

FED. SUPPLY CLASS

5320

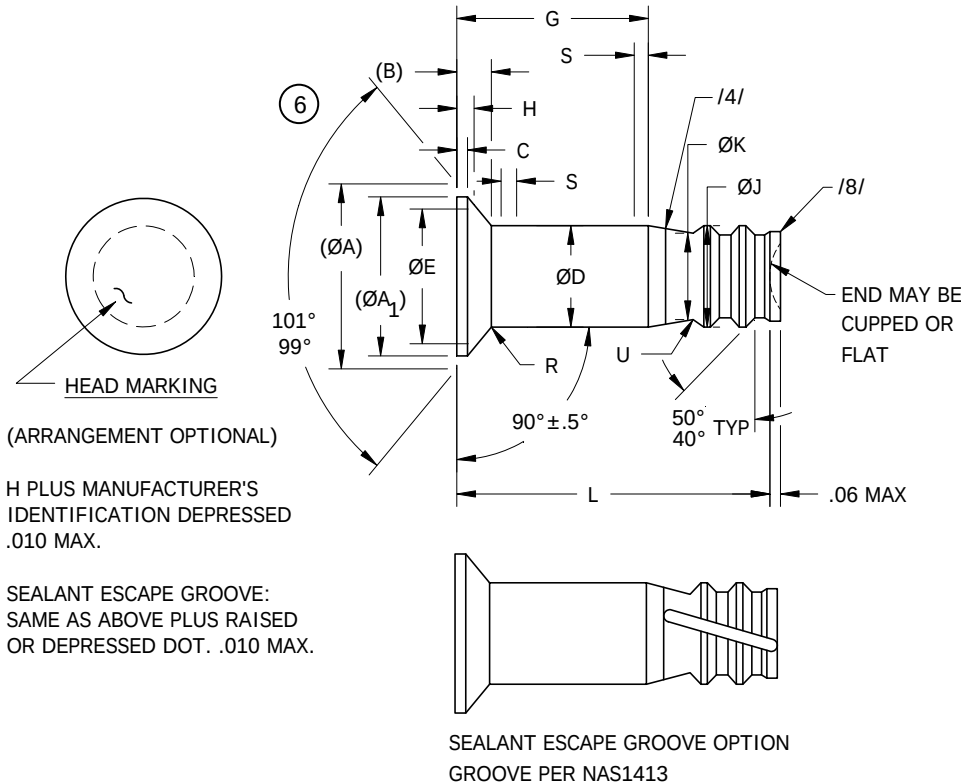
AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 12-01

REVISION DATE: SEPTEMBER 19, 2014

ISSUE DATE: MAY 1960



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TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK	(ØA) MAX /5/	(ØA ₁) MIN /5/	(B) MAX /5/	C MAX	GAGE			ØJ	ØK	R RAD	S MAX /7/	U MAX RAD
							ØE +.0002 -.0000 /6/	H /6/ PROTRUSION						
								NOM	±TOL					
NAS1414	.125	.1250 .1235	.211	.180	.037	.009	.1626	.0182	.0015	.122 .117	.105 .099	.015 .005	.021	.020
NAS1415	.156	.1565 .1550	.256	.220	.042	.011	.2026	.0203	.0017	.152 .146	.127 .121	.015 .005	.026	.020
NAS1416	.190	.1895 .1880	.305	.263	.049	.013	.2439	.0230	.0020	.185 .177	.151 .143	.015 .008	.031	.020
NAS1418	.250	.2495 .2480	.399	.346	.063	.017	.3313	.0255	.0023	.246 .235	.201 .190	.020 .010	.042	.020
NAS1420	.312	.3120 .3105	.479	.417	.071	.020	.4045	.0280	.0025	.300 .290	.255 .246	.025 .010	.052	.025
NAS1422	.375	.3745 .3730	.566	.496	.081	.023	.4852	.0305	.0028	.369 .354	.315 .303	.030 .010	.062	.025

MATERIAL:

ALLOY STEEL PER PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

6 160,000-180,000 PSI PER AMS2759; HARDNESS PER PROCUREMENT SPECIFICATION.

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	
NAS1413	

CUSTODIAN	
NATIONAL AEROSPACE STANDARDS COMMITTEE	
TITLE	
PIN, SWAGE LOCKING, STEEL, 100° SHEAR HEAD, STUMP TYPE	

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CLASSIFICATION PART STANDARD	
NAS1413-1422 2014	
SHEET 1 OF 3	

FINISH:

CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
NICKEL-CADMIUM PLATING PER AMS2416. /9/

LUBRICATION:

CETYL ALCOHOL PER PROCUREMENT SPECIFICATION.

CODE: DASH NUMBER DESIGNATES MAXIMUM GRIP IN .0625 INCREMENTS.
ADD "-" AFTER BASIC NUMBER FOR CADMIUM PLATE.

EXAMPLE OF PART NUMBER:

NAS1416 H N 08

- GRIP (SEE CODE)
- ADD "N" AFTER BASIC NUMBER FOR NICKEL-CADMIUM PLATING
- ADD "H" AFTER BASIC NUMBER WHEN SEALANT ESCAPE GROOVE IS REQUIRED
- BASIC NUMBER

NAS1416-08 = .190 DIAMETER STEEL PIN, 100° FLUSH HEAD, STUMP TYPE, .500 GRIP,
TYPE II CADMIUM PLATE.

NAS1416N08 = .190 DIAMETER STEEL PIN, 100° FLUSH HEAD, STUMP TYPE, .500 GRIP,
NICKEL-CADMIUM PLATE.

NAS1416H08 = .190 DIAMETER STEEL PIN, 100° FLUSH HEAD, SEALANT GROOVE, STUMP TYPE,
.500 GRIP, TYPE II CADMIUM PLATE.

NAS1416HN08 = .190 DIAMETER STEEL PIN, 100° FLUSH HEAD, SEALANT GROOVE, STUMP TYPE,
.500 GRIP, NICKEL-CADMIUM PLATE.

NOTES:

- (1) DIMENSIONS IN INCHES.
- (2) FOR RECOMMENDED HOLE SIZES, SEE NAS618.
- (3) FOR COLLAR SELECTION, MINIMUM TENSILE STRENGTH, AND INSPECTION GAGE, SEE NAS1080.
- /4/ SLIGHT HOOK PERMITTED WHERE TAPER OF LOCKING GROOVE MEETS TAPER OF ORIGINAL BLANK.
- /5/ DIMENSIONS $\varnothing A$, $\varnothing A_1$ & B: INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY, NOT FOR INSPECTION PURPOSES. VALUES, $\varnothing A$, $\varnothing A_1$ & B: CALCULATED LIMITS RESULTING FROM TOLERANCES ON C, $\varnothing D$, $\varnothing E$, H & HEAD ANGLE.
- /6/ GAGE PROTRUSION (H): SEE NAS1413 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
- /7/ AT THE INTERSECTION OF THE HEAD TO SHANK, " $\varnothing D$ " MAY BE .002 LARGER THAN MAX " $\varnothing D$ " FOR DISTANCE "S" AS MEASURED FROM THE TANGENCY OF "R" RADIUS. " $\varnothing D$ " IMMEDIATELY BEFORE THE END OF GRIP "G" MAY BE .001 SMALLER THAN MIN " $\varnothing D$ " FOR DISTANCE "S".
- /8/ CHAMFER OR RADIUS OR PARTIAL LAND PERMISSIBLE, .06 MAX.

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NAS1414-THRU-NAS1422
SHEET 2



Documents

Document Sharing Hub