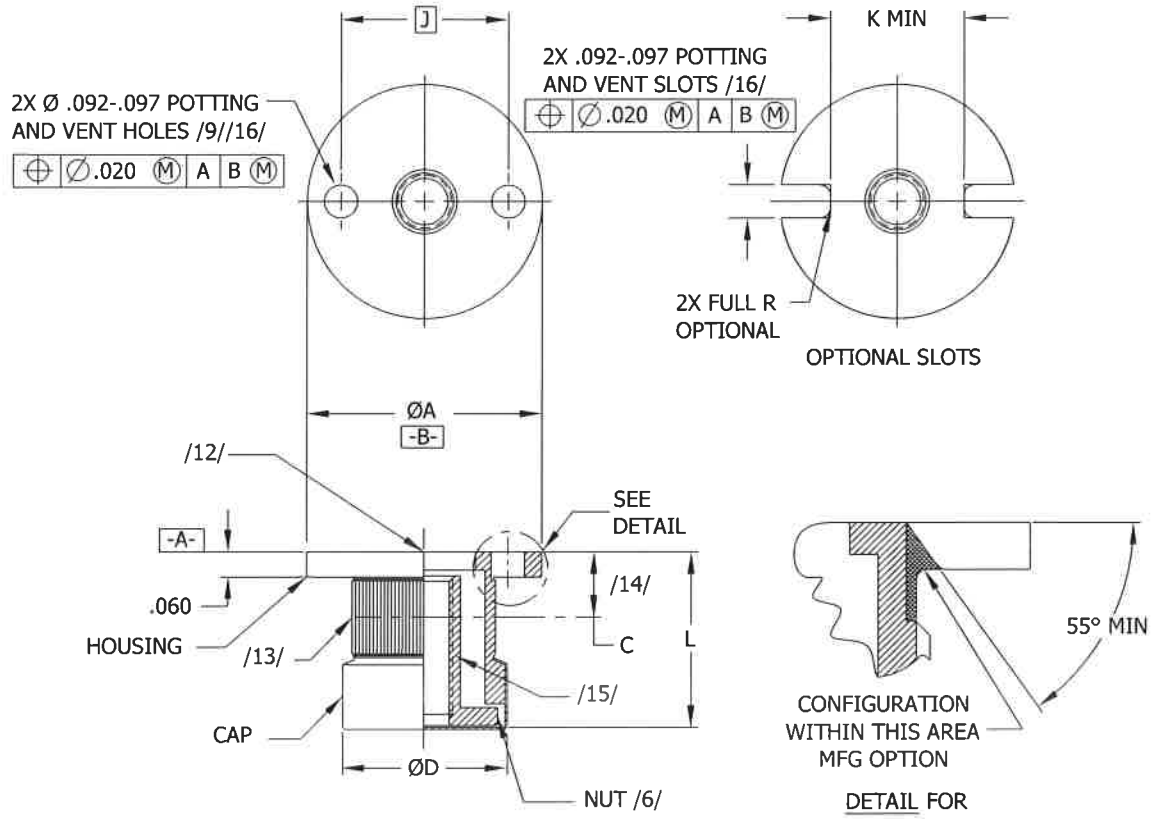
NATIONAL AEROSPACE STANDARD

FED.SUPPLY CLASS
5325



(8) COMPLETELY REVISED

TABLE I – DIMENSIONS

FIRST DASH NO.	THREAD CLASS 3B	ØA +.000 -.010	C	ØD MAX	J BASIC	K MIN	L /7/	INSTALLATION HOLE SIZE
08	.1640-32 UNJC	.685	.16	.545	.500	.393	.37	.686-.691
3	.1900-32 UNJF	.685	.16	.545	.500	.393	.43	.686-.691
4	.2500-28 UNJF	.748	.18	.735	.591	.484	.56	.749-.755
5	.3125-24 UNJF	.810	.20	.800	.655	.548	.75	.811-.817
6	.3750-24 UNJF	.873	.22	.865	.718	.611	.81	.874-.880

REVISION DATE: NOVEMBER 30, 2010
ISSUE DATE: JUNE 1960

THIRD ANGLE PROJECTION	CUSTODIAN	REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE	8
PROCUREMENT SPECIFICATION: NONE	TITLE: **INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING, NONSELF-LOCKING, FLOATING, SANDWICH PANEL**	CLASSIFICATION PART STANDARD: **NAS1835**
		SHEET 1 OF 3

MATERIAL:

NUT: CARBON STEEL PER ASTM A 108, ASTM A 576, OR MATERIAL COMPOSITION PER AIR4127 ~~FED-STD-66,~~ ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.
CORROSION RESISTANT STEEL TYPE 303 (UNS S30300) PER ASTM A 582/A 582M.

HOUSING: CARBON STEEL PER ASTM A 108, ASTM A 576, OR MATERIAL COMPOSITION PER AIR4127 ~~FED-STD-66,~~ ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.
AL ALLOY, GRADE 2024 (UNS A92024), TEMPER T4 OR T351 PER AMS-QQ-A-225/6.
CORROSION RESISTANT STEEL, TYPE 303 (UNS S30300) PER ASTM A 582/A 582M.

CAP: AL ALLOY, GRADE 3003-O, 3003-H14 (UNS A93003) PER ~~QQ-A-250/2~~, ASTM B 209, 5052-O, 5052-H32 (UNS A95052) PER AMS-QQ-A-250/8, OR 6061-O (UNS A96061) PER ~~QQ-A-250/11~~ AMS4025.

FINISH:

CARBON STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
AL ALLOY - HOUSING - ANODIZE PER MIL-A-8625, TYPE I, CLASS OPTIONAL.
AL ALLOY - CAP - ANODIZE PER MIL-A-8625, TYPE I, CLASS OPTIONAL OR COAT PER MIL-DTL-5541, CLASS 3 OR CLASS 1A.
CRES - PASSIVATE PER AMS2700, METHOD I, CLASS 4; SILVER PLATE PER AMS2410 OR AMS2411; OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. SOLID FILM LUBRICANT PER AS5272 TYPE I, APPLIED TO NUT ONLY.

CODE:

NO LETTER AFTER BASIC NUMBER INDICATES CARBON STEEL NUT AND HOUSING, CADMIUM PLATED.
SUFFIX "A" TO BASIC NUMBER INDICATES CARBON STEEL NUT, CADMIUM PLATED AND AL ALLOY HOUSING, ANODIZED.
SUFFIX "C" TO BASIC NUMBER INDICATES CRES NUT AND HOUSING, PASSIVATED.
FIRST DASH NUMBER INDICATES NOMINAL THREAD SIZE, SEE TABLE I.
NO LETTER AFTER DASH NUMBER FOR CRES INDICATES PASSIVATE ONLY. /5/
SUFFIX "M" TO DASH NUMBER INDICATES SOLID FILM LUBRICANT ON NUT. /5/
SUFFIX "N" TO DASH NUMBER INDICATES NONSELF-LOCKING.
SUFFIX "P" TO DASH NUMBER INDICATES CADMIUM PLATE ON CRES NUT. /5/
SUFFIX "S" TO DASH NUMBER INDICATES SILVER PLATED CRES NUT. /5/

EXAMPLE OF PART NUMBER:

NAS1835-3M - .1900-32 UNJF-3B THREAD, CARBON STEEL NUT AND HOUSING, CADMIUM PLATED WITH SOLID FILM LUBRICANT ON NUT, SELF-LOCKING.

NAS1835A3N - .1900-32 UNJF-3B THREAD, CARBON STEEL NUT, CADMIUM PLATED, NONSELF-LOCKING, AL ALLOY ANODIZED HOUSING.

NAS1835C4S - .2500-28 UNJF-3B THREAD, CRES NUT AND HOUSING, PASSIVATED, SILVER PLATED NUT, SELF-LOCKING.

NAS1835C4P - .2500-28 UNJF-3B THREAD, CRES NUT AND HOUSING, PASSIVATED, CADMIUM PLATED NUT, SELF-LOCKING.

(8) COMPLETELY REVISED

NOTES:

(1) THREADS PER AS8879.

(2) LOCKING TORQUE PER NASM25027 EXCEPT SELF-LOCKING, CORROSION RESISTANT STEEL INSERT WITHOUT PLATING OR LUBRICANT WILL BE TESTED USING A SILVER PLATED BOLT OR SCREW.

(3) TOLERANCES UNLESS OTHERWISE SPECIFIED:
.XXX - ±.010
.XX - ±.02

(4) AN ADHESIVE-BACKED INSTALLATON TAB NAS1837 (ALUMINUM OR PLASTIC) SHALL BE FURNISHED WITH EACH INSERT. NOTE: WHEN TAB MATERIAL PREFERENCE IS DESIRED, PROCURING ACTIVITY SHALL SPECIFY.

/5/ PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.

/6/ MINIMUM RADIAL FLOAT .032.

/7/ MAXIMUM BOLT ENGAGEMENT SHOULD NOT EXCEED "L" MINUS .060.

~~(8) LOCATE PELLET NO CLOSER THAN 10° FROM EDGES OF EITHER POTTING HOLE.~~

/9/ BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.

(10) DIMENSIONING AND TOLERANCING PER ANSI ASME Y14.5M-1982.

(11) DIMENSIONS IN INCHES.

/12/ MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.

/13/ STRAIGHT OR DIAMOND ANTIROTATION KNURL (MANUFACTURER'S OPTION).

/14/ CENTERLINE OF THREAD LOCK WHEN APPLICABLE.

/15/ SHANK DEFORMED THIS AREA TO PROVIDE THREAD LOCK WHEN APPLICABLE.

/16/ POTTING AND VENT HOLES OR SLOTS (MANUFACTURER'S OPTION).

(17) DIMENSIONAL LIMITS APPLY AFTER PLATING, AND PRIOR TO SOLID FILM LUBE.

(18) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

(19) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

(20) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

(8) COMPLETELY REVISED