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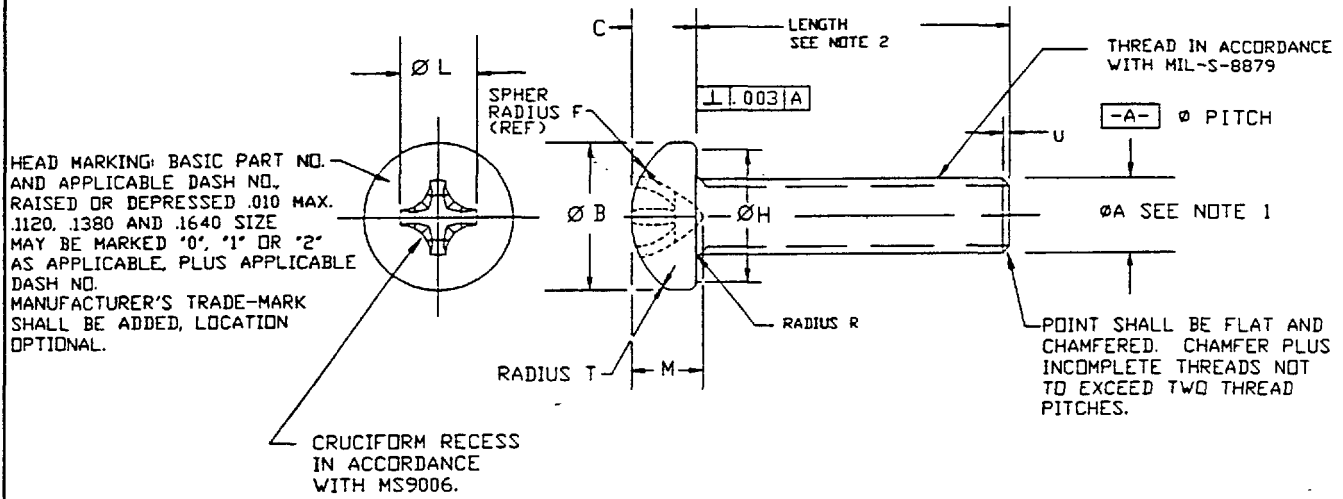


TABLE I.

| BASIC PART NUMBER | THREAD | ØA MAX | ØB | | C HEAD HEIGHT | | F SPHER RAD REF | ØH MIN | ØL +.010 -0.000 | CRUCIFORM RECESS: | | | | R RAD | U MAX | T RAD MAX | INSPECTION VALUES MIL TENSILE MIN LB |
|-------------------|------------------|--------|------|------|---------------|------|-----------------|--------|-----------------|-------------------|-----------------------------------|------|------|-------|-------|-----------|--------------------------------------|
| | | | MAX | MIN | MAX | MIN | | | | M MAX | DEPTH OF PENETRATION (SEE NOTE 4) | | MAX | | | | |
| NAS600 | .1120-40 UNJC-3A | .112 | .219 | .205 | .080 | .070 | .17 | .195 | .109 | .090 | .068 | .053 | .010 | .005 | .04 | .042 | 960 |
| NAS601 | .1380-32 UNJC-3A | .138 | .270 | .256 | .097 | .087 | .21 | .242 | .153 | .111 | .077 | .055 | .010 | .005 | .05 | .046 | 1,430 |
| NAS602 | .1640-32 UNJC-3A | .164 | .322 | .306 | .115 | .105 | .24 | .289 | .169 | .127 | .094 | .071 | .020 | .010 | .05 | .052 | 2,230 |
| NAS603 | .1900-32 UNJF-3A | .190 | .373 | .357 | .133 | .122 | .28 | .331 | .186 | .145 | .110 | .089 | .020 | .010 | .05 | .061 | 3,180 |
| NAS604 | .2500-28 UNJF-3A | .250 | .492 | .473 | .175 | .162 | .37 | .424 | .268 | .192 | .141 | .118 | .020 | .010 | .06 | .087 | 5,790 |
| NAS605 | .3125-24 UNJF-3A | .312 | .615 | .594 | .218 | .203 | .53 | .518 | .337 | .227 | .170 | .149 | .020 | .010 | .06 | .099 | 9,260 |
| NAS606 | .3750-24 UNJF-3A | .375 | .740 | .716 | .261 | .244 | .65 | .611 | .380 | .266 | .210 | .190 | .025 | .015 | .06 | .143 | 14,000 |

TABLE II. DASH NUMBERS

| DASH NO | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 18 | 20 | 22 | 24 | 26 | 28 | 30 | 32 | 34 | 36 TO 96 |
|------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|------|------|------|------|------|------|------|------|------|------|--------------|
| LENGTH | .19 | .25 | .31 | .38 | .44 | .50 | .56 | .62 | .69 | .75 | .81 | .88 | .94 | 1.00 | 1.12 | 1.25 | 1.38 | 1.50 | 1.62 | 1.75 | 1.88 | 2.00 | 2.12 | 2.25 TO 6.00 |
| LENGTH TOL | | | | | | +0 | | | | | | | | | | | | | +0 | | | | | +0 |
| | | | | | | | | | | | | | | | | | | | | | | | | |

1/ SEE NOTE 5

8 COMPLETELY REVISED

LIST OF CURRENT SHEETS

| SHT. | REV. |
|------|------|
| 1 | 8 |
| 2 | NEW |

CUSTODIAN **NATIONAL AEROSPACE STANDARDS COMMITTEE**



PROCUREMENT SPECIFICATION
MIL-S-7839

TITLE
SCREW, MACHINE - AIRCRAFT, PAN HEAD, CRUCIFORM RECESS FULL THREADED, ALLOY STEEL

CLASSIFICATION
STANDARD PART
NAS600 THRU 606
SHEET 1 OF 2

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APPROVAL DATE SEPTEMBER 1950 REVISION 6 13 MARCH 1990 7 25 APRIL 1991 8 25 MARCH 1994



MATERIAL: ALLOY STEEL, 4140 (UNS G41400) IN ACCORDANCE WITH MIL-S-5626, 4340 (UNS G43400) IN ACCORDANCE WITH MIL-S-5000 OR 8740 (UNS G87400) IN ACCORDANCE WITH MIL-S-6049.

HEAT TREATMENT: 160,000 TO 180,000 PSI TENSILE STRENGTH IN ACCORDANCE WITH MIL-H-6875, 36-40HRC.

FINISH: ~~CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE I, CLASS 2 (SEE CODE).~~
CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 2 FOR PARTS CARRYING "B" OR "P" AFTER LAST DASH NUMBER (SEE CODE).

CODE: LAST DIGIT OF NAS BASIC PART NUMBER DESIGNATES SCREW SIZE.
FIRST DASH NUMBER DESIGNATES NOMINAL LENGTH IN .0625 INCH INCREMENTS (CONVERTED TO TWO DECIMAL PLACES IN ACCORDANCE WITH ANSI Y14.5M)
INTERMEDIATE OR LONGER LENGTHS MAY BE SPECIFIED BY USE OF WHOLE DASH NUMBER ONLY.
USE OF .25 INCH INCREMENTS IS RECOMMENDED FOR SCREW LENGTHS FROM 2.25 TO 6.00 INCHES.
~~OMIT CODE FOLLOWING LENGTH DASH NUMBER FOR SCREW WITH TYPE I, CLASS 2 PLATING (SEE NOTE 7).~~
ADD "B" FOLLOWING LENGTH DASH NUMBER FOR SCREW WITH CADMIUM PLATING PER QQ-P-416, TYPE II, CLASS 2, WITH DULL BLACK CHROMATE TREATMENT.
ADD "P" FOLLOWING LENGTH DASH NUMBER FOR SCREW WITH CADMIUM PLATING PER QQ-P-416, TYPE II, CLASS 2.

EXAMPLES OF PART NUMBERS:

- NAS600-6 = .1120-40 UNJC-3A SCREW, MACHINE, AIRCRAFT, PAN HEAD, CRUCIFORM RECESS, FULL THREADED, ALLOY STEEL, .38 INCH LONG, CADMIUM PLATE, TYPE I, CLASS 2 (SEE NOTE 7).
- NAS601-8B = .1380-32 UNJC-3A SCREW, MACHINE, AIRCRAFT, PAN HEAD, CRUCIFORM RECESS, FULL THREADED, ALLOY STEEL, .50 INCH LONG, CADMIUM PLATE, TYPE II, CLASS 2, COLOR DULL BLACK.
- NAS602-12P = .1640-32 UNJC-3A SCREW, MACHINE, AIRCRAFT, PAN HEAD, CRUCIFORM RECESS, FULL THREADED, ALLOY STEEL, .75 INCH LONG, CADMIUM PLATE, TYPE II, CLASS 2.

NOTES:

- (1.) DIAMETER OF UNTHREADED PORTION OF SCREWS SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.
- (2.) FOR SCREWS 2 INCHES LONG OR SHORTER, COMPLETE THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD. SCREWS OF LONGER LENGTH SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH OF 1.75 INCHES.
- (3.) DELETED
- (4.) SEE MS9006 FOR GAGE REQUIREMENTS TO MEASURE DEPTH OF PENETRATION FOR CRUCIFORM RECESS.
- (5.) DASH NUMBERS 9, 11, 13, 15, 18, 22, 26, AND 30 ARE INACTIVE FOR DESIGN AFTER MARCH 1990.
- (6.) DELETED
- (7.) PART NUMBERS HAVING NO CODE LETTER FOLLOWING LENGTH DASH NUMBER ARE INACTIVE FOR DESIGN AFTER MARCH 1990. SUPERSEDED BY "P" CODE.
- (8.) ALL DIMENSIONS ARE IN INCHES.
- (9.) SCREWS SHALL BE FREE FROM BURRS OR SLIVERS. BREAK ALL SHARP EDGES.
- (10.) SHEAR TEST NOT APPLICABLE.
- (11.) FOR DESCRIPTION OF STATUS NOTES SEE NAS380.
- (12.) DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH ANSI Y14.5M.

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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WASHINGTON, D.C. 20005

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.

NAS600 THRU 606
SHEET 2

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