

FED. SUPPLY CLASS

5320

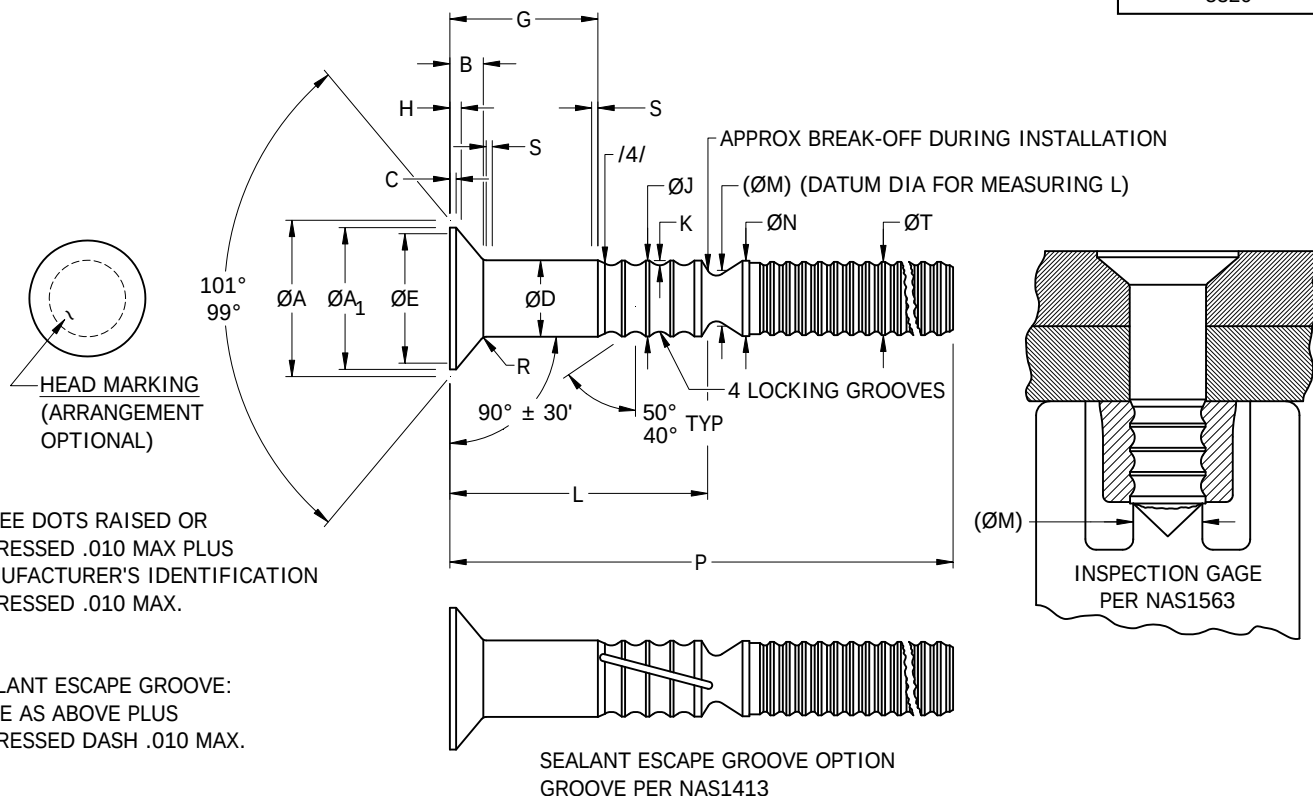


TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK	ØA MAX /5/	ØA ₁ MIN /5/	B MAX /5/	C MAX	GAGE			ØJ	K	(ØM) GAGE	ØN	R RAD	S MAX /7/	ØT MAX
							ØE +.0002 -.0000 /6/	H PROTRUSION /6/								
								NOM	± TOL							
NAS1516	.190	.1895 .1880	.386	.344	.084	.013	.3270	.0224	.0019	.185 .177	.015 .011	.164	.185 .169	.020 .010	.031	.183
NAS1518	.250	.2495 .2480	.507	.455	.110	.017	.4318	.0290	.0020	.242 .235	.018 .014	.224	.242 .221	.020 .010	.042	.243
NAS1520	.312	.3120 .3105	.634	.574	.137	.020	.5449	.0346	.0021	.305 .294	.023 .017	.268	.305 .276	.025 .010	.052	.299
NAS1522	.375	.3745 .3730	.762	.693	.165	.023	.6580	.0404	.0024	.368 .361	.027 .021	.339	.368 .336	.030 .010	.062	.359

THIRD
ANGLE
PROJECTION

PROCUREMENT
SPECIFICATION

NAS1413

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

**PIN, SWAGE LOCKING,
ALUMINUM ALLOY,
100° HEAD (NASM24694), PULL-TYPE**

REVISION

4

CLASSIFICATION
PART STANDARD

NAS1516-1522 2016
SHEET 1 OF 3

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
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: MARCH 31, 2016

ISSUE DATE: MAY 1960

MATERIAL: 7075 ALUMINUM ALLOY PER PROCUREMENT SPECIFICATION.

HEAT TREAT: T6 PER AMS2772; PER PROCUREMENT SPECIFICATION.

FINISH: ANODIZE PER MIL-A-8625 OR CHEMICAL SURFACE TREATMENT PER MIL-DTL-5541.

LUBRICATION: CETYL ALCOHOL PER PROCUREMENT SPECIFICATION.

CODE: DASH NUMBER DESIGNATES NOMINAL GRIP IN .0625 INCREMENTS.
ADD "H" AFTER BASIC NUMBER WHEN SEALANT ESCAPE GROOVE IS REQUIRED.

EXAMPLE OF PART NUMBER:

④ NAS1516-08 = Ø.190 7075 ALUMINUM ALLOY PIN, 100° FLUSH HEAD (NASM24694),
PULL-TYPE, .500 GRIP.

NAS1516H08 = Ø.190 7075 ALUMINUM ALLOY PIN, 100° FLUSH HEAD (NASM24694),
SEALANT ESCAPE GROOVE, PULL-TYPE, .500 GRIP.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (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 ØA, ØA₁ & B: INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY, NOT FOR INSPECTION PURPOSES.
VALUES ØA, ØA₁ & B: CALCULATED LIMITS RESULTING FROM TOLERANCES ON C, ØD, ØE, 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, "ØD" MAY BE .002 LARGER THAN MAX "ØD" FOR DISTANCE "S" AS MEASURED FROM THE TANGENCY OF "R" RADIUS. "ØD" IMMEDIATELY BEFORE THE END OF GRIP "G" MAY BE .001 SMALLER THAN MIN "ØD" FOR DISTANCE "S".
- ④ (8) 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.
- (9) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

REVISION

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NAS1516-08-101
SHEET 2



Documents
Document Sharing Hub