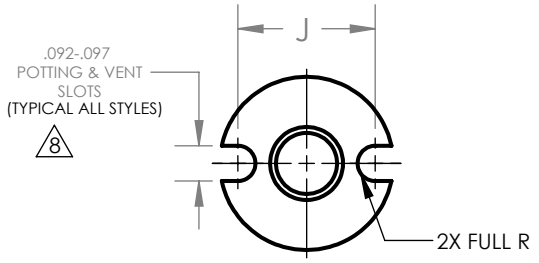
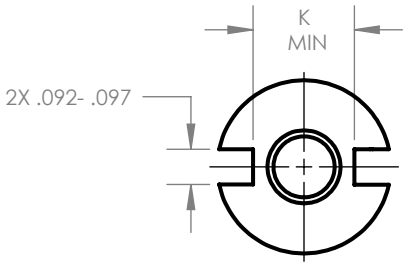
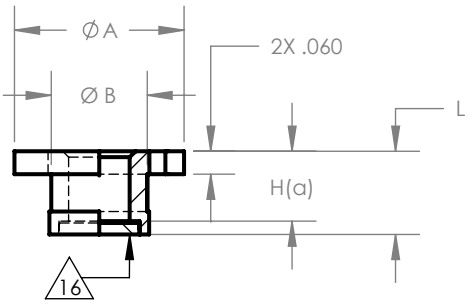
NAS 1836

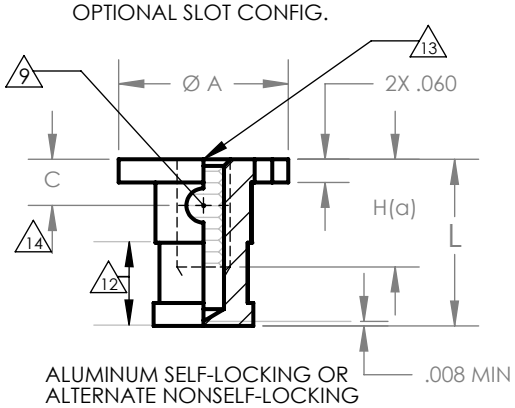
INSERT, MOLDED IN, THREADED, SELF-LOCKING NONSELF-LOCKING,LIGHTWEIGHT, SANDWICH PANEL



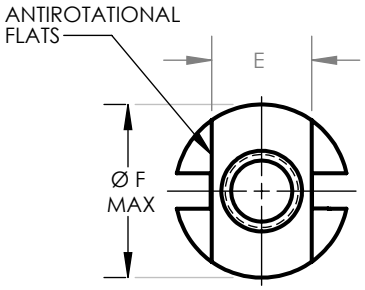


OPTIONAL SLOT CONFIG.

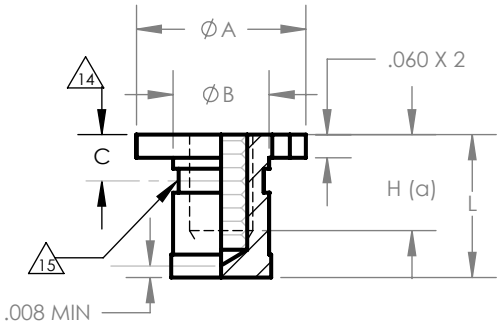




ALUMINUM SELF-LOCKING OR ALTERNATE NONSELF-LOCKING ALUMINUM STYLES



PLUGGED STYLE FOR SHORT LENGTHS
MANUFACTURER'S OPTION



BLIND TAPPED STYLE FOR LONG LENGTHS
ALL STEEL AND CRES SELF-LOCKING AND
NONSELF-LOCKING ALUMINUM STYLE.

TABLE 1

FIRST DASH NO	THREAD CLASS 3B MINOR DIA	ØA +.000 -.010	ØB	C	E	ØF MAX	H(a)	J BASIC	K MIN	L(b) MIN	INSTALLATION HOLE SIZE
-06	.1380-32 UNJC	0.451	0.3	0.1	0.26	0.45	0.187	0.358	0.251	0.217	.452 - .457
-08	.1640-32 UNJC	0.451	0.3	0.1	0.26	0.45	0.187	0.358	0.251	0.217	.452 - .457
-3	.1900-32 UNJF	0.451	0.3	0.1	0.26	0.45	0.187	0.358	0.251	0.217	.452 - .457
-4	.2500-28 UNJF	0.498	0.3	0.1	0.31	0.49	0.25	0.405	0.298	0.279	.499 - .504

NAS 1836

INSERT, MOLDED IN, BLIND, THREADED, SELF-LOCKING NONSELF-LOCKING,LIGHTWEIGHT, SANDWICH PANEL

(a) MINIMUM THREAD "H" IN SHORT LENGTHS. MINIMUM THREAD "H" WHERE LENGTH PERMITS SHALL BE 2 X DIAMETER OF THREAD.

(b) MINIMUM LENGTH WHICH MAY BE SPECIFIED.

MATERIAL: CARBON STEEL PER ASTM-A-108, ASTM A576 OR MATERIAL COMPOSITION PER FED-STD-66.
ULTIMATE TENSILE STRENGTH , 85 KSI MINIMUM
ALUMINUM ALLOY, GRADE 2024 (UNS A92024) TEMPER T4 OR T351 PER QQ-A-225/6.
CORROSION RESISTANT STEEL, TYPE 303 (UNS S30300) PER ASTM A582.
NONMETALLIC LOCKING ELEMENT - POLYAMIDE PER FED SPEC L-P-410

FINISH: CARBON STEEL - CADMIUM PLATE PER SAE-AMS QQ-P-416, TYPE II, CLASS 2.
ALUMINUM ALLOY - ANODIZE PER MIL-A-8625 TYPE I, CLASS OPTIONAL.
CRES - PASSIVATE PER ASTM-A-967, TYPE II. SILVER PLATE PER AMS2410 OR AMS2411OR CADMIUM PLATE PER SAE-AMS QQ-P-416 TYPE II, CLASS 2.
SOLID FILM LUBRICANT PER AS5272, TYPE I, 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 NOMIMAL THREAD SIZE SEE TABLE I.
SUFFIX N TO FIRST DASH NUMBER INDICATES NON SELF-LOCKING.
SECOND DASH NUMBER INDICATES LENGTH IN .031 INCREMENTS;
ALWAYS USE 2 DIGIT DASH NUMBER. (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 1836-3-08M	.1900-32 UNJF-3B THREAD, CARBON STEEL, CADMIUM PLATED, WITH SOLID FILM LUBRICANT, .248 LONG, SELF-LOCKING.
NAS 1836A3N09	.1900-32 UNJF-3B THREAD, AL ALLOY, ANODIZED, .279 LONG, NONSELF-LOCKING.
NAS 1836C08-10S	.1640-32 UNJC-3B THREAD, CRES, SILVER PLATED, .310 LONG, SELF-LOCKING.
NAS 1836C4N12	.2500-28 UNJF-3B THREAD, CRES, PASSIVATED, .372 LONG, NONSELF-LOCKING.

NAS 1836

INSERT, MOLDED IN, THREADED, SELF-LOCKING NONSELF-LOCKING,LIGHTWEIGHT, SANDWICH PANEL

NOTES:

1. THREADED 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 N SCREW.
3. TOLERANCES UNLESS OTHERWISE SPECIFIED:
   XXX = ±.010
   XX = ±.02
4. AN ADHESIVE-BACKED INSTALLATION TAB NAS 1837 (PLASTIC 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 CLEARENCE BETWEEN BOTTOM OF INSERT AND INSIDE SURFACE OF BOTTOM SKIN.
7. MAXIMUM BOLT ENGAGEMENT SHOULD NOT EXCEED "L" MINUS .060.

△8 BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.

△9 NONMETALLIC THREAD LOCK WHEN APPLICABLE
LOCATE PELLET NO CLOSER THAN 10° FROM EDGE OF EITHER POTTING HOLE OR SLOT.

10. DIMENSIONING AND TOLERANCING PER ANSI Y 14.5M-1982.
11. DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED.

△12 EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375.

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

△14 CENTERLINE OF THREAD LOCK WHEN APPLICABLE.

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

△16 PLUG TO PROVIDE MAXIMUM THREAD ON SHORT LENGTH INSERT IF NECESSARY.

17. ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUNOUT SAME AXIS.
18. DIMENSIONAL LIMITS APPLY AFTER PLATING, PRIOR TO SOLID FILM LUBE.