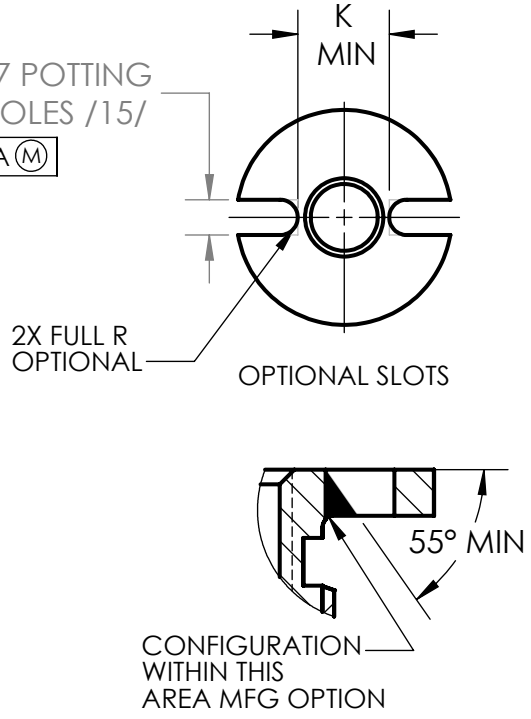
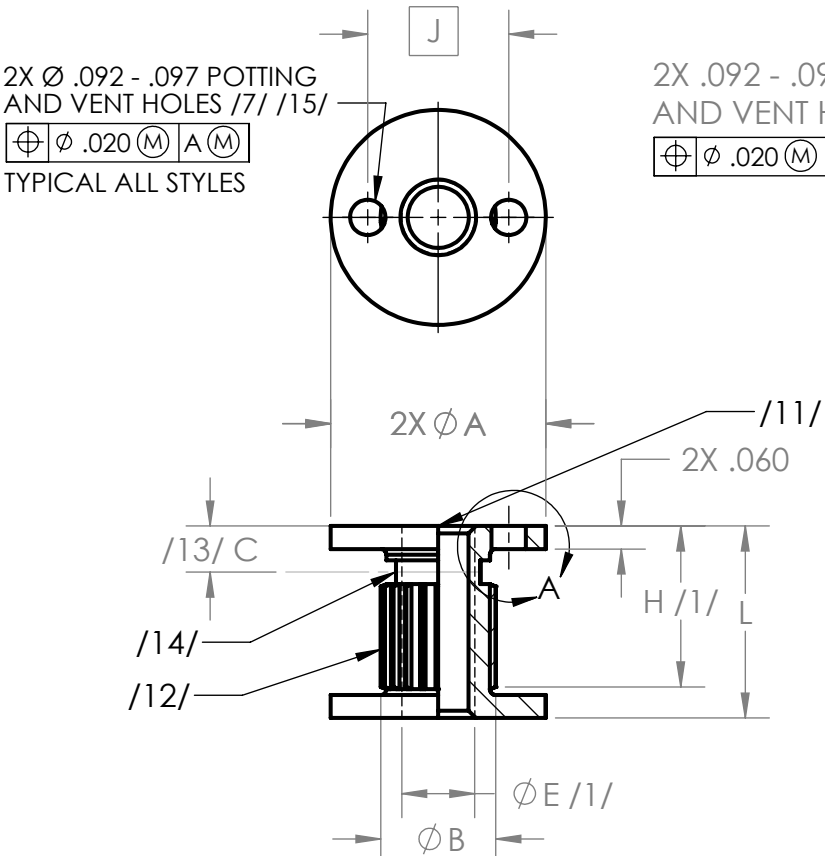
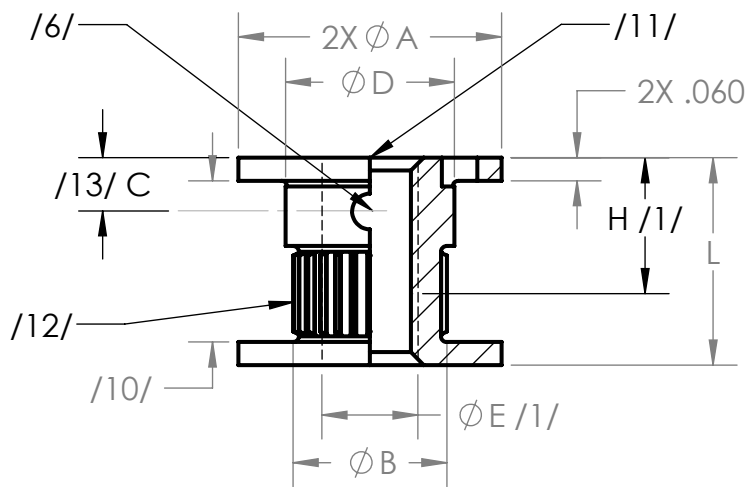


NAS1833
INSERT, MOLDED IN, THREADED,
SELF-LOCKING, NONSELF LOCKING, SANDWICH PANEL



DETAIL A
 FOR OPTIONAL CONFIGURATION
 TYPICAL FOR ALL STYLES

ALL STEEL AND CRES SELF-LOCKING AND NONSELF-LOCKING
 OR NONSELF-LOCKING ALUMINUM STYLE INSERTS



ALUMINUM SELF-LOCKING STYLE OR ALTERNATE
 NONSELF-LOCKING ALUMINUM STYLE

NAS1833

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

TABLE I - DIMENSIONS											
FIRST DASH NO.	THREAD CLASS 3B MINOR DIA [A-]	ØA +.000 -.010	ØB	C	ØD	ØE /1/	H MIN /1/	J BASIC	K MIN	L MIN /2/	INSTALLATION HOLE SIZE
06	.1380 - 32 UNJC	.560	.30	.12	.375	.139 - .145	.276	.367	.260	.250	.561 - .566
08	.1640 - 32 UNJC	.560	.30	.12	.375	.168 - .174	.328	.367	.260	.250	.561 - .566
3	.1900 - 32 UNJF	.560	.30	.12	.375	.195 - .201	.380	.367	.260	.250	.561 - .566
4	.2500 - 28 UNJF	.685	.37	.14	.440	.256 - .263	.500	.467	.360	.312	.686 - .691
5	.3125 - 24 UNJF	.685	.47	.16	.500	.315 - .322	.625	.467	.360	.312	.686 - .691
6	.3750 - 24 UNJF	.841	.50	.22	.550	.376 - .383	.750	.591	.484	.375	.842 - .847

MATERIAL:

CARBON STEEL PER ASTM A 108, ASTM A 576, OR MATERIAL COMPOSITION PER AIR4127. ULTIMATE TENSILE STRENGTH, 85 KSI MINIMUM.

AL ALLOY, GRADE 2024 (UNS A92024) TEMPER T4 OR T351 PER AMS-QQ-A-225/6.

CORROSION RESISTANT STEEL, TYPE 303 (UNS S30300) PER ASTM A 582/A 582M.

NONMETALLIC LOCKING ELEMENT - POLYAMIDE PER L-P-410.

FINISH:

CARBON STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

AL ALLOY - ANODIZE PER MIL-A-8625, TYPE I, CLASS OPTIONAL.

CRES - PASSIVATE PER ASM2700, METHOD1, CLASS 4; SILVER PLATE PER AMS2410 OR AMS2411; OR CADMIUM PLATE PER 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 NOMINAL THREAD SIZE, SEE TABLE I.
 SUFFIX "N" TO FIRST DASH NUMBER INDICATES NONSELF-LOCKING.
 SECOND DASH NUMBER INDICATES LENGTH IN THOUSANDTHS.
 NO LETTER AFTER SECOND DASH NUMBER FOR CRES INDICATES PASSIVATE ONLY. /9/
 SUFFIX "M" TO SECOND DASH NUMBER INDICATES SOLID FILM LUBRICANT. /9/
 SUFFIX "P" TO SECOND DASH NUMBER INDICATES CADMIUM PLATE ON CRES INSERT. /9/
 SUFFIX "S" TO SECOND DASH NUMBER INDICATES SILVER PLATE ON CRES INSERT. /9/

EXAMPLE OF PART NUMBER:

NAS1833-3-500M	.1900-32 UNJF -3B THREAD, CARBON STEEL, CADMIUM PLATED WITH SOLID FILM LUBRICANT, .500 LONG, SELF-LOCKING.
NAS1833A3N500	.1900-32 UNJF -3B THREAD, AL ALLOY, ANODIZED, .500 LONG, NONSELF-LOCKING.
NAS1833C08-375S	.1640-32 UNJC -3B THREAD, CRES, SILVER PLATED, .375 LONG, SELF-LOCKING.
NAS1833C08-375P	.1640-32 UNJC -3B THREAD, CRES, CADMIUM PLATED, .375 LONG, SELF-LOCKING.
NAS1833C4N625	.2500-28 UNJF -3B THREAD, CRES, PASSIVATED, .625 LONG NONSELF-LOCKING
NAS1833-4-1250	.2500-28 UNJF -3B THREAD, CARBON STEEL, CADMIUM PLATED, 1.250 LONG, SELF-LOCKING.

NAS1833

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

NOTES:

- /1/ MINIMUM THREAD DEPTH "H" WHERE LENGTH PERMITS SHALL BE 2X DIAMETER OF THREAD. LENGTHS SHORTER THAN 2X DIAMETER OF THREAD SHALL BE THREADED THE ENTIRE LENGTH. LENGTHS LONGER THAN 2X DIAMETER MAY HAVE A THREAD RELIEF SHOWN BY "Ø E" AND "H" OR MAY BE THREADED THE ENTIRE LENGTH (MANUFACTURER'S OPTION).
- /2/ MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- (3) THREADS PER AS8879.
- (4) LOCKING TORQUE PER NASM25027 EXCEPT SELF-LOCKING, CORROSION RESISTANT STEEL INSERT WITHOUT PLATING OR LUBRICANT WILL BE TESTED USING A SILVER PLATED BOLT OR SCREW.
- (5) TOLERANCES UNLESS OTHERWISE SPECIFIED: .XXX ± .010, .XX ± .02.
- /6/ NONMETALLIC THREAD LOCK WHEN APPLICABLE. LOCATE PELLET NO CLOSER THAN 10° FROM EDGE OF EITHER POTTING HOLE OR SLOT.
- /7/ BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.
- (8) AN ADHESIVE-BACKED INSTALLATION TAB NAS1837 (PLASTIC) SHALL BE FURNISHED WITH EACH INSERT.
- /9/ PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.
- /10/ EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375.
- /11/ MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
- /12/ STRAIGHT OR DIAMOND ANTIROTATIONAL KNURL (MANUFACTURER'S OPTION) .
- /13/ CENTERLINE OF THREAD LOCK WHEN APPLICABLE.
- /14/ SHANK DEFORMED THIS AREA TO PROVIDE THREAD LOCK WHEN APPLICABLE.
- /15/ POTTING AND VENT HOLES OR SLOTS (MANUFACTURER'S OPTION).
- (16) DIMENSIONS IN INCHES. DIMENSIONAL LIMITS APPLY AFTER PLATING, AND PRIOR TO SOLID FILM LUBE.
- (17) ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUNOUT TO DATUM A.
- (18) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (19) REMOVE ALL BURRS AND SHARP EDGES EXCEPT AS NOTED IN NOTE /7/.
- (20) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (21) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (22) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.