNS S44004).
 SPRING: CRES WIRE, SPRING TEMPER PER ~~AMS5673~~ AMS5678, 17-7 PH
 (UNS S17700) OR ~~QQ-W-423, COMPOSITION 302, CONDITION B~~
 ASTM A313/A313M, TYPE 302 (UNS S30200).

NON-MAGNETIC:

BOLT AND PLUNGER: CRES A286 CHEMISTRY OF AMS5737 (UNS S66286).
 BALLS OR ELEMENT: CRES PER ~~MIL-S-7720~~ AMS-S-7720.
 SPRING: NICKEL-CHROMIUM-IRON ALLOY PER ~~QQ-W-390 CONDITION C~~
 ASTM B166 COLD DRAWN, SPRING TEMPER OR NICKEL-ALLOY SPRING
 PER AMS5699, SPRING TEMPER.

HEAT TREATMENT:

BOLT AND PLUNGER: PER AMS2759 TO CONDITION H1000.
 BALLS: PER AMS2759 55 TO 62 HRC.

FINISH:

CRES MATERIAL PASSIVATED PER AMS2700, METHOD 1, CLASS 4.

LUBRICATION:

BOLT PLUNGER MANUFACTURED FROM PH 13-8Mo AND A286 MATERIAL SHALL BE COATED WITH DRY FILM LUBRICANT PER ~~MIL-L-8937~~ AS5272, TYPE I OR ~~MIL-L-46010~~ AS5272, TYPE II RESPECTIVELY.

REVISION

2

NASM21125

SHEET 2



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