

FED. SUPPLY CLASS
5325

1. SCOPE

- 1.1 Scope. This specification covers helical coil screw-thread inserts made from formed wire, the inner surfaces of which, after assembly, provide threads as specified.
- 1.2 Classification. Inserts shall be of the following types and classes, as specified (see 6.2).
 - a. Type I - Coarse thread
 - (1) Class 1 - Free running.
 - (2) Class 2 - Screw locking (self-locking).
 - b. Type II - Fine thread
 - (1) Class 1 - Free running.
 - (2) Class 2 - Screw locking (self-locking).
 - c. Type III - Taper pipe thread
 - (1) Class 5 - NPT pipe thread
 - (2) Class 6 - ANPT pipe thread
 - d. Type IV - Metric - spark plug thread
 - (1) Class 3 - Staking (spark plug thread)

2. APPLICABLE DOCUMENTS

- 2.1 Government documents.
 - 2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

FEDERAL

- FED-STD-H28/2 Screw Thread Standards for Federal Services, Section 2, Unified Inch
- FED-STD-H28/7 Screw Thread Standards for Federal Services, Section 7, Pipe Threads, General Purpose

MILITARY

- MS9018 Insert - 18-1.5MM Aviation Spark Plug Helical Coil
- MS9071 Bosses, 18-1.50MM Spark Plug Thread Helical Insert, Standard Dimensions for (ASG)

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-I-8846, REVISION D AMENDMENT 1, SUPPLEMENT 1.

THIRD ANGLE PROJECTION 	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NONE	TITLE INSERT, SCREW-THREAD, HELICAL COIL	CLASSIFICATION SPECIFICATION NASM8846 SHEET 1 OF 10

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 09-01

Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks can be obtained from the Department of Defense Single Stock Point (DODSSP) <http://dodssp.daps.dla.mil>.

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

AMERICAN SOCIETY OF MECHANICAL ENGINEERS (ASME)

ASME B46.1 Surface Texture (Surface Roughness, Waviness, and Lay)

Copies can be obtained from ASME, Three Park Ave., New York, NY 10016-5990 www.asme.org

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM E 8/E 8M	Materials, Metallic, Tension Testing of
ASTM E290	Materials, Metallic, Semi-guided Bend Test for Ductility of
ASTM E1282	Standard Guide for Specifying the Chemical Compositions and Selecting Sampling Practices and Quantitative Analysis Methods for Metals and Alloys
ASTM D3951-90	Standard Practice for Commercial Packaging

Copies can be obtained from ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA, 19428-2959 USA www.astm.org

NATIONAL AEROSPACE STANDARDS (NAS)

NAS1130	Insert Screw Thread, Helical Coil, Free Running and Self-Locking, Tangless
NAS6603 thru 6620	Bolt, Hex Head, Close Tolerance, Alloy Steel, Long Thread, Self-Locking and Nonlocking
NAS1352	Screw, Cap, Socket Head and Screw Cap Socket Head, Self-Locking, Alloy Steel, Cadmium Plated, UNC-3A
NASM21209	Insert, Screw Thread, Coarse and Fine, Screw Locking, Helical Coil, CRES
NASM33537	Insert - Screw-Thread, Helical Coil Coarse and Fine Thread, Standard Dimensions for
NASM122076 thru	Insert - CRES Helical Coil Coarse Thread, 1 Dia Nominal Length
NASM122115	
NASM122116 thru	Insert - CRES Helical Coil Coarse Thread, 1-1/2 Dia Nominal Length
NASM122155	
NASM122156 thru	Insert - CRES Helical Coil Coarse Thread, 2 Dia Nominal Length
NASM122195	
NASM122196 thru	Insert - CRES Helical Coil Coarse Thread, 2-1/2 Dia Nominal Length
NASM122235	
NASM122236 thru	Insert-CRES Helical Coil Coarse Thread, 3 Dia Nominal Length
NASM122275	
NASM124651 thru	Insert CRES Helical Coil Fine Thread, 1 Dia Nominal Length
NASM124690	
NASM124691 thru	Insert CRES Helical Coil Fine Thread, 1-1/2 Dia Nominal Length
NASM124730	
NASM124731 thru	Insert CRES Helical Coil Fine Thread, 2 Dia Nominal Length
NASM124770	
NASM124771 thru	Insert CRES Helical Coil Fine Thread, 2-1/2 Dia Nominal Length
NASM124810	
NASM124811 thru	Insert CRES Helical Coil Fine Thread, 3 Dia Nominal Length
NASM124850	

Copies can be obtained from the Aerospace Industries Association, 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209 www.aia-aerospace.org

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REVISION
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NASM8846
SHEET 2

