



National Aerospace Fasteners Corp.

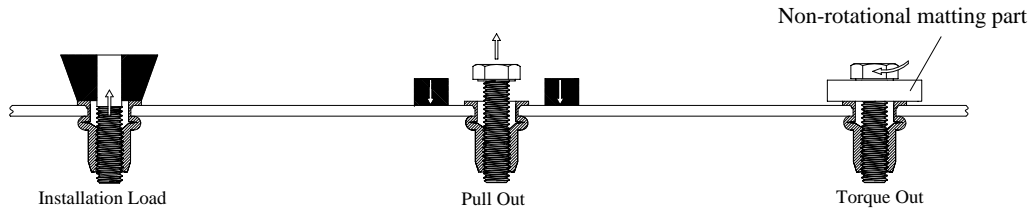


N K *SERIES*

RIB WALL

MINIMIZED PROFILE HEAD

Test Method



Engineering Data

Unified Thread

Thread Size	Installation Load (LBS)		Pull Out * (LBS)	Torque Out ** (Lb-In)
	Min grip	Max grip		
# 6 -32 UNC	585	1,130	2,000	60
# 8 -32 UNC	585	1,130	2,050	65
#10 -24 UNC	890	1,500	2,530	90
#10 -32 UNF	890	1,500	2,530	90
1/4 -20 UNC	995	1,680	2,980	200
1/4 -28 UNF	995	1,680	2,980	200
5/16-18 UNC	1,860	3,030	4,800	420
5/16-24 UNF	1,860	3,030	4,800	420
3/8 -16 UNC	1,860	3,030	4,800	540
3/8 -24 UNF	1,860	3,030	4,800	540

Metric Thread

Thread Size	Installation Load (KN)		Pull Out * (KN)	Torque Out ** (N-m)
	Min grip	Max grip		
M4X0.7	2.6	5.0	8.9	7.5
M5X0.8	4.0	6.7	11.3	10.0
M6X1.0	4.4	7.5	13.3	23.0
M8X1.25	8.3	13.5	21.4	48.0
M10X1.5	8.3	13.5	21.4	62.0

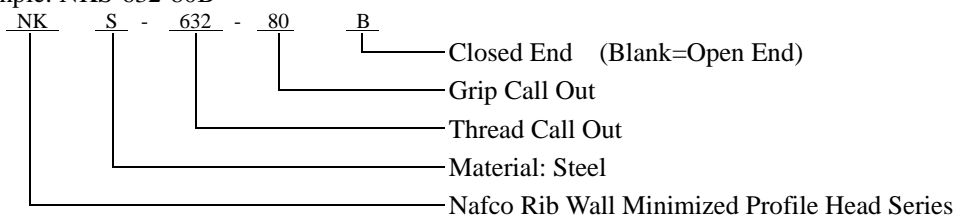
- * **Pull Out** is the force required to pull the NAFCO product from the parent material.
- ** **Torque Out** is the maximum recommended torque to be applied to the bolt (class 8.8/9.8), which will not cause thread distortion in the insert.
- *** These values are averages only- certain variations must be expected in actual application. NAFCO recommends that these values be used only as a guide.

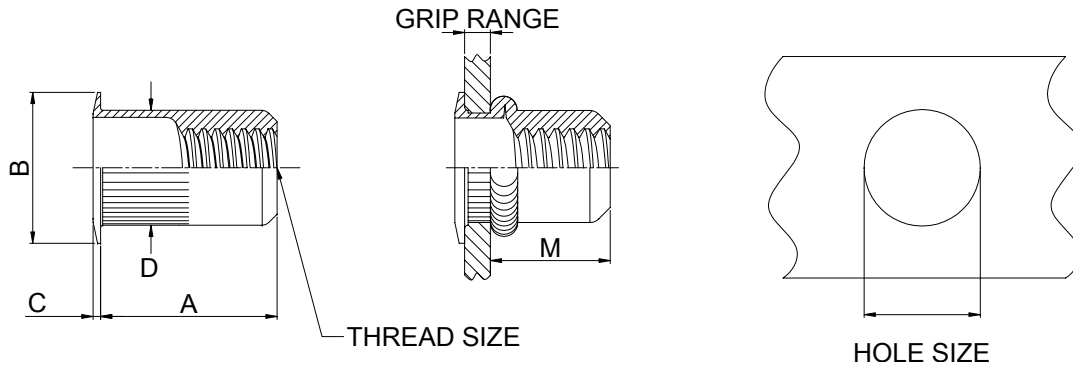
Fastener Specifications

Material: Steel 1008, 1010, or Equiv. Per SAE J403f
 Finish: Zinc Plate Yellow Chromate
 Per ASTM B633 Fe / Zn 8, Type II
 (Special Material and Plating also Available on Request)

Part Number Explanation

Example: NKS-632-80B





UNIFIED THREAD

Unit: Inch

THREAD SIZE	PART NUMBER	GRIP RANGE		A	B		C	D	M	HOLE SIZE
		Min.	Max.	± .015	Min.	Max.	± .003	Max.	Ref.	+ .004/- .000
# 6 -32 UNC	NKS-632-80	.020	.080	.420	.300	.320	.019	.265	.305	.266
# 6 -32 UNC	NKS-632-130	.080	.130	.470	.300	.320	.019	.265	.305	.266
# 8 -32 UNC	NKS-832-80	.020	.080	.420	.300	.320	.019	.265	.305	.266
# 8 -32 UNC	NKS-832-130	.080	.130	.470	.300	.320	.019	.265	.305	.266
#10 -24 UNC	NKS-1024-130	.020	.130	.475	.330	.350	.019	.296	.315	.297
#10 -24 UNC	NKS-1024-225	.130	.225	.585	.330	.350	.019	.296	.315	.297
#10 -32 UNF	NKS-1032-130	.020	.130	.475	.330	.350	.019	.296	.315	.297
#10 -32 UNF	NKS-1032-225	.130	.225	.585	.330	.350	.019	.296	.315	.297
1/4 -20 UNC	NKS-420-165	.027	.165	.580	.445	.465	.022	.390	.380	.391
1/4 -20 UNC	NKS-420-260	.165	.260	.680	.445	.465	.022	.390	.380	.391
1/4 -28 UNF	NKS-428-165	.027	.165	.580	.445	.465	.022	.390	.380	.391
1/4 -28 UNF	NKS-428-260	.165	.260	.680	.445	.465	.022	.390	.380	.391
5/16-18 UNC	NKS-518-150	.027	.150	.690	.581	.609	.022	.530	.470	.531
5/16-18 UNC	NKS-518-312	.150	.312	.805	.581	.609	.022	.530	.425	.531
5/16-24 UNF	NKS-524-150	.027	.150	.690	.581	.609	.022	.530	.470	.531
5/16-24 UNF	NKS-524-312	.150	.312	.805	.581	.609	.022	.530	.425	.531
3/8 -16 UNC	NKS-616-150	.027	.150	.690	.581	.609	.022	.530	.470	.531
3/8 -16 UNC	NKS-616-312	.150	.312	.805	.581	.609	.022	.530	.425	.531
3/8 -24 UNF	NKS-624-150	.027	.150	.690	.581	.609	.022	.530	.470	.531
3/8 -24 UNF	NKS-624-312	.150	.312	.805	.581	.609	.022	.530	.425	.531

METRIC THREAD

Unit: mm

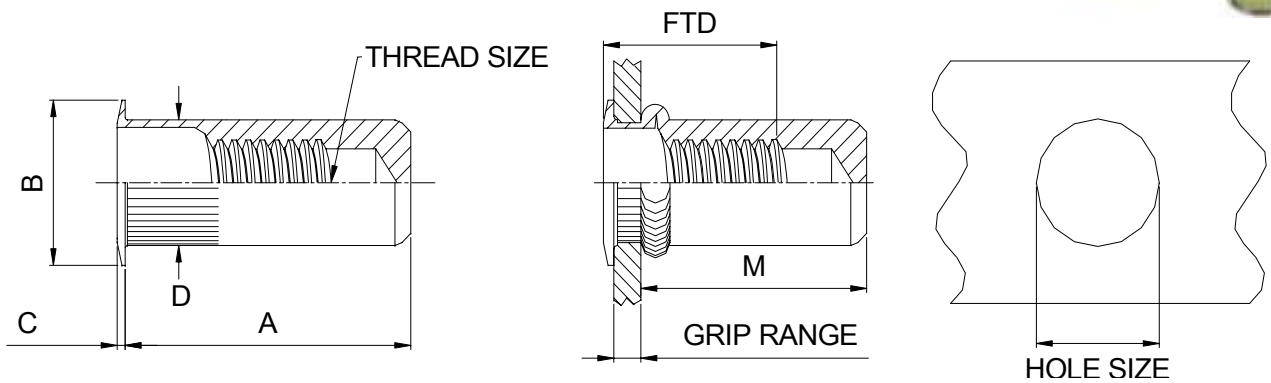
THREAD SIZE	PART NUMBER	GRIP RANGE		A	B		C	D	M	HOLE SIZE
		Min.	Max.	± 0.38	Min.	Max.	± 0.08	Max.	Ref.	+0.10/-0.00
M4 X0.7	NKS-470-2.0	0.50	2.00	10.67	7.62	8.12	0.48	6.73	7.75	6.75
M4 X0.7	NKS-470-3.3	2.00	3.30	11.94	7.62	8.12	0.48	6.73	7.75	6.75
M5 X0.8	NKS-580-3.3	0.50	3.30	12.07	8.39	8.89	0.48	7.52	8.00	7.60
M5 X0.8	NKS-580-5.7	3.30	5.70	14.86	8.39	8.89	0.48	7.52	8.00	7.60
M6 X1.0	NKS-610-4.2	0.70	4.20	14.73	11.31	11.81	0.55	9.91	9.65	10.00
M6 X1.0	NKS-610-6.6	4.20	6.60	17.27	11.31	11.81	0.55	9.91	9.65	10.00
M8 X1.25	NKS-8125-3.8	0.70	3.80	17.53	14.79	15.46	0.55	13.46	11.94	13.50
M8 X1.25	NKS-8125-7.9	3.80	7.90	20.45	14.79	15.46	0.55	13.46	10.80	13.50
M10X1.5	NKS-1015-3.8	0.70	3.80	17.53	14.79	15.46	0.55	13.46	11.94	13.50
M10X1.5	NKS-1015-7.9	3.80	7.90	20.45	14.79	15.46	0.55	13.46	10.80	13.50

*Actual grip range can be affected by parent material and hole size, contact NAFCO for details.

**Other sizes, threads and grip ranges are available on request.

NK-B

CLOSED END RIB WALL MINIMIZED PROFILE HEAD SERIES



UNIFIED THREAD

Unit: Inch

THREAD SIZE	PART NUMBER	GRIP RANGE		A ± .015	B		C ± .003	D Max.	M Ref.	FTD Max.	HOLE SIZE +0.004/-0.000
		Min.	Max.		Min.	Max.					
# 6 -32 UNC	NKS-632-80B	.020	.080	.740	.300	.320	.019	.265	.640	.610	.266
# 6 -32 UNC	NKS-632-130B	.080	.130	.740	.300	.320	.019	.265	.580	.670	.266
# 8 -32 UNC	NKS-832-80B	.020	.080	.740	.300	.320	.019	.265	.640	.610	.266
# 8 -32 UNC	NKS-832-130B	.080	.130	.740	.300	.320	.019	.265	.580	.670	.266
#10 -24 UNC	NKS-1024-130B	.020	.130	.990	.330	.350	.019	.296	.845	.730	.297
#10 -24 UNC	NKS-1024-225B	.130	.225	.990	.330	.350	.019	.296	.735	.840	.297
#10 -32 UNF	NKS-1032-130B	.020	.130	.990	.330	.350	.019	.296	.845	.730	.297
#10 -32 UNF	NKS-1032-225B	.130	.225	.990	.330	.350	.019	.296	.735	.840	.297
1/4 -20 UNC	NKS-420-165B	.027	.165	1.190	.445	.465	.022	.390	1.005	.895	.391
1/4 -20 UNC	NKS-420-260B	.165	.260	1.190	.445	.465	.022	.390	.905	1.035	.391
1/4 -28 UNF	NKS-428-165B	.027	.165	1.190	.445	.465	.022	.390	1.005	.895	.391
1/4 -28 UNF	NKS-428-260B	.165	.260	1.190	.445	.465	.022	.390	.905	1.035	.391
5/16-18 UNC	NKS-518-150B	.027	.150	1.390	.581	.609	.022	.530	1.175	.995	.531
5/16-18 UNC	NKS-518-312B	.150	.312	1.390	.581	.609	.022	.530	1.025	1.120	.531
5/16-24 UNF	NKS-524-150B	.027	.150	1.390	.581	.609	.022	.530	1.175	.995	.531
5/16-24 UNF	NKS-524-312B	.150	.312	1.390	.581	.609	.022	.530	1.025	1.120	.531
3/8 -16 UNC	NKS-616-150B	.027	.150	1.390	.581	.609	.022	.530	1.175	.995	.531
3/8 -16 UNC	NKS-616-312B	.150	.312	1.390	.581	.609	.022	.530	1.025	1.120	.531
3/8 -24 UNF	NKS-624-150B	.027	.150	1.390	.581	.609	.022	.530	1.175	.995	.531
3/8 -24 UNF	NKS-624-312B	.150	.312	1.390	.581	.609	.022	.530	1.025	1.120	.531

METRIC THREAD

Unit: mm

THREAD SIZE	PART NUMBER	GRIP RANGE		A ± .015	B		C ± .003	D Max.	M Ref.	FTD Max.	HOLE SIZE +0.10/-0.00
		Min.	Max.		Min.	Max.					
M4 X0.7	NKS-470-2.0B	0.50	2.00	18.80	7.62	8.12	0.48	6.73	16.26	15.49	6.75
M4 X0.7	NKS-470-3.3B	2.00	3.30	18.80	7.62	8.12	0.48	6.73	14.73	17.02	6.75
M5 X0.8	NKS-580-3.3B	0.50	3.30	25.15	8.39	8.89	0.48	7.52	21.46	18.54	7.60
M5 X0.8	NKS-580-5.7B	3.30	5.70	25.15	8.39	8.89	0.48	7.52	18.67	21.34	7.60
M6 X1.0	NKS-610-4.2B	0.70	4.20	30.23	11.31	11.81	0.55	9.91	25.53	22.73	10.00
M6 X1.0	NKS-610-6.6B	4.20	6.60	30.23	11.31	11.81	0.55	9.91	22.99	26.29	10.00
M8 X1.25	NKS-8125-3.8B	0.70	3.80	35.31	14.76	15.46	0.55	13.46	29.85	25.27	13.50
M8 X1.25	NKS-8125-7.9B	3.80	7.90	35.31	14.76	15.46	0.55	13.46	26.04	28.45	13.50
M10X1.5	NKS-1015-3.8B	0.70	3.80	35.31	14.76	15.46	0.55	13.46	29.85	25.27	13.50
M10X1.5	NKS-1015-7.9B	3.80	7.90	35.31	14.76	15.46	0.55	13.46	26.04	28.45	13.50

*Actual grip range can be affected by parent material and hole size, contact NAFCO for details.

**Other sizes, threads and grip ranges are available on request.

***FTD to express full thread



QS9000

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