

FED. SUPPLY CLASS

5307

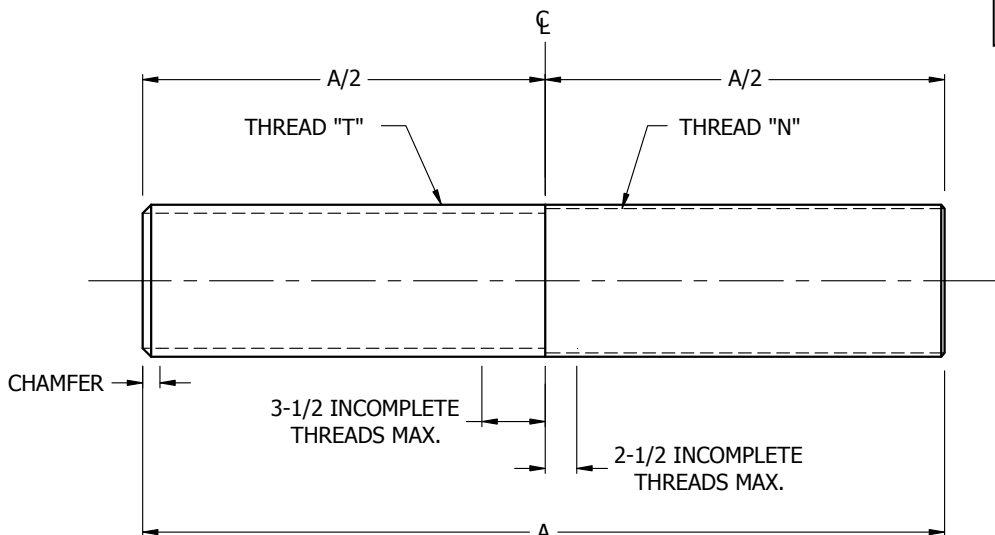


TABLE I – (TAP END THREAD DESIGNATION CLASS SHF)

DASH NO.	T TAP END THREAD NC-5 HF	N NUT END THREAD UNF-2A
STEEL		
102	.2500-20	.2500-28
103	.3125-18	.3125-24
104	.3750-16	.3750-24
105	.4375-14	.4375-20
106	.5000-13	.5000-20
107	.5625-12	.5625-18
108	.6250-11	.6250-18
109	.7500-10	.7500-16
110	.8750-9	.8750-14
111	1.0000-8	1.0000-12
112	1.1250-7	1.1250-12
113	1.2500-7	1.2500-12

TABLE II – (TAP END THREAD DESIGNATION CLASS 5 CSF)

DASH NO.	T TAP END THREAD NC-5 HF		N NUT END THREAD UNF-2A	
	CRES	BRASS		
202	302	.2500-20	.2500-28	
203	303	.3125-18	.3125-24	
204	304	.3750-16	.3750-24	
205	305	.4375-14	.4375-20	
206	306	.5000-13	.5000-20	
207	307	.5625-12	.5625-18	
208	308	.6250-11	.6250-18	
209	309	.7500-10	.7500-16	
210	310	.8750-9	.8750-14	
211	311	1.0000-8	1.0000-12	
212	312	1.1250-7	1.1250-12	
213	313	1.2500-7	1.2500-12	

TABLE III – (TAP END THREAD DESIGNATION CLASS 5 ONF)

DASH NO.	T TAP END THREAD NC-5 ONF	N NUT END THREAD UNF-2A
NI-CU		
402	.2500-20	.2500-28
–	–	–
404	.3750-16	.3750-24
–	–	–
406	.5000-13	.5000-20
–	–	–
408	.6250-11	.6250-18
409	.7500-10	.7500-16
410	.8750-9	.8750-14
411	1.0000-8	1.0000-12
412	1.1250-7	1.1250-12
413	1.2500-7	1.2500-12

MATERIAL:

STEEL, CARBON OR ALLOY, PER FEDERAL STANDARD No. 66 AIR4127.
CRES, PER FEDERAL STANDARD No. 66 AIR4127, 300 SERIES.
BRASS, PER ASTM B21/B21M, ASTM B124/B124M OR ASTM B283, COMPOSITION 1.
NICKEL-COPPER ALLOY, PER QQ-N-281, CLASS B, COLD DRAWN OR EQUIVALENT.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51864, AMENDMENT 1. PART NUMBERS REMAIN MS51864.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION FF-S-1362	TITLE STUD, PLAIN, GENERAL PURPOSE	CLASSIFICATION PART STANDARD
		MS51864 SHEET 1 OF 5

FINISH:

STEEL, CARBON OR ALLOY, CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 3.
CRES, PASSIVATED PER AMS2700, METHOD 1, CLASS 4.
BRASS, OXIDE OR BLACK FINISH PER MIL-F-495.

CODE:

THE MS PART NUMBER CONSISTS OF THE MS NUMBER, PLUS THE DASH NUMBER, PLUS THE SECOND DASH NUMBER FOR LENGTH (TABLE IV).

EXAMPLES OF PART NUMBERS:

MS51864-102-16 = STUD, CARBON OR ALLOY STEEL, Ø.2500 INCHES, 2 INCHES LENGTH
MS51864-204-18 = STUD, CRES, Ø.3750 INCHES, 2.250 INCHES LENGTH
MS51864-306-20 = STUD, BRASS, Ø.5000 INCHES, 2.500 INCHES LENGTH
MS51864-409-30 = STUD, NICKEL-COPPER ALLOY, Ø.7500 INCHES, 3.750 INCHES LENGTH

NOTES:

- (1) THREADS: NC-5 THREADS SHALL CONFORM TO FED-STD-H28, PART III; UNF-2A THREADS SHALL CONFORM TO FED-STD-H28, PART I.
- (2) MECHANICAL PROPERTIES: STUDS SHALL BE CAPABLE OF DEVELOPING MECHANICAL PROPERTIES IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION. TENSILE STRENGTHS AND PERTINENT LENGTH DASH NUMBERS ARE LISTED BELOW:

<u>MATERIAL</u>	<u>MIN. TENSILE STRENGTH KSI</u>	<u>DASH NUMBERS</u>
STEEL, CARBON OR ALLOY		
SIZES 1/4 THRU 1	120	
OVER 1 THRU 1 1/2	105	102-113
STEEL, CRES	80	202-213
BRASS	60	302-313
NICKEL-COPPER ALLOY	80	402-413

- (3) HARDNESS:
STEEL, CARBON OR ALLOY, 19 HRC MINIMUM.
STEEL, CRES, 140 HB MINIMUM.
BRASS, 65 HRB MINIMUM.
NICKEL-COPPER ALLOY, 80 HRB MINIMUM.
- (4) CHAMFER: 45° TO 50° ANGLE FROM THE OUTSIDE DIAMETER TO 1/64 TO 1/32 INCHES BELOW ROOT DIAMETER OF THREAD.
- (5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (6) LENGTH TOLERANCES: STUDS 6 INCHES AND UNDER ±.125 INCHES, STUDS OVER 6 INCHES ±.188 INCHES.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

① COMPLETELY REVISED

REVISION

1

NASM51864

SHEET 2



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America Inc. MS PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS. ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABLE LICENSEE= www.sepana.ir/5991803002, User=sam, albert
No reproduction or networking permitted without license from IHS. Not for Resale, 01/04/2016 15:52:31 MST. TRADEMARK RIGHTS.

Full document details: AIA NASM51864 2011