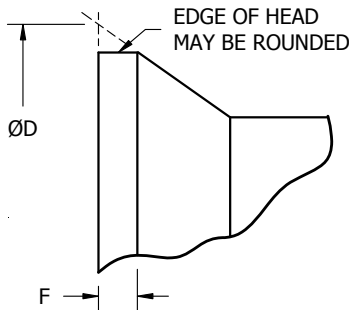


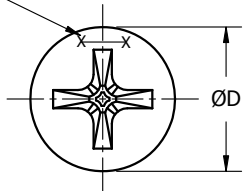
FED. SUPPLY CLASS

5305

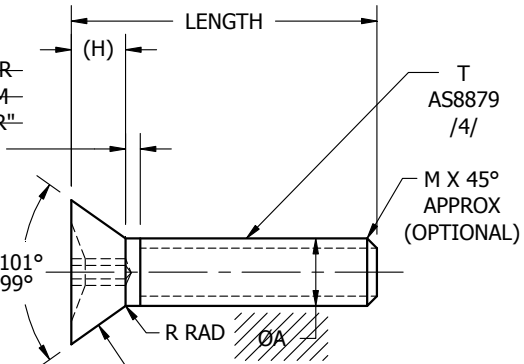
MARK STEEL SCREWS WITH TWO "X" CONNECTED WITH A BAR. ONLY ONE "X" NEED BE VISIBLE AFTER SLOTTING. POSITION OPTIONAL



AN INCREASE OF .001 OVER "ØA" IS PERMISSIBLE FROM POINT OF TANGENCY OF "R" AND SHANK TO 1/32" /6/

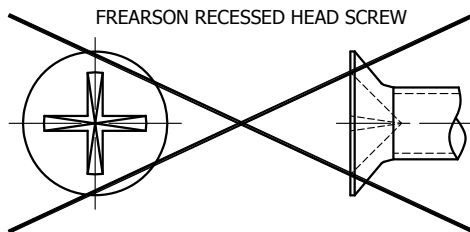


RECESSED HEAD SCREW



THE CONICAL SURFACE OF THE HEAD SHALL BE CONCENTRIC WITH THE BODY WITHIN .003 FIM.

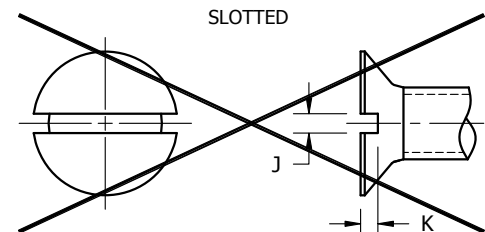
THIS TYPE OF RECESS HAS A LARGE CENTER OPENING, TAPERED WINGS, AND A BLUNT BOTTOM, WITH ALL EDGES RELIEVED OR ROUNDED. RECESS SHALL BE IN ACCORDANCE WITH MS9006.



FREARSON RECESSED HEAD SCREW

THIS TYPE OF RECESS CONSISTS OF TWO INTERSECTING SLOTS WITH PARALLEL SIDES CONVERGING TO A SHARP APEX AT BOTTOM OF RECESS. RECESS SHALL BE IN ACCORDANCE WITH THE 1959 SUPPLEMENT TO HANDBOOK H28 - SCREW THREADS FOR FEDERAL SERVICES 1944 (RECESS TYPE II).

FREARSON RECESSED HEAD SCREW INACTIVE FOR DESIGN AFTER 15 OCT. 1958.



SLOTTED

SLOTTED HEAD SCREW INACTIVE FOR DESIGN AFTER 1 SEPT. 1963.

FOR DEFINITION OF DRAWING STATUS NOTES, SEE NAS380.

FIGURE 1 - RECESSED, FREARSON, AND SLOTTED HEAD SCREWS

9 COMPLETELY REVISED

TABLE I - RECESSED HEAD SCREW DIMENSIONS

T THREAD /4/	ØA DIA		ØD			F MAX	(H)	J		K		M MAX	R RAD		MIN ULT TENSILE STRENGTH LBF (REF)	MIN SINGLE SHEAR STRENGTH LBF (REF) /8/
	MAX	MIN	MAX SHARP	MIN SHARP	ABS MIN WITH MAX F			MAX	MIN	MAX	MIN		MAX	MIN		
.1120-40 UNJC-3A	.1110	.1080	.225	.213	.183	.012	.045	.039	.031	.024	.017	.031	.012	.002	750	450
.1380-32 UNJC-3A	.1372	.1340	.279	.267	.233	.014	.057	.048	.039	.030	.022	.031	.012	.002	1,120	670
.1640-32 UNJC-3A	.1631	.1600	.332	.319	.282	.015	.068	.054	.045	.036	.027	.031	.015	.005	1,740	1,040
.1900-32 UNJF-3A	.1890	.1860	.385	.371	.332	.016	.080	.060	.050	.042	.031	.031	.015	.005	2,490	1,490
.2500-28 UNJF-3A	.2490	.2460	.507	.491	.447	.018	.106	.075	.064	.055	.042	.031	.015	.005	4,520	2,710
.3125-24 UNJF-3A	.3115	.3085	.635	.617	.568	.020	.133	.084	.072	.069	.058	.047	.020	.010	7,240	4,340
.3750-24 UNJF-3A	.3740	.3710	.762	.742	.686	.023	.159	.094	.081	.083	.064	.047	.020	.010	10,950	6,570

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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 12-01

REVISION DATE: NOVEMBER 30, 2012

ISSUE DATE: MARCH 1953

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 9
PROCUREMENT SPECIFICATION NASM7839	TITLE SCREW, MACHINE, 100°, FLAT HEAD, FULL THREADED, ALLOY STEEL	CLASSIFICATION PART STANDARD NAS514 SHEET 1 OF 4

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

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MATERIAL:

ALLOY STEEL:
~~4037 (UNS G40370) PER AMS6300 (RESTRICTED TO SIZES THROUGH Ø.3750), /7/~~
 4130 (UNS G41300) PER MIL-S-6758 AMS-S-6758,
 4340 (UNS G434000) PER MIL-S-5000 AMS6415 OR AMS6484,
 8630 (UNS G86300) PER MIL-S-6050, /7/
 8735 (UNS G87350) PER MIL-S-6098, /7/ OR
 8740 (UNS G87400) PER MIL-S-6049 AMS6322, AMS6325, OR AMS6327.

HEAT TREATMENT:

125 TO 145 KSI TENSILE STRENGTH PER AMS2759.

FINISH:

CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2.
 CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 FOR PARTS CARRYING "B" OR "P" AFTER LAST
 DASH NUMBER (SEE CODE).
 PARTS WITH CLASS 3 PLATING MAY BE FURNISHED FROM SUPPLIER'S STOCK UNTIL 30 NOVEMBER
 1975.

CODE:

ADD "P" BETWEEN BASIC PART NUMBER AND FIRST DASH NUMBER FOR CRUCIFORM RECESS.
~~ADD "F" BETWEEN BASIC PART NUMBER AND FIRST DASH NUMBER FOR FREARSON (REED AND
 PRINCE) RECESS.~~
~~NO LETTER INDICATES SLOTTED HEAD.~~
 ADD "B" FOLLOWING LAST DASH NUMBER FOR SCREW WITH DULL BLACK CHROMATE TREATMENT.
 ADD "P" FOLLOWING LAST DASH NUMBER FOR SCREW WITH CADMIUM PLATING PER AMS-QQ-P-416,
 TYPE II.

EXAMPLE OF PART NUMBER:

NAS514 P 428-8 = CRUCIFORM RECESS HEAD MACHINE SCREW WITH .2500-28 UNJF-3A THREAD
 .500 INCH LONG
 ————— LENGTH IN .0625 OF AN INCH
 ————— DIAMETER AND THREADS PER INCH AS PER TABLE 2
 ————— CROSS RECESS HEAD
 ————— BASIC PART NUMBER

NAS514 P 428-8 B = CRUCIFORM RECESS HEAD MACHINE SCREW WITH .2500-28 UNJF-3A THREAD,
 .500 INCH LONG, BLACK
 ————— BLACK COLOR
 ————— LENGTH IN .0625 OF AN INCH
 ————— DIAMETER AND THREADS PER INCH AS PER TABLE 2
 ————— CROSS RECESS HEAD
 ————— BASIC PART NUMBER

⑨ COMPLETELY REVISED

REVISION 9
NAS514 SHEET 2