

FED. SUPPLY CLASS

5307

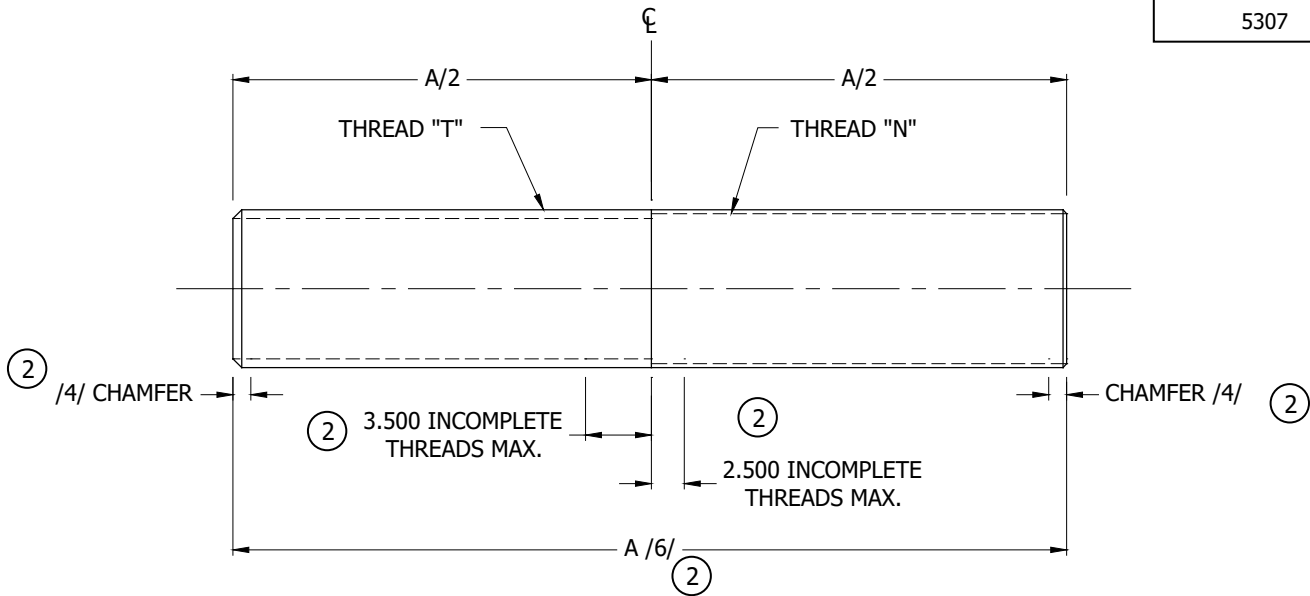


TABLE I – TAP END THREAD DESIGNATION CLASS 5 HF

DASH NO.	T TAP END THREAD NC-5 HF /1/	N NUT END THREAD UNF-2A /1/
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 CSF /1/	N NUT END THREAD UNF-2A /1/
CRES		
202	.2500-20	.2500-28
203	.3125-18	.3125-24
204	.3750-16	.3750-24
205	.4375-14	.4375-20
206	.5000-13	.5000-20
207	.5625-12	.5625-18
208	.6250-11	.6250-18
209	.7500-10	.7500-16
210	.8750-9	.8750-14
211	1.0000-8	1.0000-12
212	1.1250-7	1.1250-12
213	1.2500-7	1.2500-12

TABLE III – TAP END THREAD DESIGNATION CLASS 5 ONF

DASH NO.	T TAP END THREAD NC-5 ONF /1/	N NUT END THREAD UNF-2A /1/
NI-CU		
402	.2500-20	.2500-28
403	—	—
404	.3750-16	.3750-24
405	—	—
406	.5000-13	.5000-20
407	—	—
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:

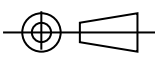
STEEL, CARBON OR ALLOY, PER FEDERAL STANDARD No. 66 AIR4127.

CRES, PER FEDERAL STANDARD No. 66 AIR4127, 300 SERIES.

BRASS, PER ASTM B21/B21M, ASTM B124/B124M OR ASTM B283/B283M, COMPOSITION 1.

NICKEL-COPPER ALLOY, PER QQ-N-281, CLASS B, COLD DRAWN OR EQUIVALENT.

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

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	
FF-S-1362	

CUSTODIAN	
NATIONAL AEROSPACE STANDARDS COMMITTEE	
TITLE	
STUD, PLAIN, GENERAL PURPOSE	

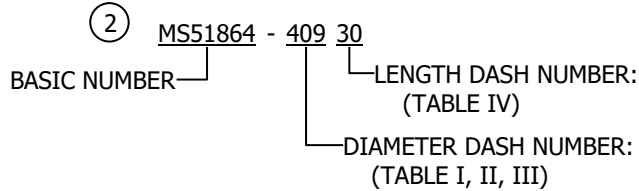
REVISION	
2	
CLASSIFICATION PART STANDARD	
NAS51864	
SHEET 1 OF 3	

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FINISH:

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

CODE:



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:

- (2) /1/ THREADS: NC-5 THREADS SHALL CONFORM TO FED-STD-H28/23; UNF-2A THREADS SHALL CONFORM TO FED-STD-H28/2.
- (2) MECHANICAL PROPERTIES: STUDS SHALL BE CAPABLE OF DEVELOPING MECHANICAL PROPERTIES IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION. TENSILE STRENGTHS AND PERTINENT LENGTH AND DIAMETER DASH NUMBERS ARE LISTED BELOW:

	MATERIAL	MIN. TENSILE STRENGTH KSI	DASH NUMBERS
(2)	STEEL, CARBON OR ALLOY		
	SIZES .2500 THRU 1.0000	120	102-111
	OVER 1.0000	105	112-113
	STEEL, CRES	80	202-213
	BRASS	60	302-313
	NICKEL-COPPER ALLOY	80	402-413

(3) HARDNESS:

- (2) STEEL, CARBON OR ALLOY,
SIZES .2500 THRU 1.0000, 25 HRC MINIMUM.
SIZES OVER 1.0000, 19 HRC MINIMUM.
STEEL, CRES, 140 HB MINIMUM.
BRASS, 65 HRB MINIMUM.
NICKEL-COPPER ALLOY, 80 HRB MINIMUM.

- (2) /4/ CHAMFER: 45° TO 50° ANGLE FROM THE OUTSIDE DIAMETER TO .016 TO .031 INCHES BELOW ROOT DIAMETER OF THREAD.

(5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.

- (2) /6/ LENGTH TOLERANCES: STUDS 6 INCHES AND UNDER ±.125 INCHES, STUDS OVER 6 INCHES ±.188 INCHES.