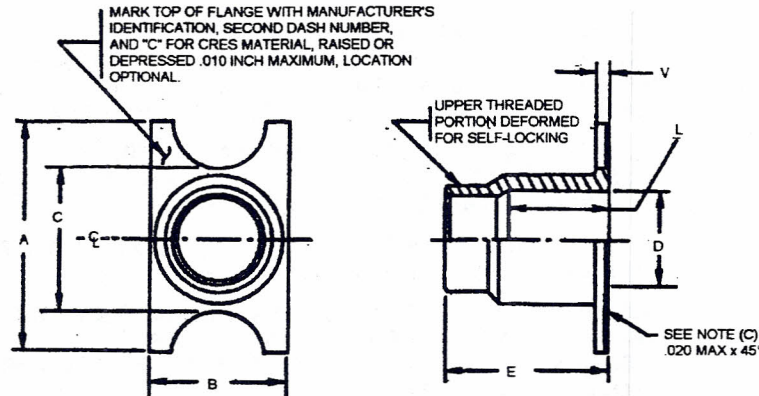


FED. SUP CLASS

**5310**


DASH NUMBER		(b) THREAD	A ±.005	B ±.005	C ±.005	D DIA MIN.	(a)		V	AXIAL TENSILE STR. MIN. LBS. MIN.	MAX WEIGHT LBS/100
STEEL	CRES						E MAX.	L C'BORE MIN.			
A08-1	C08-1	.1640-32 UNJC-3B	.437	.300	.300	.168	.208	.041	.040 .028	2,000	.16
A08-2	C08-2						.270	.100			.23
A08-3	C08-3						.333	.163			.28
A08-4	C08-4						.396	.225			.33
A08-5	C08-5						.458	.288			.38
A08-6	C08-6						.520	.350			.43
A3-1	C3-1	.1900-32 UNJF-3B	.487	.300	.300	.194	.208	.041	.040 .030	2,825	.16
A3-2	C3-2						.270	.100			.23
A3-3	C3-3						.333	.163			.28
A3-4	C3-4						.396	.225			.33
A3-5	C3-5						.458	.288			.38
A3-6	C3-6						.520	.350			.43
A4-1	C4-1	.2500-28 UNJF-3B	.562	.400	.362	.254	.253	.036	.052 .040	5,060	.37
A4-2	C4-2						.315	.100			.47
A4-3	C4-3						.377	.163			.56
A4-4	C4-4						.439	.225			.64
A4-5	C4-5						.501	.288			.74
A4-6	C4-6						.563	.350			.82
A5-1	C5-1	.3125-24 UNJF-3B	.727	.480	.478	.317	.294	.036	.064 .050	8,000	.70
A5-2	C5-2						.350	.100			.76
A5-3	C5-3						.411	.163			.87
A5-4	C5-4						.474	.225			.99
A5-5	C5-5						.536	.288			1.10
A5-6	C5-6						.599	.350			1.20
A6-1	C6-1	.3750-24 UNJF-3B	.785	.560	.560	.379	.315	.025	.070 .055	11,900	.95
A6-2	C6-2						.365	.100			1.15
A6-3	C6-3						.428	.145			1.40
A6-4	C6-4						.490	.205			1.55
A6-5	C6-5						.570	.270			1.70
A6-6	C6-6						.623	.330			1.86

- (a) MINIMUM "E" LIMITED ONLY BY STRENGTH REQUIREMENTS.  
 (b) THREADS IN ACCORDANCE WITH MIL-S-8879 BEFORE THREAD LOCK AND LUBRICATION.  
 (c) CHAMFER OR RADIUS THIS EDGE, TWO PLACES, PERMISSIBLE TO ASSURE .030 MINIMUM RADIAL FLOAT IN THE NUT PLATE ASSEMBLY.

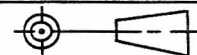

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LIST OF CURRENT SHEETS	
NO.	REV.
1	2
2	2
3	NEW

CUSTODIAN NATIONAL AEROSPACE STANDARD COMMITTEE

THIRD ANGLE PROJECTION



PROCUREMENT SPECIFICATION

TITLE

CLASSIFICATION PART STANDARD

NOTED

**NUT - SELF-LOCKING, COUNTERBORE  
 REPLACEABLE ELEMENT**
**NAS 1794**

SHEET 1 OF 3



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

**MATERIAL:** ALLOY OR CARBON STEEL, HEAT TREATED.  
CRES A286 PER AMS5525, AMS5732 OR AMS5737. MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR 1.0) FOR A FIELD STRENGTH OF 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATION PER MIL-I-17214 OR ASTM A342.

**FINISH:** ALLOY OR CARBON STEEL - CADMIUM PLATE PER QQ-P-416, CLASS 1 OR 2. TYPE OF PLATING IS OPTIONAL IF LUBRICATED NUTS WILL MEET THE SALT SPRAY REQUIREMENTS OF QQ-P-416, TYPE II.

A286 CRES - (450°F) PASSIVATE PER QQ-P-35, NICKEL OR COPPER STRIKE OPTIONAL AND TRY FILM LUBRICANT.

A286 CRES - (800°F) SILVER PLATE PER AMS2410 TO A .0002 MINIMUM THICKNESS ON SURFACE WHICH CAN BE TOUCHED BY A .750 DIA BALL. THREADS SHALL SHOW COMPLETE COVERAGE BUT THICKNESS REQUIREMENTS WAIVED.

**LUBRICANT:** MOLYDISULFIDE (MoS<sub>2</sub>) DRY FILM LUBRICANT PER NAS3356.

**CODE:** "A" FOLLOWING BASIC NUMBER INDICATES STEEL NUT.  
"C" FOLLOWING BASIC NUMBER INDICATES CRES NUT.  
"N" SUFFIXED TO DASH NUMBER INDICATES NUT WITHOUT TRY FILM LUBRICANT.  
"P" SUFFIXED TO CRES NUTS INDICATES SILVER PLATE.

**EXAMPLE OF PART NUMBERS:**

NAS 1794A3-3 = .1900-32UNJF-3B THREAD, STEEL NUT, .163 COUNTERBORE DEPTH, CADMIUM PLATED, WITH LUBRICANT.

NAS1794A4-3N = .2500-28UNJF-3B THREAD, STEEL NUT, .163 COUNTERBORE DEPTH, CADMIUM PLATED, WITHOUT LUBRICANT.

NAS 1794C4-2 = .2500-28UNJF-3B THREAD, CRES NUT, .100 COUNTERBORE DEPTH, PASSIVATED, WITH LUBRICANT.

NAS1794C3-4NP = .1900-32UNJF-3B THREAD, CRES NUT, .225 CONTERBORE DEPTH, WITHOUT LUBRICANT, SILVER PLATED.

- NOTES:**
- ALL DIMENSIONS IN INCHES.
  - NUTS SHALL BE USED IN ACCORDANCE WITH LIMITATIONS OF MS33588.
  - THIS NUT IS INTENDED FOR USE WITH NAS1791, NAS1792 AND NAS1793 PLATE NUT ASSEMBLIES AND APPLICABLE GANG CHANNEL ASSEMBLIES.
  - CONFIGURATION OF NUT IS OPTIONAL WITHIN THE LIMITATIONS IMPOSED BY DIMENSIONS AND REQUIREMENTS AS SPECIFIED HEREIN.
  - LOCKING TORQUE RE-USABILITY FOR DRY FILM LUBRICATED NUTS IS REQUIRED FOR 50 SEATED CYCLES. USE CADMIUM PLATED STEEL BOLTS ON STEEL NUTS AND A286 OR 13-8 Mo BOLTS ON CRES NUTS TO THE FOLLOWING TORQUE LOADS:

②

<u>THREAD SIZE</u>	<u>SEATED TORQUE (IN-LBS.)</u>
.1640-32UNJC-3B	18
.1900-32UNJF-3B	25
.2500-28UNJF-3B	60
.3125-24UNJF-3B	120
.3750-24UNJF-3B	125

NUT LOCKING TORQUE VALUES OF NASM25027 APPLY.  
[TEST BOLTS MAY BE REPLACED AND TEST CONTINUED IF NUT LOCKING TORQUE FALLS BELOW MINIMUM.]

- THE DASH NUMBERS AND APPLICABLE CODES FOR NAS 1794 NUT ARE THE SAME AS FOR NAS 1791, NAS1792, AND NAS1793 PLATE NUT ASSEMBLIES FOR RESPECTIVE MATERIAL AND SIZES.

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWING FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

FORM 4-88

NAS 1794  
SHEET 2

APPROVAL DATE: November 1978 REVISION: ① July 2001 ② October 2003

## PROCUREMENT SPECIFICATIONS:

UNLESS OTHERWISE SPECIFIED, STEEL NUTS - NAS3350, CLASS I, AND CRES NUTS - NASM25027.

ALL PARTS MUST MEET QUALIFICATION AND INSPECTION REQUIREMENTS. MANUFACTURERS SHALL PROVIDE EVIDENCE OF QUALIFICATION WHEN REQUIRED. TESTING SHALL BE PERFORMED BY MANUFACTURER OR INDEPENDENT LABORATORY. PROCURING AGENCY MAY CONDUCT CONFIRMING QUALIFICATION TESTS. NO QPL SHALL BE ESTABLISHED.

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.  
1250 EYE STREET, N.W.  
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.

APPROVAL DATE JULY 2001 REVISION

**NAS 1794**

SHEET 3