

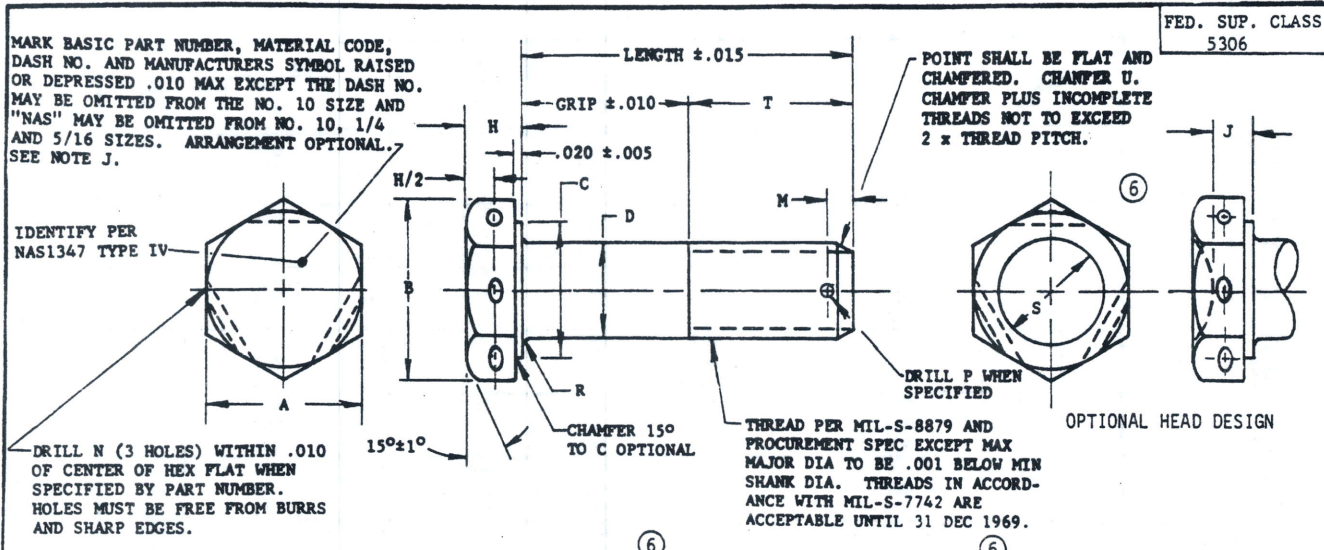


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NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N. W., WASHINGTON, D. C. 20036



BASIC PART NUMBER	THREAD UNJF-3A <div>⑥</div>	A	B REF	C MIN (d)	D DIA	H -.015 -.000	J	M +.010	N DIA +.010 -.000	P DIA +.010 -.000	R RAD	S	T REF	U MAX	INSPECTION DATA		
															X	Y	Z
															(a)	(a)	(b)
NAS673	.1900-32	.376 .367 .439	.43	.335	.1895 .1890 .2490	.110	.088 .073 .098	.163	.046	.070	.020 .010 .025	.18 .20 .24	.338	.016	.005	.0045	.0040
NAS674	.2500-28	.430 .502 .564	.51	.398	.2490 .3120 .3745	.125	.083 .119 .140	.181	.046	.076	.015 .030 .020	.26 .30 .32	.425	.018	.006	.0045	.0030
NAS675	.3125-24	.492 .564 .690	.58	.460	.3115 .3745 .4370	.156	.104 .140 .161	.181	.070	.076	.020 .030 .020	.32 .37 .39	.469	.021	.008	.0045	.0030
NAS676	.3750-24	.553 .690 .752	.65	.523	.3740 .4370 .4995	.188	.125 .161 .182	.201	.070	.106	.020 .030 .020	.39 .43 .45	.578	.021	.009	.006	.0025
NAS677	.4375-20	.679 .752 .741	.79	.648	.4365 .4995 .4990	.219	.146 .182 .167	.201	.070	.106	.020 .030 .020	.45 .49 .51	.594	.025	.010	.006	.0025
NAS678	.5000-20	.741	.87	.710	.4990	.250	.167	.216	.070	.106	.020	.735	.025	.011	.006	.0020	

MATERIAL: SEE PROCUREMENT SPECIFICATION

FINISH: NO PROTECTIVE FINISH REQUIRED

CODE: DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE SHEET 2)
~~NO LETTER BEFORE DASH NUMBER INDICATES 4AL 4MN MATERIAL (SEE NOTE H)~~
 ADD "V" BEFORE DASH NUMBER TO INDICATE 6AL-4V MATERIAL
 ADD "D" AFTER DASH NUMBER TO INDICATE DRILLED SHANK
 ADD "H" AFTER DASH NUMBER TO INDICATE DRILLED HEAD

EXAMPLE: ~~NAS674 10 = .2500 DIA BOLT, .625 GRIP, 4AL 4MN MATERIAL~~
 NAS674V10 = .2500 DIA BOLT, .625 GRIP, 6AL-4V MATERIAL
 NAS674V10D = .2500 DIA BOLT, .625 GRIP, DRILLED SHANK, 6AL-4V MATERIAL

- NOTES:**
- CONCENTRICITY: "C" AND "D" DIAMETERS WITHIN "X" VALUES TIR
 "D" AND THREAD PITCH DIAMETERS WITHIN "Y" VALUES TIR
 - SHANK STRAIGHTNESS: WITHIN "Z" VALUES INCH/INCH TIR
 - BOLTS SHALL BE FREE FROM BURRS AND SHARP EDGES
 - WASHER FACE DIAMETER: NOT TO EXCEED ACTUAL WIDTH ACROSS FLATS
 - ANGLE: UNDER SIDE OF HEAD TO SHANK: 90° + 30'/-00'
 - MAXIMUM ROUGHNESS HEIGHT RATING ANSI B46.1; HEAD TO SHANK FILLET, THREAD ROOT, THREAD SIDES, THREAD RUN-OUT 16 MICROINCHES, SHANK AND BEARING SURFACE OF HEAD 63 MICROINCHES, ALL OTHER SURFACES 125 MICROINCHES.
 - GRIP LENGTH: FROM UNDER SIDE OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
 - 4AL-4MN MATERIAL INACTIVE FOR DESIGN AFTER SEPT 1968. USE 6AL-4V MATERIAL.
 - PARTS IDENTIFIED PER THE ABOVE MARKING REQUIREMENTS ARE ACCEPTABLE UNTIL 31 DECEMBER 1979

DIMENSIONS IN INCHES

EDITORALLY UPDATED

LIST OF CURRENT SHEETS	
NO	REV
1	6
2	5

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION STANDARD PART
NAS 621	BOLT, CLOSE TOLERANCE-HEXAGON HEAD, TITANIUM, .190 TO .500	NAS673 thru 678 SHEET 1 OF 2