

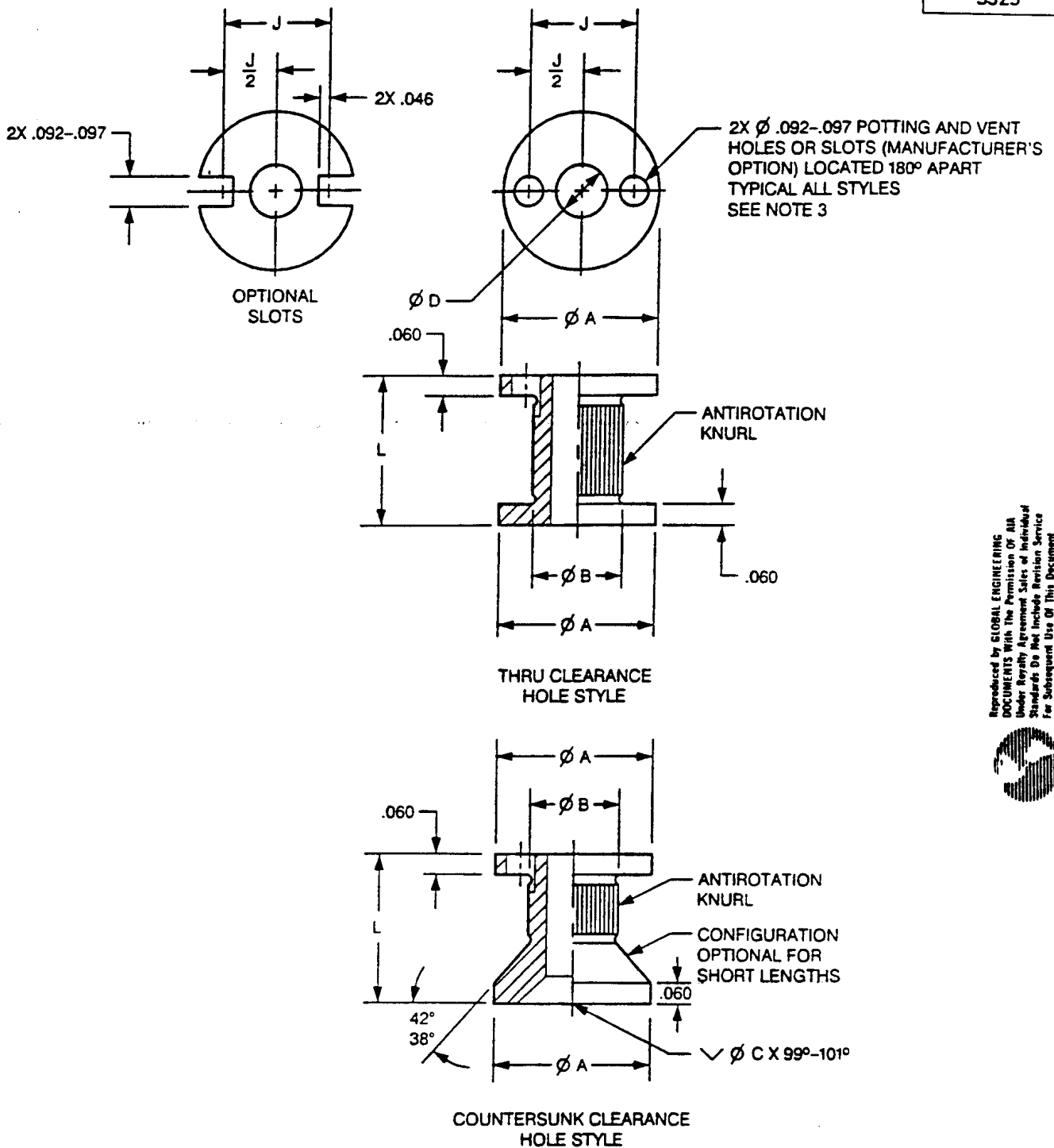


Aerospace Industries Association

NATIONAL AEROSPACE STANDARD

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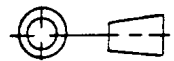
④ COMPLETELY REVISED

LIST OF CURRENT SHEETS

SHT.	REV.
1	4
2	NEW

CUSTODIAN **NATIONAL AEROSPACE STANDARDS COMMITTEE**

THIRD
ANGLE
PROJECTION



PROCUREMENT
SPECIFICATION

NONE

TITLE

**INSERT, MOLDED IN, CSK AND THRU CLEARANCE
HOLE, SANDWICH PANEL**

CLASSIFICATION
STANDARD PART

NAS1834

SHEET 1 OF 2

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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

APPROVAL DATE JUNE 1970 REVISION ① 15 JULY 1974 ② 30 OCTOBER 1981 ③ 11 MARCH 1992 ④ 25 FEBRUARY 1994

TABLE I

FIRST DASH NO	Ø A + .000 - .010	Ø B	Ø C	Ø D (CLEARANCE HOLE)	J	L (a) MIN	INSTALLATION HOLE SIZE
-06	.560	.300	.280	.139-.145	.367	.250	.561-.566
-08	.560	.300	.332	.168-.174	.367	.250	.561-.566
-3	.560	.300	.385	.195-.201	.367	.250	.561-.566
-4	.685	.375	.507	.256-.263	.467	.312	.686-.691
-5	.685	.475	.625	.315-.322	.467	.312	.686-.691
-6	.841	.500	.750	.376-.383	.591	.375	.842-.847

(a) MINIMUM LENGTH WHICH MAY BE SPECIFIED.

MATERIAL: CARBON STEEL, IN ACCORDANCE WITH ASTM A 108, ASTM A 576 OR MATERIAL COMPOSITION PER FED-STD-66, ULTIMATE TENSILE STRENGTH 85,000 PSI MINIMUM.
AL ALLOY, GRADE 2024 (UNS A92024), TEMPER T4 OR T351 PER QQ-A-225/6.
CORROSION RESISTANT STEEL, TYPE 303 (UNS S30300) IN ACCORDANCE WITH ASTM A 582.

FINISH: CARBON STEEL - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
AL ALLOY - ANODIZE PER MIL-A-8625, TYPE I, CLASS OPTIONAL.
CRES - PASSIVATE PER QQ-P-35, TYPE II.

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 CLEARANCE HOLE SIZE. SEE TABLE I.
SUFFIX K TO FIRST DASH NUMBER INDICATES COUNTERSUNK TYPE.
SECOND DASH NUMBER INDICATES LENGTH IN THOUSANDTHS.

EXAMPLE OF PART NUMBER:

NAS1834-3-500 CARBON STEEL, CADMIUM PLATED, .500 LONG, WITH THRU CLEARANCE HOLE FOR Ø .1900 BOLT
NAS1834C4-500 CRES, PASSIVATED, .500 LONG, WITH THRU CLEARANCE HOLE FOR Ø .2500 BOLT
NAS1834C4K500 CRES, PASSIVATED, .500 LONG, WITH COUNTERSUNK CLEARANCE HOLE FOR Ø .2500 BOLT

NOTES:

- TOLERANCES UNLESS OTHERWISE SPECIFIED:
.XXX - ± .010
.XX - ± .02
- AN ADHESIVE-BACKED INSTALLATION TAB NAS1837 (ALUMINUM OR PLASTIC) SHALL BE FURNISHED WITH EACH INSERT.
NOTE: WHEN TAB MATERIAL PREFERENCE IS DESIRED, PROCURING ACTIVITY SHALL SPECIFY.
- BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.
- DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED.

NAS1834

SHEET 2

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