

## NAS 1832

### INSERT, MOLDED IN, THREADED, SANDWICH PANEL

APPLICATIONS: SELF LOCKING AND NON SELF LOCKING THREADS

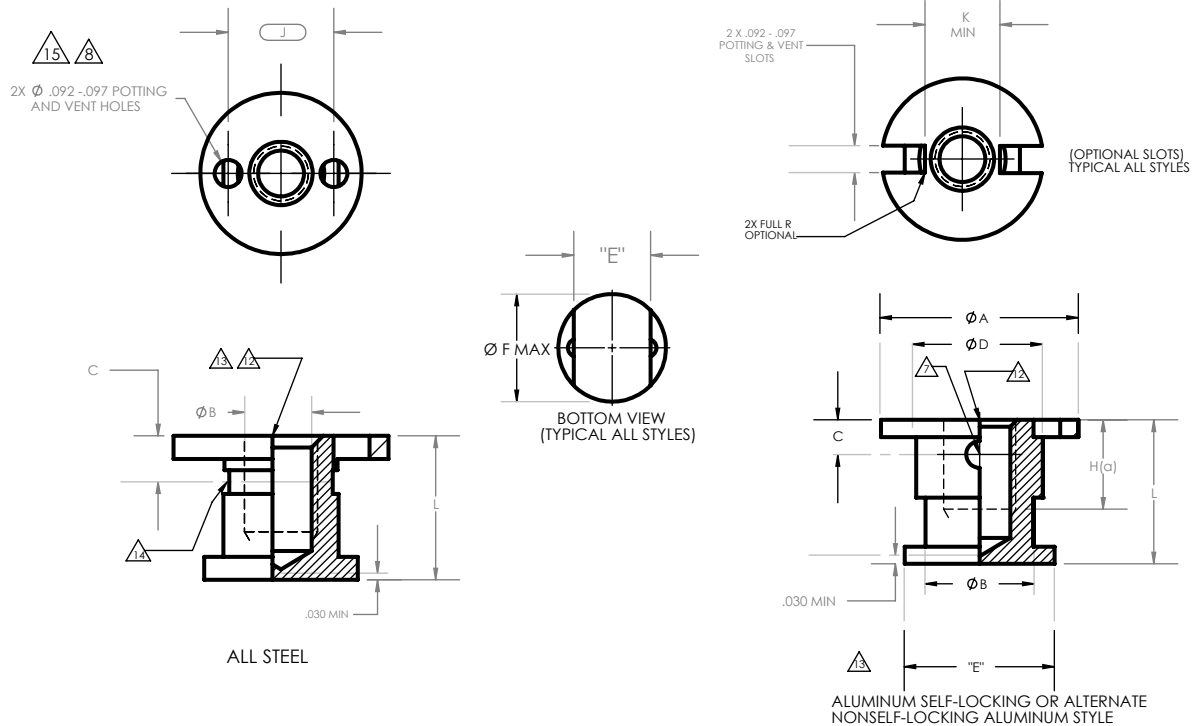


TABLE 1

FIRST DASH NO.	THREAD CLASS 3B MINOR DIA	$\varnothing A$ +.000 -.010	$\varnothing B$	C	$\varnothing D$	E	$\varnothing F$ MAX	H(a) MIN	J BASIC	K MIN	L(b) MIN	INSTALLATION HOLE SIZE
-06	.1380-32 UNJC	.560	.300	.12	.375	.400	.560	.250	.367	.260	.37	.561 - .566
-08	.1640-32 UNJC	.560	.300	.12	.375	.400	.560	.250	.367	.260	.37	.561 - .566
-3	.1900-32 UNJF	.560	.300	.12	.375	.400	.560	.250	.367	.260	.37	.561 - .566
-4	.2500-28 UNJF	.685	.375	.14	.440	.520	.685	.310	.467	.360	.50	.686 - .691
-5	.3125-24 UNJF	.685	.475	.16	.500	.520	.685	.310	.467	.360	.50	.686 - .691
-6	.3750-24 UNJF	.841	.500	.22	.550	.560	.841	.370	.591	.484	.50	.842 - .847

(a) MINIMUM THREAD "H" IN SHORT LENGTHS. MINIMUM THREAD "H" WHERE LENGTH PERMITS SHALL BE 2X DIAMETER OF THREAD.

(b) MINIMUM LENGTH WHICH MAY BE SPECIFIED.

MATERIAL: CARBON STEEL PER ASTM-A-108. ASTM-A-576 OR MATERIAL COMPOSITION PER FED-STD-66, ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM. ALUMINUM ALLOY, GRADE 2024 (UNS AS2024), TEMPER T4 OR T351 PER QQ-A-225/6.  
CORROSION RESISTANT STEEL, TYPE 303 (UNS 30300 PER ASTM-A-582. NONMETALLIC LOCKING ELEMENT - POLYAMIDE PER FED SPEC L-P-410.

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**FINISH:** CARBON STEEL - CADMIUM PLATE PER SAE-AMS QQ-P-416, TYPE 2, CLASS 2.  
ALUMINUM ALLOY - ANODIZE PER MIL-A-8625 TYPE 1, CLASS OPTIONAL.  
CRES - PASSIVATE PER ASTM-A-967, SILVER PLATE PER AMS2410 OR AMS2411  
OR CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE 2, CLASS 2.  
SOLID FILM LUBRICANT PER AS5272, TYPE 1, APPLIED TO THREADS ONLY.

**CODING:** NO LETTER AFTER BASIC NUMBER INDICATES CARBON STEEL, CADMIUM PLATED.  
SUFFIX A TO BASIC NUMBER INDICATES AL ALLOY, ANODIZED.  
SUFFIX C TO BASIC NUMBER INDICATES CRES. PASSIVATED.  
FIRST DASH NUMBER INDICATES NOMINAL THREAD SIZE, SEE TABLE 1.  
SUFFIX N TO FIRST DASH NUMBER INDICATES NON SELF-LOCKING.  
SECOND DASH NUMBER INDICATES LENGTH IN .125 INCREMENTS. SEE NOTE 6.  
NO LETTER AFTER SECOND DASH NUMBER FOR CRES INDICATES PASSIVATE ONLY.  
SEE NOTE 5.  
SUFFIX M TO SECOND DASH NUMBER INDICATES SOLID FILM LUBRICANT.  
SEE NOTE 5.  
SUFFIX P TO SECOND DASH NUMBER INDICATES CADMIUM PLATE ON CRES INSERT.  
SEE NOTE 5.  
SUFFIX S TO SECOND DASH NUMBER INDICATES SILVER PLATE ON CRES INSERT.  
SEE NOTE 5.

**EXAMPLE OF PART NUMBER:**

NAS 1832-3-4M .1900-32 UNJF -3B THREAD, CARBON STEEL, CADMIUM PLATED  
WITH MOLYCOAT 3402C LUBRICANT, .500 LONG, SELF-LOCKING.

NAS 1832A3N4 .1900-32 UNJF -3B THREAD, ALUMINUM ALLOY, ANODIZED, .500 LONG  
NONSELF LOCKING.

NAS 1832CO8-3S .1640-32 UNJC -3B THREAD, CRES, SILVER PLATED, .375 LONG.  
SELF-LOCKING.

NAS 1832C08-3P .2500-28 UNJF -3B THREAD, CRES, PASSIVATED, .625 LONG  
NONSELF-LOCKING

NAS 1832C4N5 .2500-28 UNJF -3B THREAD, CARBON STEEL, CADMIUM PLATED, 1.250  
LONG, SELF-LOCKING.

**NOTES:**







1. THREADS PER MIL-S-8879.
2. LOCKING TORQUE PER MIL-DTL 25027 EXCEPT SELF-LOCKING. CORROSION RESISTANT STEEL INSERT WITHOUT PLATING OR LUBRICANT WILL BE TESTED USING A SILVER PLATED BOLT OR SCREW.

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## NOTES CONT'D:

## 3. TOLERANCES UNLESS OTHERWISE SPECIFIED:

XXX =  $\pm 0.010$ XX =  $\pm 0.02$ 

4. AN ADHESIVE-BACKED INSTALLATION TAB NAS 1837 (PLASTIC PER WITTEN 2007) SHALL BE FURNISHED WITH EACH INSERT.
5. PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.
6. SELECT A LENGTH WHICH WILL ALLOW A MINIMUM OF .040 CLEARANCE BETWEEN BOTTOM OF INSERT AND INSIDE SURFACE OF BOTTOM SKIN.
7.  NONMETALLIC THREAD LOCK WHEN APPLICABLE. LOCATE A PELLET NO CLOSER THAN 10° FROM EDGE OF EITHER POTTING HOLE OR SLOT.
8.  BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.
9. DIMENSIONING AND TOLERANCING PER ANSI Y 14.5M-1982.
10. DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED.
11. NOT USED.
12.  MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
13.  CENTERLINE OF THREAD LOCK WHEN APPLICABLE.
14.  SHANK DEFORMED IN THIS AREA TO PROVIDE THREAD LOCK WHEN APPLICABLE.
15.  POTTING & VENT HOLES OR SLOTS (MANUFACTURER'S OPTION).
16. ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUNOUT TO DATUM A.
17. DIMENSIONAL LIMITS APPLY AFTER PLATING, PRIOR TO SOLID FILM LUBE.