

FED. SUPPLY CLASS

5306

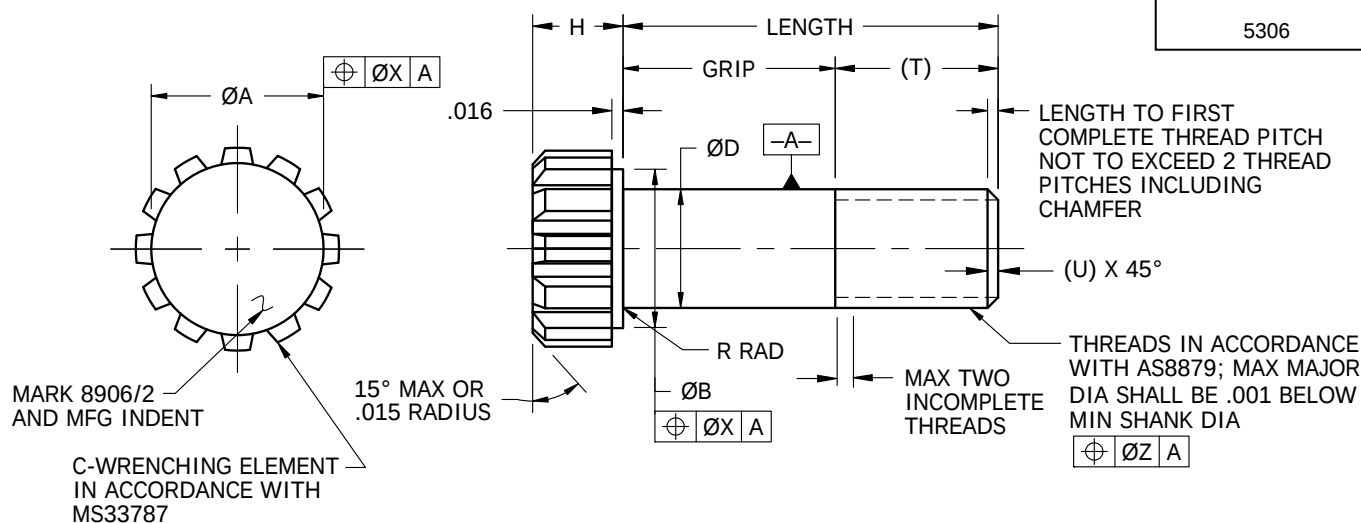


FIGURE 1 – BOLT SHEAR

TABLE I – BOLT SIZES

DASH NO.	THREAD UNJF-3A PER AS8879	ØA MIN /1/	ØB /1/ /4/		C WRENCHING ELEMENT	ØD /1/ /2/		H	R		(T)	(U)	CONCENTRICITY	
			MAX	MIN		MAX	MIN		MAX	MIN			X	Z
3	.1900-32	.381	.380	.359	12	.1895	.1885	.140	.022	.016	.331	.04	.004	.0045
4	.2500-28	.447	.446	.422	14	.2495	.2485	.164	.028	.022	.397	.04	.005	
5	.3125-24	.512	.511	.484	16	.3120	.3110	.187	.035	.029	.467	.05	.006	
6	.3750-24	.575	.574	.546	18	.3745	.3735	.210	.039	.038	.515	.05	.008	
7	.4375-20	.707	.703	.671	22	.4370	.4360	.257	.049	.039	.599	.06	.009	
8	.5000-20	.772	.784	.734	24	.4995	.4985	.281	.055	.045	.649	.06	.010	.0060
9	.5625-18	.901	.891	.859	28	.5615	.5605	.328	.061	.051	.725	.07	.011	
10	.6250-18	.967	.954	.922	30	.6240	.6230	.350	.068	.058	.777	.07	.012	
12	.7500-16	1.096	1.063	1.031	34	.7490	.7480	.400	.080	.070	.914	.08	.015	
14	.8750-14	1.291	1.250	1.218	40	.8740	.8730	.468	.093	.083	1.049	.09	.018	.0090
16	1.0000-12	1.487	1.438	1.406	46	.9990	.9980	.539	.105	.095	1.218	.10	.020	
18	1.1250-12	1.683	1.625	1.593	52	1.1240	1.1225	.609	.113	.108	1.334	.10	.022	
20	1.2500-12	1.813	1.812	1.781	56	1.2490	1.2475	.690	.130	.120	1.449	.10	.025	.0120
22	1.3750-12	2.011	2.000	1.968	62	1.3740	1.3725	.750	.143	.133	1.576	.10	.028	
24	1.5000-12	2.206	2.189	2.157	68	1.4990	1.4975	.820	.155	.145	1.700	.10	.030	

MATERIAL:

TOOL STEEL – H-11 (UNS T20811) PER AMS6487.

HEAT TREATMENT:

46-50 HRC.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-B-8906/2 REVISION A. PART NUMBERS REMAIN M8906/2.

THIRD ANGLE PROJECTION		CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NASM8906	TITLE BOLTS, SHEAR, STEEL, 132 KSI Fsu, 450 °F	1	CLASSIFICATION PART STANDARD NASM8906-2 SHEET 1 OF 4

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 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.

REVISION DATE: AUGUST 31, 2012

ISSUE DATE: SEPTEMBER 1999

FINISH:

CADMIUM PLATE IN ACCORDANCE WITH AMS-C-8837.

CODE:

THE PART NUMBER CONSISTS OF THE BASIC PART NUMBER, A DIAMETER DASH NUMBER FROM TABLE I, AND A GRIP DASH NUMBER FROM TABLE II.

EXAMPLE OF PART NUMBER:

M8906/2-3-4

.250 GRIP LENGTH

#10-32 THREAD

BASIC PART NUMBER

NOTES:

- /1/ "ØA", "ØB" AND "ØD" SHALL BE CONCENTRIC TO EACH OTHER WITHIN VALUES SPECIFIED FOR "X" (SEE TABLE I).
- /2/ "ØD" AND THREAD PITCH DIAMETER SHALL BE CONCENTRIC TO EACH OTHER WITHIN VALUES SPECIFIED FOR "Z" FIM (SEE TABLE I).
- /3/ GRIP LENGTH OF BOLT SHALL BE MEASURED FROM UNDERSIDE OF HEAD TO THE END OF FULL CYLINDRICAL PORTION OF SHANK.
- /4/ NATURAL FLOW OF MATERIAL PERMITTED TO A DIAMETER EQUAL TO "ØB".
- (5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (6) SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICROINCHES Ra PER ASME B46.1.
- (7) THE ULTIMATE TENSILE STRENGTH, DOUBLE SHEAR STRENGTH, FATIGUE TEST LOAD AND MINIMUM HEAD BEARING AREA SHALL BE IN ACCORDANCE WITH TABLE III.
- (8) THE BOLTS COVERED BY THIS PART STANDARD ARE FOR USE WHERE SHEAR LOADS (NOT TENSILE) ARE THE PRIMARY CONSIDERATION.
- (9) THE BOLTS ARE DESIGNED FOR USE WITH NUTS CONFORMING TO MIL-N-8985/2 AND WITH WASHERS CONFORMING TO NASM21299.
- (10) TOOLING SHALL BE IN ACCORDANCE WITH MS33787 AND MIL-W-8982.
- (11) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (12) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (13) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (14) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

① COMPLETELY REVISED

REVISION
1
NASM8906-2
SHEET 2