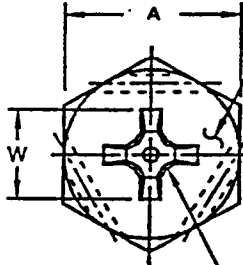


FED SUP CLASS
5305

HEAD MARKING: NAS1802-04, -06, -08 AND 3 PER NAS1347, TYPE I. NAS1802-4, -5 AND -6, BASIC PART NO, DIAMETER DASH NO, AND MANUFACTURE'S SYMBOL EXCEPT LETTERS "NAS" MAY BE ELIMINATED ON -4 SIZE.



6 CRUCIFORM RECESS PER NASM9006 (6)

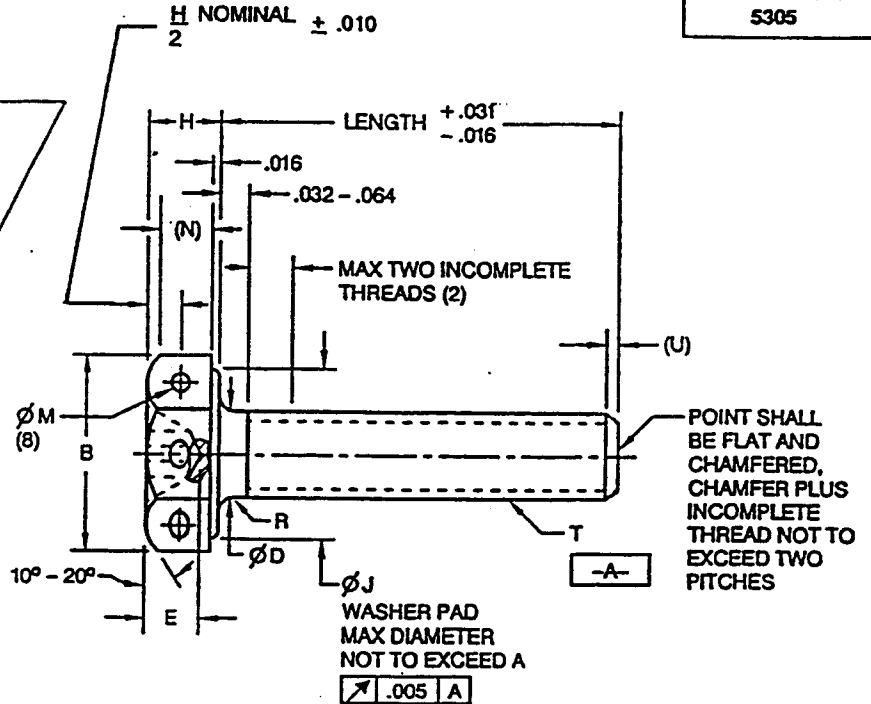


TABLE I

FIRST DASH NO	T NOMINAL THREAD SIZE PER MIL-S-8879	A HEX	B MIN	Ø D	H	Ø J (1)	Ø M +.010 -.000	(N)	R	(U)	W	E PENE-TRATION (5)	RECESS SIZE (5)
04	.1120-40 UNJC-3A	.189 .181	.207	.112 .094	.060 .049	.156	---	.032	.015 .005	.031	.116 .103	.071 .055	1
06	.1380-32 UNJC-3A	.251 .243	.277	.138 .115	.093 .080	.210	---	.050	.015 .005	.039	.154 .141	.075 .052	2
08	.1640-32 UNJC-3A	.251 .243	.277	.164 .141	.110 .096	.210	---	.056	.015 .005	.039	.169 .156	.090 .067	2
3	.1900-32 UNJF-3A	.314 .305	.348	.190 .167	.120 .105	.272	.046	.062	.020 .010	.039	.184 .171	.105 .082	2
4	.2500-28 UNJF-3A	.376 .367	.410	.250 .224	.140 .125	.335	.046	.073	.020 .010	.045	.247 .234	.118 .095	3
5	.3125-24 UNJF-3A	.439 .429	.480	.312 .282	.171 .156	.398	.070	.102	.020 .010	.052	.317 .304	.148 .126	4
6	.3750-24 UNJF-3A	.502 .492	.552	.375 .345	.203 .188	.460	.070	.131	.025 .015	.052	.342 .329	.173 .151	4

LIST OF CURRENT SHEETS

SHT.	REV.
1	6
2	6



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CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE



PROCUREMENT SPECIFICATION NOTED

TITLE
SCREW, HEX HEAD, CRUCIFORM RECESS, FULL
THREAD A286 CRES, 160,000 PSI TENSILE

CLASSIFICATION
STANDARD PART

NAS1802

SHEET 1 OF 2

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APPROVAL DATE MARCH 1977 REVISION 1 30 DEC 1981 2 30 NOV 1983 3 18 APRIL 1980 4 3 JUNE 1984 5 5 Dec. 1996 6 9 SEP 1999

MATERIAL: CRES - A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.

FINISH: PASSIVATE PER QQ-P-35, TYPE OPTIONAL
CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. POST-PLATE HYDROGEN
EMBRITTLMENT BAKING AND TESTING PER QQ-P-416 ARE NOT REQUIRED FOR A286
MATERIAL.

HEAT TREAT: DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER MIL-H-6875.
160-190 KSI Flu. PRECIPITATION HARDENING PER AMS5853. (11)

CODE: FIRST DASH NUMBER INDICATES DIAMETER PER TABLE I.
DASH (-) FOLLOWING FIRST DASH NUMBER INDICATES UNDRILLED HEAD.
LETTER 'D' FOLLOWING FIRST DASH NUMBER INDICATES DRILLED HEAD.
(-3 THRU -6 SIZES ONLY).
SECOND DASH NUMBER INDICATES LENGTH IN .0625 INCREMENTS.
LETTER 'P' FOLLOWING SECOND DASH NUMBER INDICATES CADMIUM PLATE.

EXAMPLE OF PART NUMBER: NAS1802-4-16 - 2500-28 UNJF-3A SCREW, 1.000 LONG, PASSIVATED.
NAS1802-04-12 - .1120-40 UNJC-3A SCREW, .750 LONG, PASSIVATED.
NAS1802-4D16 - 2500-28 UNJF-3A SCREW, DRILLED HEAD, 1.000 LONG,
PASSIVATED.
NAS1802-4D16P - 2500-28 UNJF-3A SCREW, DRILLED HEAD, 1.000 LONG,
CADMIUM PLATED.

NOTES:

- ⑥ 1. TOLERANCES: $\pm .010$, ANGLES ± 1 DEGREE UNLESS OTHERWISE NOTED.
 2. COMPLETE THREAD LENGTH FOR SCREWS LONGER THAN 2.000 SHALL BE 1.750 MINIMUM.
 - ⑥ 3. SURFACE TEXTURE PER ASME B46.1: HEAD TO SHANK FILLET, THREAD FLANKS AND
THREAD ROOT 32 MICROINCHES Ra; BEARING SURFACE OF HEAD 63 MICROINCHES Ra;
OTHER SURFACES 125 MICROINCHES Ra.
 4. DIMENSION IN INCHES UNLESS OTHERWISE SPECIFIED.
 - ⑥ 5. GAGING OF THE CRUCIFORM RECESS SHALL BE IN ACCORDANCE WITH NASM9006, GAGE
PENETRATION NOTED ABOVE.
 6. ORIENTATION OF RECESS SLOTS TO HEX IS OPTIONAL
 7. SCREWS SHALL BE FREE FROM BURRS AND SLIVERS.
 8. DRILL "M" DIAMETER, THREE HOLES WITHIN .010 OF CENTER OF HEX FLAT WHEN
SPECIFIED BY PART NUMBER, -3 THRU -6 SIZES ONLY.
 9. MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH
H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342, METHOD 6.
 10. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.
 - ⑥ 11. THE EFFECT OF COLD WORK AND AGING INDUCED DURING THE MANUFACTURING CYCLE MAY INCREASE THE
ULTIMATE TENSILE STRENGTH OF THE FINISHED PART, BUT THIS SHALL NOT EXCEED 1.3 TIMES THE TYPE I
LOAD AS SPECIFIED IN NAS4003.
- ⑥ **PROCUREMENT SPECIFICATION:** NAS4003 EXCEPT AS NOTED. COLD WORKING OF HEAD TO SHANK FILLET
RADIUS, THREAD ROLLING AFTER HEAT TREAT. RECESS TORQUE VALUES AND
WRENCH TORQUE TESTING NOT REQUIRED. ~~USE NAS4003 LOT PACKAGING—
AND FOR TENSILE VALUES FOR SCREWS SMALLER THAN 1.000 32.~~

NAS 1802

SHEET 2

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APPROVAL DATE: MARCH 1977 REVISION (5) 5 Dec. 1996 (6) 9 SEP 1999