

FED. SUPPLY CLASS

5305

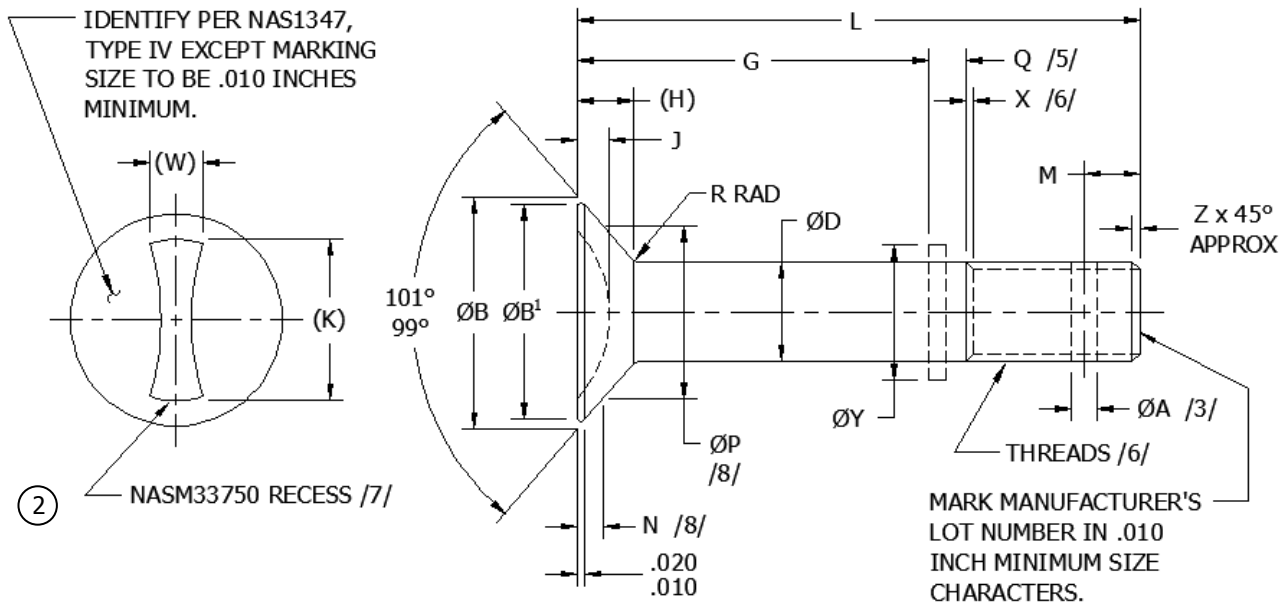


TABLE I – DIMENSIONS

FIRST DASH NO.	NOMINAL DIA	THREAD SIZE /6/	ØA /3/		ØB	ØB ¹	ØD		(H) /4/	J		(K)	M +.010 - .000
			MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN		
3	.1900	.1900-32 UNJF-3A	.080	.070	.385	.328	.1894	.1885	.080	.045	.042	.305	.083
4	.2500	.2500-28 UNJF-3A	.086	.076	.507	.449	.2492	.2483	.106	.054	.051	.422	.090
5	.3125	.3125-24 UNJF-3A	.086	.076	.635	.577	.3117	.3108	.133	.064	.061	.490	.105
6	.3750	.3750-24 UNJF-3A	.116	.106	.762	.704	.3742	.3733	.160	.088	.084	.639	.105
7	.4375	.4375-20 UNJF-3A	.116	.106	.890	.832	.4367	.4358	.188	.100	.097	.715	.110
8	.5000	.5000-20 UNJF-3A	.116	.106	1.017	.959	.4991	.4982	.215	.105	.101	.766	.110
9	.5625	.5625-18 UNJF-3A	.151	.141	1.145	1.087	.5616	.5607	.242	.118	.114	.877	.115

TABLE I – DIMENSIONS (CONTINUED)

FIRST DASH NO.	NOMINAL DIA	HEAD PROTRUSION 8/				Q		R		(W)	ØY		Z		RECESS NO. /7/
		N		ØP											
		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN	MAX	MIN	
3	.1900	.0290	.0263	.3147	.3143	.120	.074	.020	.015	.110	.225	.196	.041	.021	3
4	.2500	.0342	.0316	.4245	.4241	.120	.105	.020	.015	.134	.294	.256	.041	.021	4
5	.3125	.0395	.0370	.5389	.5385	.151	.120	.030	.020	.160	.380	.320	.057	.037	5
6	.3750	.0450	.0426	.6532	.6528	.166	.120	.030	.020	.198	.445	.382	.057	.037	6
7	.4375	.0503	.0481	.7676	.7672	.197	.120	.030	.020	.224	.514	.450	.057	.037	7
8	.5000	.0557	.0537	.8820	.8816	.229	.120	.030	.020	.256	.599	.510	.057	.037	8
9	.5625	.0611	.0592	.9964	.9960	.260	.120	.030	.020	.300	.671	.582	.072	.052	9

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS27577, REVISION F. PART NUMBERS REMAIN MS27577.



THIRD ANGLE PROJECTION

PROCUREMENT SPECIFICATION

NASM83050

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

**BOLT, SELF-RETAINING, IMPEDANCE TYPE,
95 KSI FSU, FLUSH HEAD, 450 °F**

REVISION

2

CLASSIFICATION

PART STANDARD

NASM27577

SHEET 1 OF 6

MATERIAL:

SCREW:

ALLOY STEEL: 4340 (UNS G43400) PER ~~MIL-S-5000~~ AMS6415 OR AMS6484; 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6349 OR AMS6382; 8740 (UNS G87400) PER ~~MIL-S-6049~~ AMS6322, AMS6325, OR AMS6327; 4130 (UNS G41300) PER ~~MIL-S-6758~~ AMS-S-6758; OR 6150 (UNS G51500) PER ~~MIL-S-8503~~ AMS6448.

CRES STEEL: 17-4PH (UNS S17400) PER AMS5643 EXCEPT THAT AGING TEMPERATURE SHALL NOT BE LESS THAN 1000 °F, OR A286 (UNS S66286) PER AMS5732.

TITANIUM ALLOY: TITANIUM 6AL-4V (UNS R56400) PER ~~MIL-T-9047~~ AMS6930 OR AMS6931.

RETAINING ELEMENT:

17-4PH (UNS S17400) PER AMS5643.

17-7PH (UNS S17400) PER AMS5644 OR AMS5678.

440C CRES STEEL PER ~~QQ-S-763~~ AMS-QQ-S-763.

HEAT TREATMENT:

SCREW: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759 FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM.

ALLOY STEEL: 160-180 KSI Ft_u (HRC 36 – 41)

CRES: 160-190 KSI Ft_u

TITANIUM (6AL-4V): 160 KSI Ft_u MIN

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.

TITANIUM: NO FINISH.

CODE:

THE PART NUMBER SHALL CONSIST OF THE BASIC PART NUMBER, FOLLOWED BY A MATERIAL CODE LETTER, FOLLOWED BY A NOMINAL DIAMETER SIZE IN SIXTEENTHS OF AN INCH TAKEN FROM TABLE I, FOLLOWED BY A GRIP IN SIXTEENTHS OF AN INCH TAKEN FROM TABLE III.

"-" (OR NO CODE) FOLLOWING BASIC PART NUMBER INDICATES ALLOY STEEL.

"C" FOLLOWING BASIC PART NUMBER INDICATES 17-4PH CRES STEEL.

"P" FOLLOWING BASIC PART NUMBER INDICATES A286 CRES STEEL.

"V" FOLLOWING BASIC PART NUMBER INDICATES 6AL-4V TITANIUM.

EXAMPLES OF PART NUMBER:

MS27577 - 4-24 = .2500-28 UNJF-3A ALLOY STEEL SCREW, .2500 NOMINAL DIAMETER, 1.50 NOMINAL GRIP

GRIP IN SIXTEENTHS OF AN INCH

NOMINAL DIAMETER SIZE IN SIXTEENTHS OF AN INCH

ALLOY STEEL

SCREW, CLOSE TOLERANCE

REVISION

2

MS27577

SHEET 2



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