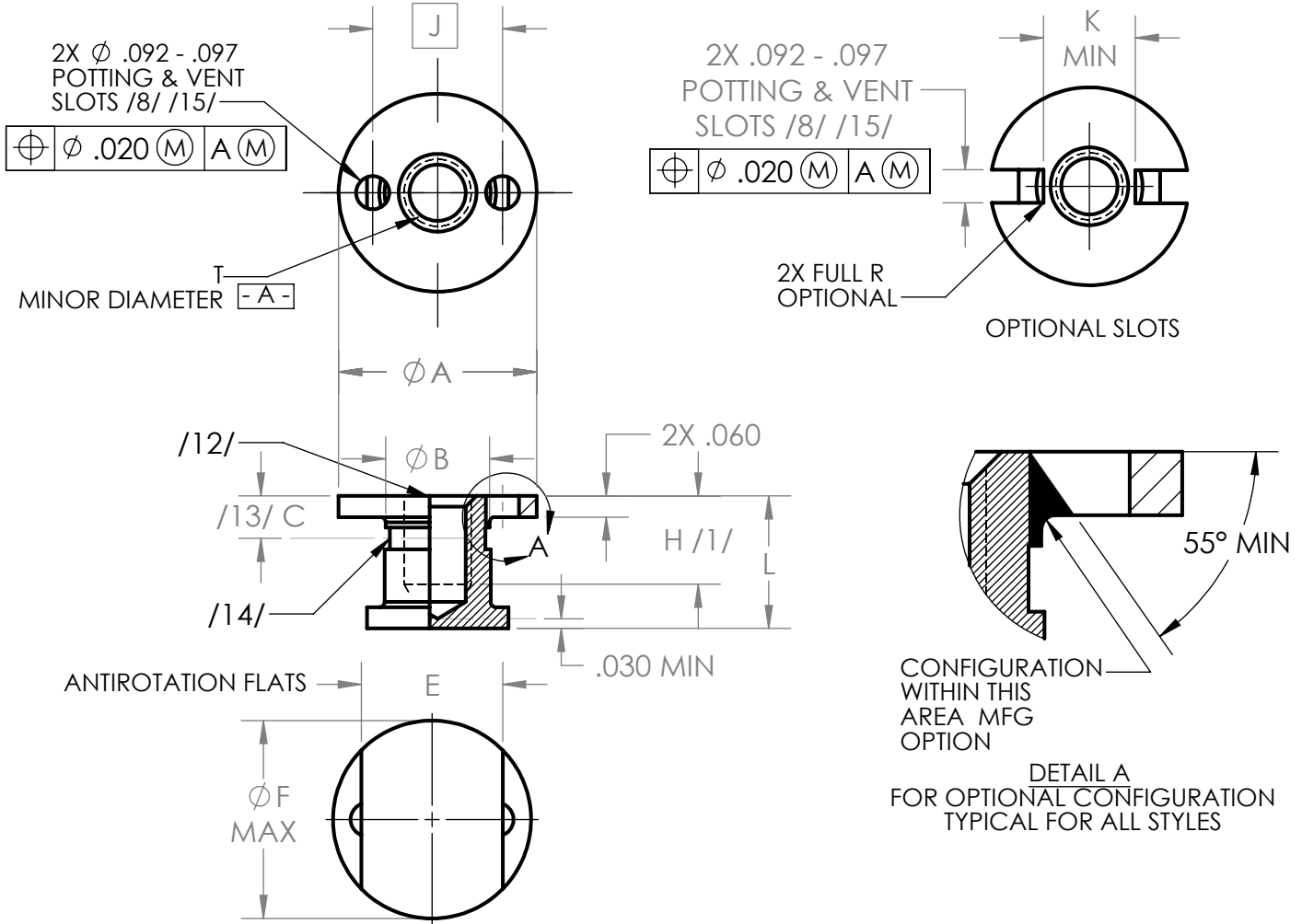
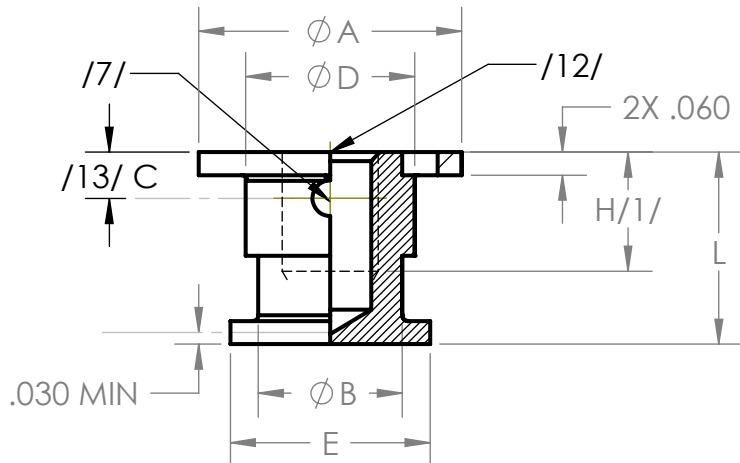


**NAS1832**

**INSERT, MOLDED IN, BLIND THREADED, LOCKING,  
NON-LOCKING, SANDWICH PANEL**



ALL STEEL AND CRES LOCKING AND NON-LOCKING OR NON-LOCKING ALUMINUM STYLE



ALUMINUM LOCKING STYLE OR ALTERNATE NON-LOCKING ALUMINUM STYLE

WITTEN COMPANY  
918-272-9567

APPROVAL DATE: REV:A 9/13/2021

GAGE CODE: 0JHK5

# NAS1832

## INSERT, MOLDED IN, BLIND THREADED, LOCKING, NON-LOCKING, SANDWICH PANEL

TABLE I - DIMENSIONS

SIZE DASH NO	T THREAD /3/	ØA +.000 -.010	ØB	C	ØD	E	ØF MAX	H MIN /1/	J BASIC	K MIN	L MIN /2/
06	.1380-32 UNJC	.560	.300	.12	.375	.400	.560	.25	.367	.260	.37
08	.1640-32 UNJC	.560	.300	.12	.375	.400	.560	.25	.367	.260	.37
3	.1900-32 UNJF	.560	.300	.12	.375	.400	.560	.25	.367	.260	.37
4	.2500-28 UNJF	.685	.375	.14	.440	.520	.685	.31	.467	.360	.50
5	.3125-24 UNJF	.685	.475	.16	.500	.520	.685	.31	.467	.360	.50
6	.3750-24 UNJF	.841	.500	.22	.550	.560	.841	.37	.591	.484	.50

TABLE II - INSTALLATION DATA

SIZE DASH NO	INSTALLATION TAB P/N /6/	ALIGNMENT TOOL /25/	INSTALLATION HOLE SIZE
06	NAS1837T3	NAS1837G3	.561-.566
08	NAS1837T3	NAS1837G3	.561-.566
3	NAS1837T3	NAS1837G3	.561-.566
4	NAS1837T6	NAS1837G6	.686-.691
5	NAS1837T6	NAS1837G6	.686-.691
6 /26/	NAS1837T9	NAS1837G9	.842-.847

**MATERIAL:**

CARBON STEEL:

PER ASTM A108. ASTM A576, ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.

AL ALLOY:

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

CRES:

TYPE 303 (UNS S30300) PER ASTM A582/A582M.

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 1, CLASS OPTIONAL.

CRES:

 PASSIVATE PER AMS2700, METHOD 1, TYPE 2, CLASS 4.  
 PASSIVATE PER AMS2700, METHOD 2, CLASS 4.  
 SILVER PLATE PER AMS2410 OR AMS2411.  
 CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

 WITTEN COMPANY  
 918-272-9567

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# NAS1832

## INSERT, MOLDED IN, BLIND THREADED, LOCKING, NON-LOCKING, SANDWICH PANEL

LUBRICATION: SOLID FILM LUBRICANT PER AS5272, TYPE OPTIONAL, APPLIED TO THREADS ONLY.

**CODE:**

NAS1832 C 5 N 4 G M

LUBRICANT:

NO CODE = NO LUBRICANT  
"M" = SOLID FILM LUBE

FINISH:

IF CARBON STEEL:  
NO CODE = CADIUM PLATED

IF AL ALLOY:  
NO CODE = ANODIZED

IF CRES:  
NO CODE = PASSIVATE PER AMS2700, METHOD 1, TY2, CL4  
"G" = PASSIVATE PER AMS2700, METHOD 2, CL 4  
"P" = CADIUM PLATE  
"S" = SILVER PLATE

LENGTH DASH NUMBER:

(INCREMENTS OF .125) /10/

LOCKING:

"L" = LOCKING  
"N" = NON-LOCKING

SIZE DASH NUMBER:

(SEE TABLE I)

MATERIAL:

"-" = CARBON STEEL, CADIUM PLATED  
"A" = AL ALLOY, ANODIZED  
"C" = CRES, PASSIVATED

BASIC PART NUMBER

**NAS1832****INSERT, MOLDED IN, BLIND THREADED, LOCKING,  
NON-LOCKING, SANDWICH PANEL****EXAMPLE OF PART NUMBER:**

NAS1832C5N4GMT	= INSERT, CRES, .3125-24 UNJF THREAD, NON-LOCKING, .500 LONG, PASSIVATED PER AMS2700, METHOD 2, CL 4, SOLID FILM LUBRICATED.
NAS1832-3-4M	= INSERT, CARBON STEEL, .1900-32 UNJF-3B THREAD, LOCKING, .500 LONG, CADMIUM PLATED, SOLID FILM LUBRICATED.
NAS1832A3N4	= INSERT, AL ALLOY, .1900-32 UNJF-3B THREAD, NON-LOCKING, .500 LONG, ANODIZED, NON-LOCKING, NO LUBRICATION.
NAS1832C06-6G	= INSERT, CRES, .1380-32 UNJC-3B THREAD, LOCKING, .750 LONG, PASSIVATED PER AMS2700, METHOD 2, CL 4, NO LUBRICATION.
NAS1832C08-3S	= INSERT, CRES, .1640-32 UNJC-3B THREAD, LOCKING, .375 LONG, SILVER PLATED, NO LUBRICATION.
NAS1832C08-3P	= INSERT, CRES, .1640-32 UNJC-3B THREAD, LOCKING, .375 LONG, CADMIUM PLATED, NO LUBRICATION.
NAS1832C4N5	= INSERT, CRES, .2500-28 UNJF-3B THREAD, NON-LOCKING, .625 LONG, PASSIVATED PER AMS2700, METHOD 1, TY2, CL 4, NO LUBRICATION.
NAS1832C5N4	= INSERT, CRES, .3125-24 UNJF-3B THREAD, NON-LOCKING, .500 LONG, PASSIVATED PER AMS2700, METHOD 1, TY2, CL 4, NO LUBRICATION.
NAS1832-3-4M	= INSERT, CARBON STEEL, .1900-32 UNJF-3B THREAD, LOCKING, .500 LONG, CADMIUM PLATED, SOLID FILM LUBRICATED.
NAS1832C6-4G	= INSERT, CRES, .3750-24 UNJF-3B THREAD, LOCKING, .500 LONG, PASSIVATED PER AMS2700, METHOD 2, CL 4, NO LUBRICATION.

**NOTES:**

- /1/ THE MINIMUM FULL THREAD DEPTH "H" SHALL BE TWO TIMES THE NOMINAL THREAD DIAMETER WHERE LENGTH PERMITS.
- /2/ MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- /3/ THREADS PER AS8879, CLASS 3B.
- (4) LOCKING TORQUE PER NASM25027 EXCEPT 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) WHEN APPLICABLE, AN NAS1837 ADHESIVE-BACKED INSTALLATION TAB WILL BE FURNISHED WITH EACH INSERT. THE INSTALLATION TAB SUPPORTS THE INSERT DURING THE POTTING PROCESS AND IS REMOVED AND DISCARDED ONCE POTTING IS CURED.
- /7/ NONMETALLIC THREAD LOCK WHEN APPLICABLE. LOCATE PELLETT NO CLOSER THAN 10° FROM EDGE OF EITHER POTTING HOLE OR SLOT.
- /8/ BURRS AROUND POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.
- (9) PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON LOCKING CRES INSERTS.
- /10/ SELECT A LENGTH WHICH WILL ALLOW A MINIMUM OF .040 CLEARANCE BETWEEN BOTTOM OF INSERT AND INSIDE SURFACE OF BOTTOM SKIN.
- (11) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

# NAS1832

## INSERT, MOLDED IN, BLIND THREADED, LOCKING, NON-LOCKING, SANDWICH PANEL

**NOTES:**

- /12/ MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
- /13/ CENTERLINE OF THREAD LOCK WHEN APPLICABLE.
- /14/ SHANK DEFORMED THIS AREA TO PROVIDE THREAD LOCK WHEN APPLICABLE.
- /15/ ORIENTATION OF POTTING AND VENT HOLES OR SLOTS RELATIVE TO THE ANTI ROTATION FLAT IS MANUFACTURER'S OPTION.
- (16) DIMENSIONS IN INCHES.
- /17/ NOT USED.
- (18) ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUNOUT TO DATUM A.
- (19) DIMENSIONS APPLY AFTER FINISH AND PRIOR TO APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (20) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (21) REMOVE ALL BURRS AND SHARP EDGES.
- (22) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (23) 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.
- (24) FOR DESCRIPTION OF STATUS NOTES SEE NAS380.
- /25/ AN ADHESIVE-BACKED INSTALLATION TAB PER NAS1837 (PLASTIC PER WITTEN 2007) SHALL BE FURNISHED WITH INSERT.