

FED. SUPPLY CLASS

5320

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

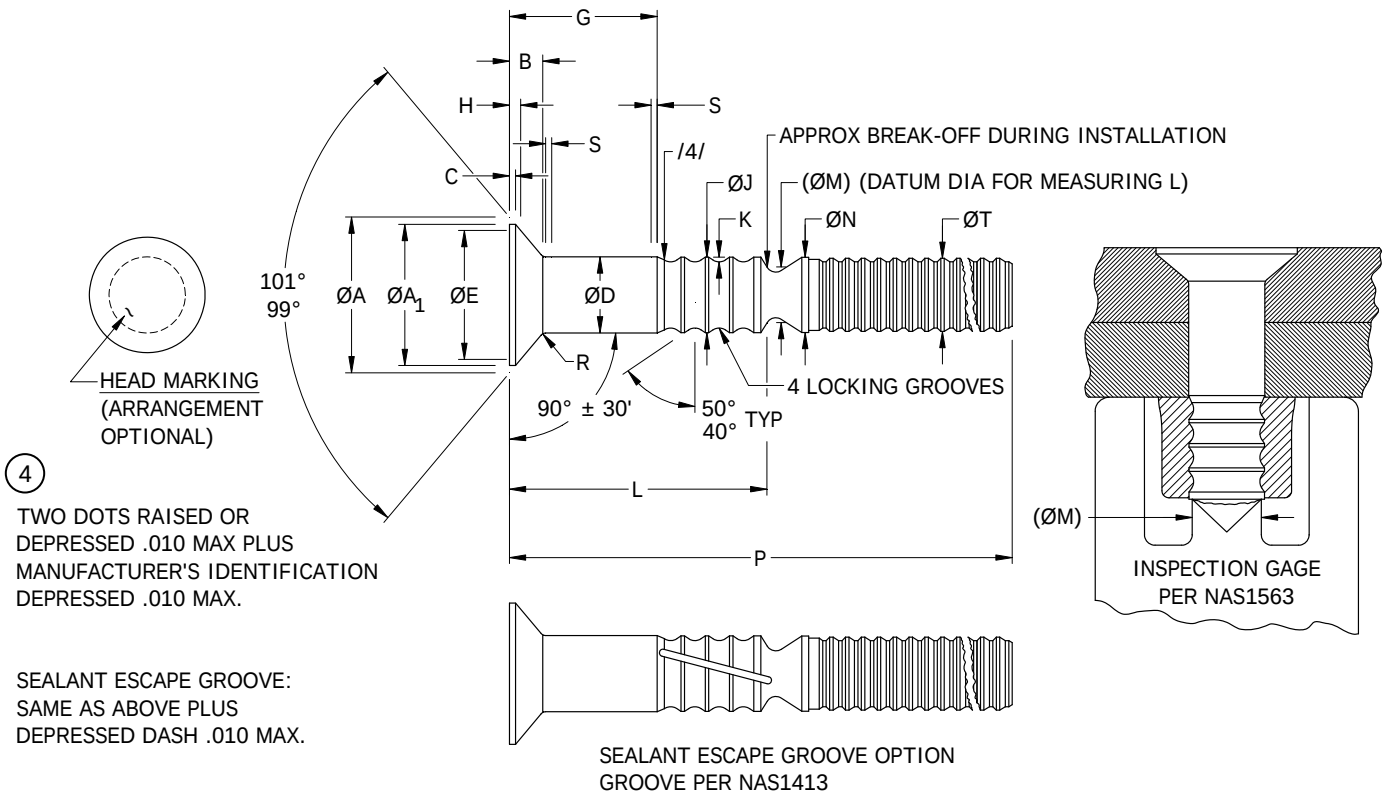


TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK /14/ 	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							
NAS1535	.164	.1650 .1635	.292	.263	.055	.008	.2558	.0130	.0018	.158 .152	.012 .008	.136	.158 .144	.020 .010	.026	.158
NAS1536	.190	.1895 .1880	.357	.316	.071	.011	.2980	.0224	.0019	.185 .177	.015 .011	.164	.185 .169	.020 .010	.031	.183
NAS1538	.250	.2495 .2480	.480	.428	.098	.015	.4048	.0290	.0020	.242 .235	.018 .014	.224	.242 .221	.020 .010	.042	.243
NAS1540	.312	.3120 .3105	.568	.508	.109	.018	.4789	.0346	.0021	.305 .294	.023 .017	.268	.305 .276	.025 .010	.052	.299
NAS1542	.375	.3745 .3730	.698	.629	.137	.021	.5940	.0404	.0024	.368 .361	.027 .021	.339	.368 .336	.030 .010	.062	.359

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.

REVISION DATE: MAY 31, 2013

ISSUE DATE: MAY 1960

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION NAS1413	TITLE PIN, SWAGE LOCKING, ALUMINUM ALLOY, 100° HEAD (NASM20426), TENSION, PULL-TYPE	CLASSIFICATION PART STANDARD
		NAS1535 THRU NAS1542
		SHEET 1 OF 3

MATERIAL:

7075 ALUMINUM ALLOY PER PROCUREMENT SPECIFICATION.

HEAT TREAT:

T6 CONDITION 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:

NAS1536-08 = .190 DIA 7075 ALUMINUM ALLOY PIN, 100° FLUSH HEAD (NASM24694),
PULL-TYPE, .500 GRIP.

NAS1536H08 = .190 DIA 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".
- (8) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

REVISION

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NAS1535 THRU
NAS1542

SHEET 2



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