

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
11000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST REVISION DATE.

FORM 12-01

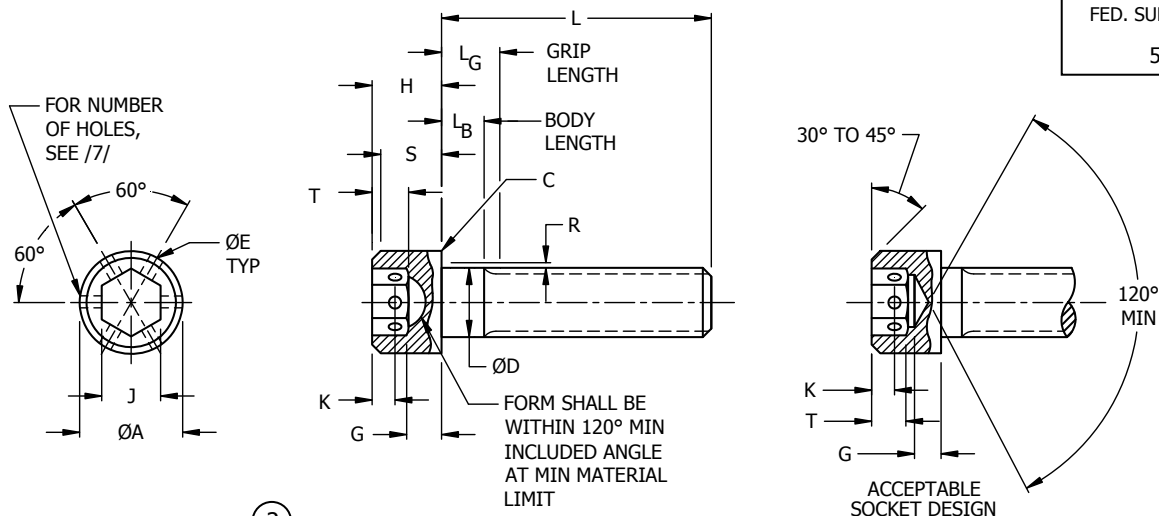


TABLE I – DASH NUMBERS AND DIMENSIONS /5/

NOMINAL SIZE			#6 (.1380)	#8 (.1640)			#10 (.1900)			1/4 (.2500)				
THREAD SIZE			.1380-40 UNF-3A	.1640-36 UNF-3A			.1900-32 UNF-3A			.2500-28 UNF-3A				
ØD	BODY	MAX	.1380	.1640			.1900			.2500				
		MIN	.1329	.1585			.1840			.2435				
ØA	HEAD	MAX	.226	.270			.312			.375				
		MIN	.218	.262			.303			.365				
H	HEAD HEIGHT	MAX	.138	.164			.190			.250				
		MIN	.134	.159			.185			.244				
S	HEAD SIDE HEIGHT	MIN	.124	.148			.171			.225				
J	SOCKET WIDTH ACROSS FLATS	MAX	.1111	.1426			.1587			.1900				
		MIN	.1094	.1406			.1562			.1875				
T	KEY ENGAGEMENT	MIN	.064	.077			.090			.120				
G	WALL THICKNESS	MIN	.047	.056			.065			.095				
C	CHAMFER OR RADIUS	MAX	.005	.005			.005			.008				
R	FILLET EXTENSION	MAX	.010	.012			.014			.014				
		MIN	.006	.007			.009			.009				
K	HOLE LOCATION	MAX	.050	.060			.065			.085				
		MIN	.035	.040			.045			.065				
ØE	HOLE	MAX	.039	.050			.050			.050				
		MIN	.033	.044			.044			.044				
	RECOMMENDED WIRE DIAMETER	MAX	.028	.040			.040			.040				
		MIN	.020	.032			.032			.032				
/8/	ALIGNMENT PLUG DIA		.025	.030			.030			.030				
/9/	TENSILE STRENGTH, LBF	MIN	1,830			2,650			3,600			6,190		
L LENGTH		TOLERANCE	DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN
.250		+.00 -.03	1											
.375			2			6			9			19		
.500			3			7			10			20		
.625			4						11			21		
.750			5			8			12			22		
.875								13			23			
1.000								14			24			
1.250		+.00 -.04							15	.38	.17	25		
1.500									16	.38	.17	26	.50	.25
1.750									17	.88	.67	27	.50	.25
2.000									18	.88	.67	28	1.00	.75
2.250												29	1.00	.75

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24678, REVISION E. PART NUMBERS REMAIN MS24678.

THIRD ANGLE PROJECTION 	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-86	TITLE SCREW, CAP, SOCKET HEAD, HEXAGON, DRILLED, ALLOY STEEL (UNF-3A)	CLASSIFICATION PART STANDARD NASM24678 SHEET 1 OF 4

② TABLE I – DASH NUMBERS AND DIMENSIONS (CONTINUED) /5/

NOMINAL SIZE			5/16 (.3125)			3/8 (.3750)			7/16 (.4375) /10/			1/2 (.5000)			5/8 (.6250)															
THREAD SIZE			.3125-24 UNF-3A			.3750-24 UNF-3A			.4375-20 UNF-3A			.5000-20 UNF-3A			.6250-18 UNF-3A															
ØD	BODY	MAX	.3125			.3750			.4375			.5000			.6250															
		MIN	.3053			.3678			.4294			.4919			.6163															
ØA	HEAD	MAX	.469			.562			.656			.750			.938															
		MIN	.457			.550			.642			.735			.921															
H	HEAD HEIGHT	MAX	.312			.375			.438			.500			.625															
		MIN	.306			.368			.430			.492			.616															
S	HEAD SIDE HEIGHT	MIN	.281			.337			.394			.450			.562															
J	SOCKET WIDTH ACROSS FLATS	MAX	.2530			.3160			.3790			.3790			.5050															
		MIN	.2500			.3125			.3750			.3750			.5000															
T	KEY ENGAGEMENT	MIN	.151			.182			.213			.245			.307															
G	WALL THICKNESS	MIN	.119			.143			.166			.190			.238															
C	CHAMFER OR RADIUS	MAX	.008			.008			.010			.010			.010															
R	FILLET EXTENSION	MAX	.017			.020			.023			.026			.032															
		MIN	.012			.015			.018			.020			.024															
K	HOLE LOCATION	MAX	.104			.123			.141			.160			.198															
		MIN	.084			.103			.121			.140			.178															
ØE	HOLE	MAX	.050			.067			.067			.067			.067															
		MIN	.044			.061			.061			.061			.061															
	RECOMMENDED WIRE DIAMETER	MAX	.040			.057			.057			.057			.057															
		MIN	.032			.045			.045			.045			.045															
/8/	ALIGNMENT PLUG DIA		.030			.051			.051			.051			.051															
/9/	TENSILE STRENGTH, LBF		9,860			14,900			20,200			27,200			43,500															
L LENGTH	TOLERANCE		DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN	DASH NO.	L _G MAX	L _B MIN													
	SIZE																													
	.3750 OR UNDER	.4375 AND OVER																												
.500	+.00 −.03	+.00 −.03	30			41			53			57			65															
.625			31			42																								
.750			32			43																								
.875			33			44																								
1.000			34			45																								
1.250	+.00 −.04	+.00 −.06	35			46			54			58			66															
1.500			36			47																								
1.750			37			.62												.35	48	.50	.19	56	.62	.27	60			68		
2.000			38			.62												.35	49	.50	.19									
2.250			39			1.12												.85	50	1.00	.69									
2.500			40			1.12												.85	51	1.00	.69									
3.000			52	1.50	1.19																									
	+ .00 − .06	+ .00 − .08										64	1.50	1.12																

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FORM 12-01

REVISION

2

NAS Documents

SHEET 2

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