NATIONAL AEROSPACE STANDARD

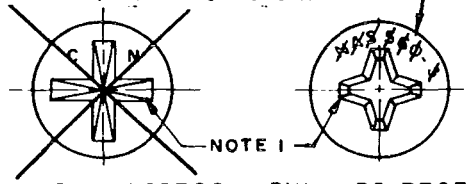
AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 610 SHOREHAM BUILDING, WASHINGTON 5, D. C.

FED SUP CLASS 5305

DEPRESSED HEAD MARKING PER NAS 1347, TYPE IV

~~HEAD MARKING: BASIC PART NO. AND APPLICABLE DASH NO. DEPRESSED DIG MAX MANUFACTURERS TRADE MARK MAY BE ADDED. FOR "H" CODE PARTS, NO CODE LETTER REQUIRED FOR "X" CODE PARTS, ADD "X" TO BASIC NUMBER FOR "C" CODE PARTS, ADD "C" TO BASIC NUMBER~~

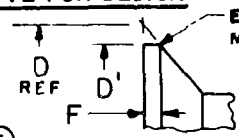
THIS HEAD MARKING MAY BE FURNISHED FROM SUPPLIERS STOCK UNTIL JUNE 30 1981



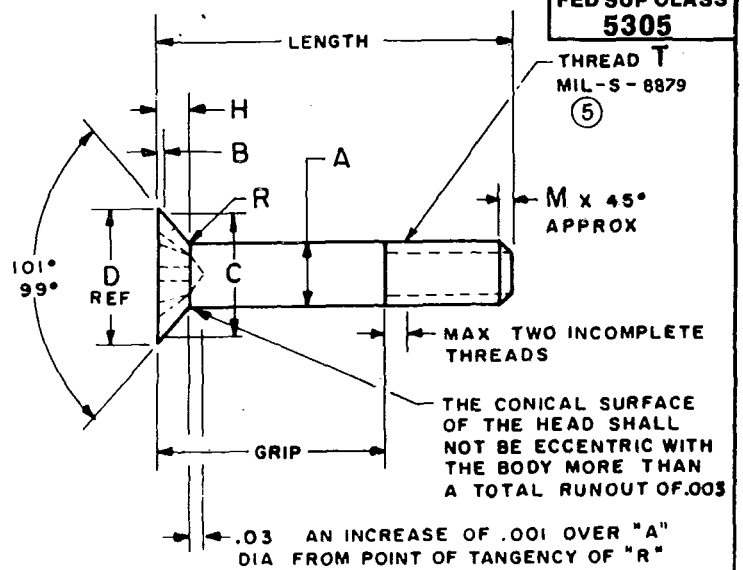
FREARSON RECESS CODE "F"

PHILLIPS RECESS CODE "K"

INACTIVE FOR DESIGN



(5)



FIRST DASH NO.	THREAD T CLASS 3A ~~(*CLASS 2A)~~	A DIA		B HEAD PROTRUSION		C GAGE CIRCLE +.0000 -.0004	D DIA(REF)		D' DIA	F	H NOM REF	M	R RAD.	
		MAX	MIN	MAX	MIN		MAX SHARP	MIN SHARP	ABS MIN WITH MAX F	MAX		MAX	MAX	MIN
-2	.1640-32UNJC	.1640	.1610	.0276	.0238	.2671	.334	.323	.287	.015	.068	.031	.020	.010
-3	.1900-32UNJF	.1890	.1860	.0299	.0259	.3147	.387	.375	.337	.016	.080	.031	.020	.010
-4	.2500-28UNJF	.2490	.2460	.0353	.0307	.4245	.510	.496	.452	.018	.106	.031	.020	.010
-5	.3125-24UNJF	.3115	.3085	.0409	.0357	.5389	.638	.622	.572	.021	.133	.047	.025	.010
-6	.3750-24UNJF	.3740	.3710	.0466	.0407	.6532	.766	.748	.692	.023	.159	.047	.030	.015
-7	.4375-20UNJF	.4365	.4325	.0522	.0457	.7676	.894	.874	.812	.026	.186	.047	.035	.015
-8	.5000-20UNJF	.4990	.4950	.0578	.0507	.8820	1.022	1.000	.932	.028	.213	.047	.040	.020
-9	.5625-18UNJF	.5615	.5575	.0633	.0557	.9964	1.150	1.126	1.052	.031	.240	.047	.045	.020

MATERIAL: (5)
CODE "C": CRES, QQ-S-763, CLASS 304 CONDITION A, CLASS 321 OR 347 CONDITION A, OR CRES, ANSI/ASTM-A 493, TYPE 384 (ULT TS OF MATERIAL 75,000 PSI AT ROOM TEMPERATURE)
CODE "H": CRES, AMS5735 (A-286) ~~OR AMS5733 (DISCALOY)~~ EXCEPT ULT TS OF MATERIAL 140,000 PSI MIN AT ROOM TEMPERATURE, ~~FABRICATED TO SPEC AMS7478~~
CODE "X": CRES, AMS5668 (INCONEL "X") (ULT TS 160,000 PSI MIN) AT ROOM TEMPERATURE

FINISH: FLASH CADMIUM PLATE .0001 MAX WHEN CODED "P" (NO PLATING FOR APPLICATIONS OVER 550°F)

CODE:
FIRST DASH NO. DESIGNATES NOMINAL DIAMETER (SEE TABLE ABOVE)
SECOND DASH NO. DESIGNATES GRIP AND LENGTH (SEE SHEET 2)
ADD "C" AFTER BASIC PART NO. TO INDICATE LOW STRENGTH SCREWS
ADD "H" AFTER BASIC PART NO. TO INDICATE HIGH TEMPERATURE SCREWS
ADD "X" AFTER BASIC PART NO. TO INDICATE HIGH STRENGTH SCREWS
ADD "K" AFTER MATERIAL CODE TO INDICATE PHILLIPS RECESS
~~ADD "F" AFTER MATERIAL CODE TO INDICATE FREARSON RECESS~~
ADD "P" AFTER FIRST DASH NO. TO INDICATE FLASH CADMIUM PLATING

(5) INACTIVE FOR DESIGN AFTER 25 June 1980. NO SUPERSEDING STANDARD

EXAMPLE OF PART NO.: NAS560CK3P12 = NON MAGNETIC, LOW STRENGTH, PHILLIPS RECESS, FLASH CADMIUM PLATED, .1900 DIA SCREW, .750 GRIP (5)

NOTES:
~~1. DIMENSIONING AND GAGING SIZES FOR THE ABOVE TYPES OF RECESSES SHALL CONFORM TO THE 1950 SUPPLEMENT TO HANDBOOK H 28 SCREW THREADS FOR FEDERAL SERVICES 1944.~~
1. PHILLIPS RECESS SHALL CONFORM TO MS9006.
2. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND NOT AN INSPECTION REQUIREMENT
3. REFER TO NAS518 AND NAS519 FOR FLUSHNESS GAGING DETAILS. HEAD PROFILE GAGES MAY BE USED BASED ON "B" AND "C" DIMENSIONS
4. MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH "H" = 200 OERSTEDS (MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT)
(5) 5. UNLESS OTHERWISE NOTED HEREON MIL-S-7839 SHALL BE APPLICABLE TO CODE "C" SCREWS. AMS7478 OR AMS7479 SHALL BE APPLICABLE TO CODE "H" AND "X" SCREWS. STRESS RUPTURE IS NOT APPLICABLE TO "H" AND "X" SCREWS.
6. DIMENSIONS IN INCHES
(5) 7. BOLT MANUFACTURERS MAY SUPPLY BOLTS WITH MIL-S-7742 THREADS, INCLUDING .1640-32UNC-2A, UNTIL JUNE 30, 1981. BOLTS WITH MIL-S-7742 THREADS MAY BE USED TO DEPLETION.

LIST OF ACTIVE SHEETS	
SHEET NO.	REV NO.
1	5
2	4

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION
NOTED	SCREW-MACHINE, NON MAGNETIC HIGH TEMPERATURE, STRUCTURAL, 100° FLUSH HEAD	STANDARD PART
		NAS 560 SHEET 1 OF 2

APPROVAL DATE 13 Jan. 1956 REVISION (1) 31 July 1958 (2) 30 Nov. 1958 (3) 15 Aug. 1961 (4) 15 Nov. 1979 (5) 25 JUNE 1980

Published and distributed by: National Standards Association, Inc. 5161 River Road Washington, D.C. 20016

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(4)

SECOND DASH NO.	GRIP ±.015	LENGTH FOR SIZES INDICATED +.030 − .015								SECOND DASH NO.	GRIP ±.015
		.1640-32*	.1900-32	.2500-28	.3125-24	.3750-24	.4375-20	.5000-20	.5625-10		
-00		.348	.400							-00	
-0		.410	.463	.526	.614					-0	
-1		.472	.526	.589	.677	.708	.790			-1	
-2	.125	.535	.588	.651	.739	.770	.852	.886	1.039	-2	.125
-3	.188	.598	.651	.714	.802	.833	.915	.949	1.102	-3	.188
-4	.250	.660	.713	.776	.864	.895	.977	1.011	1.164	-4	.250
-5	.312	.722	.775	.838	.926	.957	1.039	1.073	1.226	-5	.312
-6	.375	.785	.838	.901	.989	1.020	1.102	1.136	1.289	-6	.375
-7	.438	.846	.901	.964	1.052	1.083	1.165	1.199	1.352	-7	.438
-8	.500	.910	.963	1.026	1.114	1.145	1.227	1.261	1.414	-8	.500
-9	.562	.972	1.025	1.088	1.176	1.207	1.289	1.323	1.476	-9	.562
-10	.625	1.035	1.088	1.151	1.239	1.270	1.352	1.386	1.539	-10	.625
-11	.688	1.098	1.151	1.214	1.302	1.333	1.415	1.449	1.602	-11	.688
-12	.750	1.160	1.213	1.276	1.364	1.395	1.477	1.511	1.664	-12	.750
-13	.812	1.222	1.275	1.338	1.426	1.457	1.539	1.573	1.726	-13	.812
-14	.875	1.285	1.338	1.401	1.489	1.520	1.602	1.636	1.789	-14	.875
-15	.938	1.348	1.401	1.464	1.552	1.583	1.665	1.699	1.852	-15	.938
-16	1.000	1.410	1.463	1.526	1.614	1.645	1.727	1.761	1.914	-16	1.000
-17	1.062	1.472	1.525	1.588	1.676	1.707	1.789	1.823	1.976	-17	1.062
-18	1.125	1.535	1.588	1.651	1.739	1.770	1.852	1.886	2.039	-18	1.125
-19	1.188	1.598	1.651	1.714	1.802	1.833	1.915	1.949	2.102	-19	1.188
-20	1.250	1.660	1.713	1.776	1.864	1.895	1.977	2.011	2.164	-20	1.250
-21	1.312	1.722	1.775	1.838	1.926	1.957	2.039	2.073	2.226	-21	1.312
-22	1.375	1.785	1.838	1.901	1.989	2.020	2.102	2.136	2.289	-22	1.375
-23	1.438	1.848	1.901	1.964	2.052	2.083	2.165	2.199	2.352	-23	1.438
-24	1.500	1.910	1.963	2.026	2.114	2.145	2.227	2.261	2.414	-24	1.500
-25	1.562	1.972	2.025	2.088	2.176	2.207	2.289	2.323	2.476	-25	1.562
-26	1.625	2.035	2.088	2.151	2.239	2.270	2.352	2.386	2.539	-26	1.625
-27	1.688	2.098	2.151	2.214	2.302	2.333	2.415	2.449	2.602	-27	1.688
-28	1.750	2.160	2.213	2.276	2.364	2.395	2.477	2.511	2.664	-28	1.750
-29	1.812	2.222	2.275	2.338	2.426	2.457	2.539	2.573	2.726	-29	1.812
-30	1.875	2.285	2.338	2.401	2.489	2.520	2.602	2.636	2.789	-30	1.875
-31	1.938	2.348	2.401	2.464	2.552	2.583	2.665	2.699	2.852	-31	1.938
-32	2.000	2.410	2.463	2.526	2.614	2.645	2.727	2.761	2.914	-32	2.000

(4) *.1640 SIZE NOT PREFERRED FOR NEW DESIGN

DASH NO.	RATED STRENGTH (POUNDS) (REFERENCE PURPOSES ONLY) LOW STRENGTH (CODE "C") Ult Tensile	LOW STRENGTH (CODE "C") Single Shear	HIGH TEMPERATURE (CODE "H") Ult Tensile	HIGH TEMPERATURE (CODE "H") Single Shear	HIGH STRENGTH HIGH TEMPERATURE (CODE "X") Ult Tensile	HIGH STRENGTH HIGH TEMPERATURE (CODE "X") Single Shear
-2	1050	900	1940	1710	2250	1900
-3	1500	1200	2800	2280	3200	2700
-4	2700	2100	5050	4000	5750	4550
-5	4350	3350	8060	6280	9200	7100
-6	6550	4850	12300	9070	14000	10300
-7	8850	6600	16600	12320	18900	14300
-8	11900	8600	21600	16180	25500	18300
-9	15100	11000	28300	20560	32400	23500

(4) INACTIVE FOR DESIGN AFTER 25 June 1980. NO SUPERSEDING STANDARD

The tensile values have been computed based on the average of mean pitch and minor diameters, using room temperature ultimate tensile strengths.

GRIP LENGTHS IN ADDITION TO THOSE TABULATED ARE AVAILABLE IN .125 INCH INCREMENTS BY USE OF SIGNIFICANT DASH NUMBERS (4)

APPROVAL DATE 13 Jan. 1956 REVISION (1) 31 JULY 1958 (2) 30 NOV 1958 (3) 15 Aug. 1961 (4) 25 JUNE 1980

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION
NOTED	SCREW-MACHINE, NON MAGNETIC HIGH TEMPERATURE, STRUCTURAL, 100° FLUSH HEAD	STANDARD PART
		NAS 560 2

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