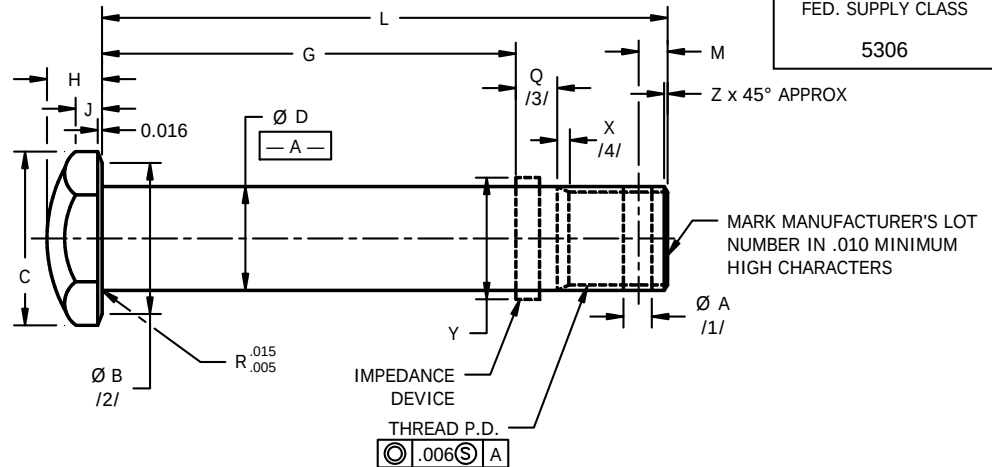
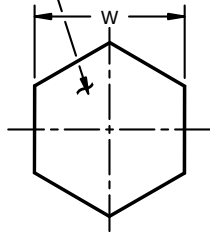


IDENTIFY PART IN ACCORDANCE WITH NAS1347 TYPE IV EXCEPT CHARACTERS TO BE .010 HIGH MINIMUM.



FED. SUPPLY CLASS

5306

TABLE I – BOLT DIMENSIONS

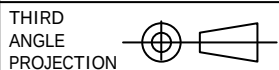
FIRST DASH NO	NOM DIA	THREAD DESIGNATION /A/	Ø A /1/		Ø B	C	Ø D		H		M +.010 -.005	Q		J		W		Y		Z	
			MAX	MIN			MIN	MIN	MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN
3	.1900	.1900-32 UNJF-3A	.080	.070	.359	.413	.1894	.1885	.110	.095	.083	.120	.074	.083	.063	.376	.367	.225	.196	.041	.021
4	.2500	.2500-28 UNJF-3A	.086	.076	.422	.488	.2492	.2483	.141	.126	.090	.120	.105	.104	.084	.439	.430	.294	.256	.041	.021
5	.3125	.3125-24 UNJF-3A	.086	.076	.484	.557	.3117	.3108	.172	.157	.105	.151	.120	.125	.105	.502	.492	.380	.320	.057	.037
6	.3750	.3750-24 UNJF-3A	.116	.106	.546	.628	.3742	.3733	.204	.189	.105	.186	.120	.146	.126	.564	.553	.445	.382	.057	.037
7	.4375	.4375-20 UNJF-3A	.116	.106	.609	.698	.4367	.4358	.235	.220	.110	.197	.120	.166	.146	.627	.617	.514	.450	.057	.037
8	.5000	.5000-20 UNJF-3A	.116	.106	.734	.840	.4991	.4982	.266	.251	.110	.229	.120	.188	.168	.752	.741	.599	.510	.057	.037
9	.5625	.5625-18 UNJF-3A	.151	.141	.859	.978	.5616	.5607	.297	.282	.115	.260	.120	.208	.188	.877	.865	.671	.582	.072	.052
10	.6250	.6250-18 UNJF-3A	.151	.141	.922	1.050	.6241	.6232	.328	.313	.115	.287	.120	.228	.208	.940	.928	.743	.645	.087	.067
12	.7500	.7500-16 UNJF-3A	.151	.141	1.047	1.194	.7491	.7482	.391	.376	.147	.320	.120	.269	.249	1.084	1.052	.900	.755	.087	.067
14	.8750	.8750-14 UNJF-3A	.151	.141	1.234	1.403	.8741	.8732	.454	.439	.147	.352	.120	.310	.290	1.252	1.239	1.050	.880	.087	.067
16	1.0000	1.000-12 UNJF-3A	.151	.141	1.422	1.615	.9991	.9982	.516	.501	.147	.383	.120	.351	.331	1.440	1.427	1.200	1.010	.087	.067

TABLE II – BOLT STRENGTH

NOMINAL SIZE	SHANK ULTIMATE DOUBLE SHEAR STRENGTH LBF MIN	BOLT ULTIMATE TENSILE STRENGTH LBF MIN
0.1900	5,380	2,530
0.2500	9,300	4,680
0.3125	14,600	7,510
0.3750	21,000	11,540
0.4375	28,600	15,560
0.5000	37,300	21,160
0.5625	47,200	26,870
0.6250	58,300	34,100
0.7500	83,900	39,800
0.8750	114,200	55,840
1.0000	149,200	74,000

③ COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS27576, REVISION E. PART NUMBERS REMAIN MS27576.



PROCUREMENT SPECIFICATION
NASM83050

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE
**BOLT, SELF-RETAINING, IMPEDANCE TYPE,
95 KSI Fsu, HEX HEAD, 450 °F**

REVISION
3

CLASSIFICATION
PART STANDARD

NASM27576
SHEET 1 OF 5

MATERIALS:

BOLT: ALLOY STEEL: SEE PROCUREMENT SPECIFICATION.
 CRES STEEL: 17-4PH (UNS S17400) IN ACCORDANCE WITH AMS5643 EXCEPT THAT AGING TEMPERATURE SHALL NOT BE LESS THAN 1000 °F OR 13-8 MO (UNS S13800) IN ACCORDANCE WITH AMS5629.
 RETAINING ELEMENT: 17-4PH (UNS S17400) IN ACCORDANCE WITH AMS5643, 17-7PH (UNS S17700) IN ACCORDANCE WITH AMS5644 OR AMS5678, OR 440C CRES STEEL (UNS S44004) IN ACCORDANCE WITH AMS-QQ-S-763.

SURFACE FINISH:

UNTHREADED SHANK AND BEARING SURFACE UNDER HEAD: 63Ra IN ACCORDANCE WITH ASME B46.1.
 ALL OTHER SURFACES: 125Ra IN ACCORDANCE WITH ASME B46.1.

HEAT TREATMENT:

IN ACCORDANCE WITH AMS-H-6875 AMS2759 TO ROCKWELL C36 TO C41.

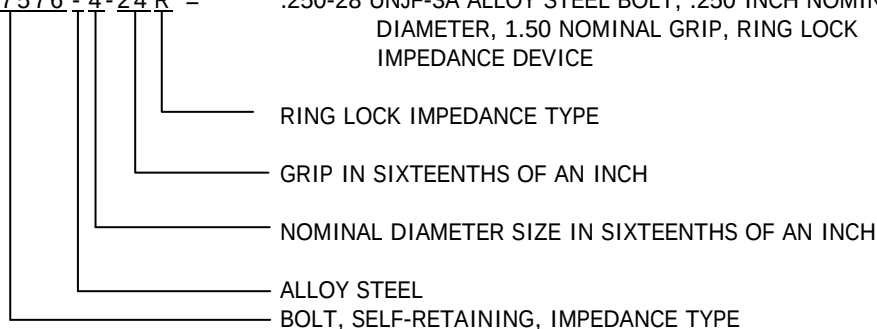
FINISH:

ALLOY STEEL: CADMIUM PLATE IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 2.
 CRES STEEL: PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

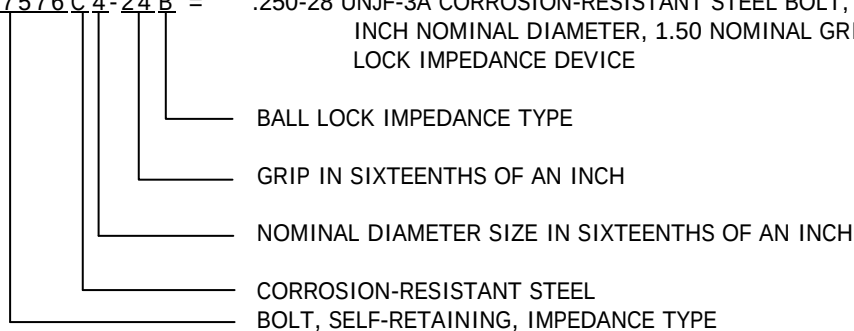
CODE:

"-" PRIOR TO FIRST DASH NUMBER INDICATES ALLOY STEEL AND "C" INDICATES CRES.
 FIRST DASH NUMBER INDICATES BOLT DIAMETER IN SIXTEENTHS OF AN INCH.
 SECOND DASH NUMBER INDICATES GRIP LENGTH IN SIXTEENTHS OF AN INCH.
 "B" SUFFIX DESIGNATES BALL TYPE IMPEDANCE DEVICE.
 "R" SUFFIX DESIGNATES RING TYPE IMPEDANCE DEVICE.
 NO SUFFIX DESIGNATES MANUFACTURER OPTION.

EXAMPLES OF PART NUMBER: MS27576 - 4 - 24 R = .250-28 UNJF-3A ALLOY STEEL BOLT, .250 INCH NOMINAL DIAMETER, 1.50 NOMINAL GRIP, RING LOCK IMPEDANCE DEVICE



MS27576 C 4 - 24 B = .250-28 UNJF-3A CORROSION-RESISTANT STEEL BOLT, .250 INCH NOMINAL DIAMETER, 1.50 NOMINAL GRIP, BALL LOCK IMPEDANCE DEVICE



REVISION

3

NAS Documents

SHEET 2

③ COMPLETELY REVISED

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