

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.

FORM 09-01

ISSUE DATE: APRIL 2002 REVISION DATE: SEPTEMBER 28, 2012

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FED. SUPPLY CLASS

5355

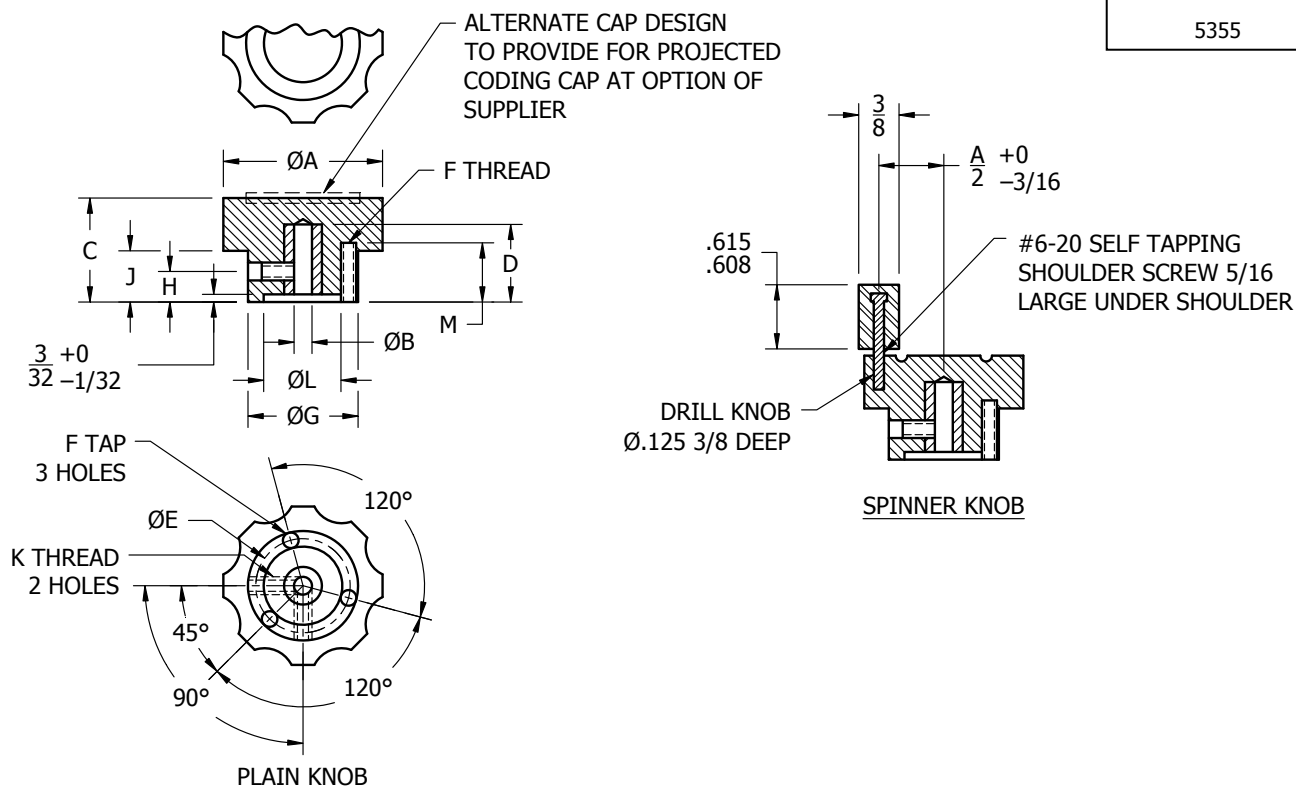


FIGURE 1 – BASIC KNOBS

TABLE I – BASIC KNOB DIMENSIONS

DASH NO.	ØA CAP	ØB SHAFT HOLE	C	D	ØE	F THREAD	ØG	H	J	K THREAD	ØL +0 -1/64	M
1N1B	3/4	.127	1/2	3/8 ± 1/16	-	-	5/8 +0 -1/64	5/32	1/4	#4-40 UNC-3B	3/8	-
1N1G		± .002										
1N2B												
1N2G												
2N2B	1 1/8	.252 ± .002	5/8	1/2 ± 1/16	9/32	#2-56 UNC-3B	13/16 +0 -1/64	7/32	11/32	#8-32 UNC-3B	15/32	1/4
2N2G												
3N2B	1 5/8		3/4	1/2 ± 1/8	13/32	#6-32 UNC-3B	1 1/8 +1/16 -1/64	1/4 +0 -1/64	3/8 +1/32 -0			
3N2G												
4N2B	2 3/8		7/8	1/2 ± 1/8	5/8	#6-32 UNC-3B	1 3/4 +0 -1/64	1/4	7/16			
4N2G												
4B2B												
4B2G												

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS91531, REVISION E. PART NUMBERS REMAIN MS91531.

THIRD ANGLE PROJECTION 	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NASM3926	TITLE 1 KNOBS, CONTROL, ROUND, PLASTIC, WITH FLUTED GRIP	CLASSIFICATION PART STANDARD NASM91531 SHEET 1 OF 8

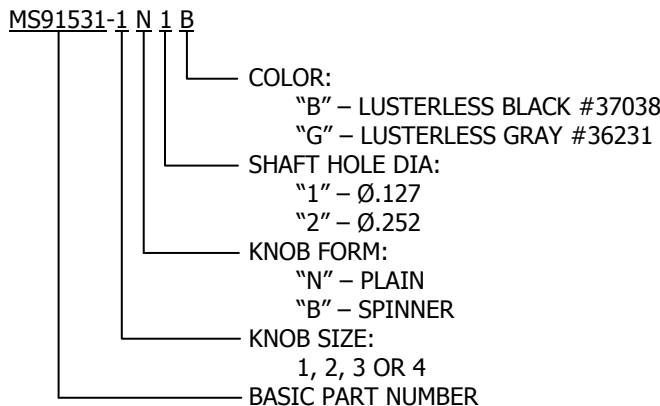
MATERIAL:

KNOB (INCLUDING SPINNER BODY), SKIRT, AND POINTER: PLASTIC, TYPE III, PER L-P-398
PS200A00301 OR PS211A00301 PER ASTM D4549; OR TYPE CFG, PER MIL-M-14 ASTM D5948.
DIAL PLATE: 5052 ALUMINUM (UNS A05052) PER QQ-A-250/8 AMS-QQ-A-250/8 OR 1100 ALUMINUM
(UNS A91100) PER QQ-A-250/4 ASTM B209, ALLOY 1100; OR BRASS PER QQ-B-613
ASTM B36/B36M OR ASTM B121/B121M.
KNOB INSERTS: BRASS, COMPOSITION 22 ALLOY 360 (UNS C36000) PER QQ-B-626 ASTM B16/B16M;
OR ALUMINUM ALLOY 7075-T6 (UNS A97075), PER QQ-A-277 AMS-QQ-A-200/11.
SPINNER INSERT: BRASS, COMPOSITION 22 ALLOY 360 (UNS C36000) PER QQ-B-626 ASTM B16/B16M.

FINISH:

DIAL PLATE: COLOR LUSTERLESS BLACK NO. 37038 PER FED-STD-595.
SET SCREWS: CADMIUM PLATING PER AMS-QQ-P-416, TYPE II, CLASS 3; OR ZINC PLATING PER ASTM B633, TYPE II, SC 1.
KNOB INSERTS: BRASS: CADMIUM PLATING PER AMS-QQ-P-416, TYPE II, CLASS 3, BEFORE ASSEMBLY; ALUMINUM ALLOY: ANODIZED PER MIL-A-8025, BEFORE ASSEMBLY.
SPINNER INSERT: GRADE G NICKEL MATTE FINISH PER AMS-QQ-N-290.

EXAMPLE OF PART NUMBER:



NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm .005$; ANGLES $\pm 1^\circ$; FRACTIONS $\pm 1/64$.
- (3) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (4) KNOBS ARE CORED OR SOLID. IF CORED, THE SET SCREWS MAY BE PLACED IN THE SUPPORTING RIBS.
- (5) REMOVE ALL BURRS AND BREAK SHARP EDGES OF UPPER GRIPPING SURFACES.
- (6) KNOB ASSEMBLIES MAY BE FURNISHED AS INTEGRAL UNITS OR AS ASSEMBLIES. WHEN 3/4 KNOBS ARE FURNISHED AS ASSEMBLIES, THE PARTS ARE CEMENTED TOGETHER. FOR ALL OTHER KNOBS, THE PARTS ARE FASTENED TOGETHER BY SCREWS AS SHOWN ON SHEET 6. FOR POINTER KNOBS, THE SCREW ASSEMBLY MAY BE OMITTED, AND THE INSERTS SPUN OVER. IN WHICH CASE THEY ARE STAKED.

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REVISION

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NASM91531 Documents

SHEET 2

- (7) SET SCREWS: TYPE I, STYLE 4, PER FF-S-200; NO. #4-40 UNC-3A IS USED FOR ALL 3/4 KNOBS, AND FOR 1/8 SHAFTS; NO. #8-32 UNC-3A IS USED FOR 1/4 SHAFTS; 3/16 LONG FOR 3/4 KNOBS, 1/4 LONG FOR 1 1/8 KNOBS, 5/16 LONG FOR 1 5/8 KNOBS, AND 3/8 LONG FOR 2 3/8 KNOBS.
- (8) ASSEMBLY SCREWS: PAN HEAD; PART NUMBER MS35214-3 FOR 1 1/8 KNOBS, AND PART NUMBER MS35214-25 FOR ALL OTHER SIZE KNOBS.
- (9) INSERT-WALL THICKNESS: 1/16 MINIMUM FOR 3/4 AND 1 1/8 KNOBS, AND 1/8 MINIMUM FOR 1 5/8 AND 2 3/8 KNOBS. INSERTS ARE OPEN END OR CLOSED END.
- (10) TORQUE TEST: 25 LBF-IN FOR ALL KNOBS UP TO AND INCLUDING 1 1/8 NOMINAL BODY DIAMETER AND 50 LBF-IN FOR ALL KNOBS ABOVE 1 1/8 NOMINAL BODY DIAMETER. FOR ALL DIAMETER KNOBS WITH SPINNERS, A 50 LBF-IN IS APPLIED TO THE END OF THE SPINNER HANDLE, PERPENDICULAR TO THE PLANE OF THE TWO AXES.
- (11) THE IMPACT TEST SHALL BE IN ACCORDANCE WITH ASTM D4549 OR ASTM D5948, AS APPLICABLE, IN LIEU OF THE IMPACT TEST OF NASM3926.
- (12) 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.
- (13) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (14) QUALIFICATION NOT APPLICABLE.
- (15) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

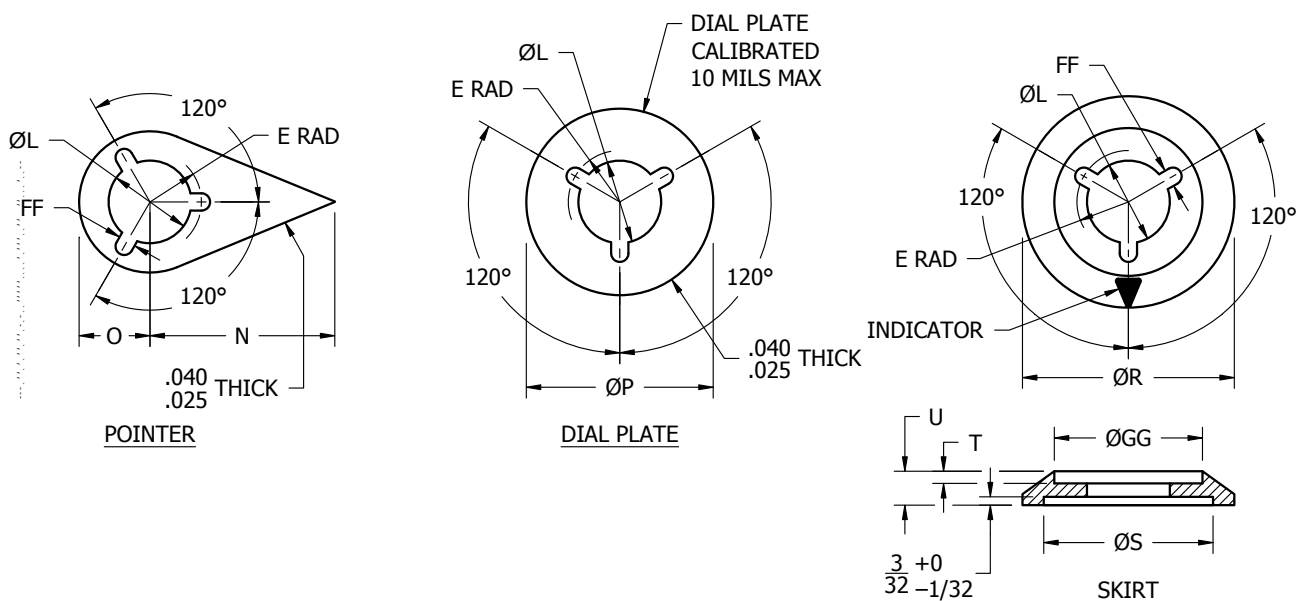


FIGURE 2 - ACCESSORIES

REVISION
1
NASM91531
SHEET 3

