NAS 1832

INSERT, MOLDED IN, THREADED, SANDWICH PANEL

APPLICATIONS: SELF LOCKING AND NON SELF LOCKING THREADS

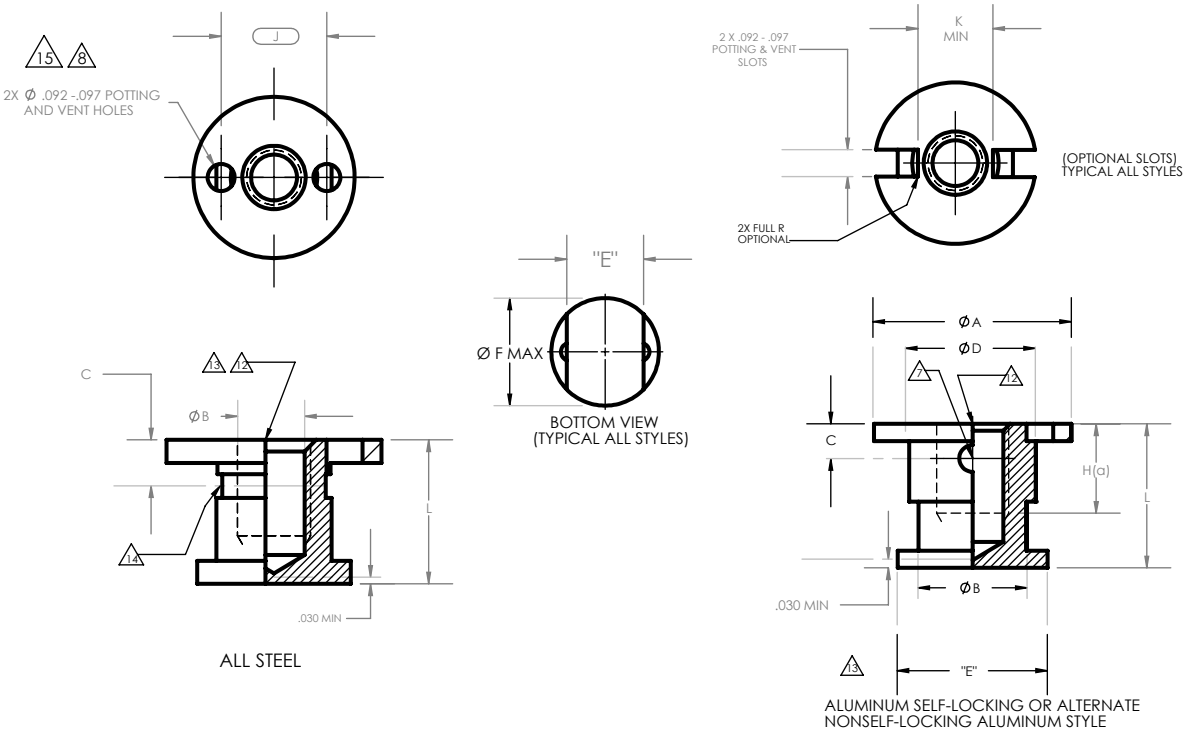

TABLE 1

FIRST DASH NO.	THREAD CLASS 3B MINOR DIA	ØA +.000 -.010	ØB	C	ØD	E	ØF 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 COMPOSTION 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 CON'TD:

3. TOLERANCES UNLESS OTHERWISE SPECIFIED:
   XXX = ±.010
   XX = ±.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.