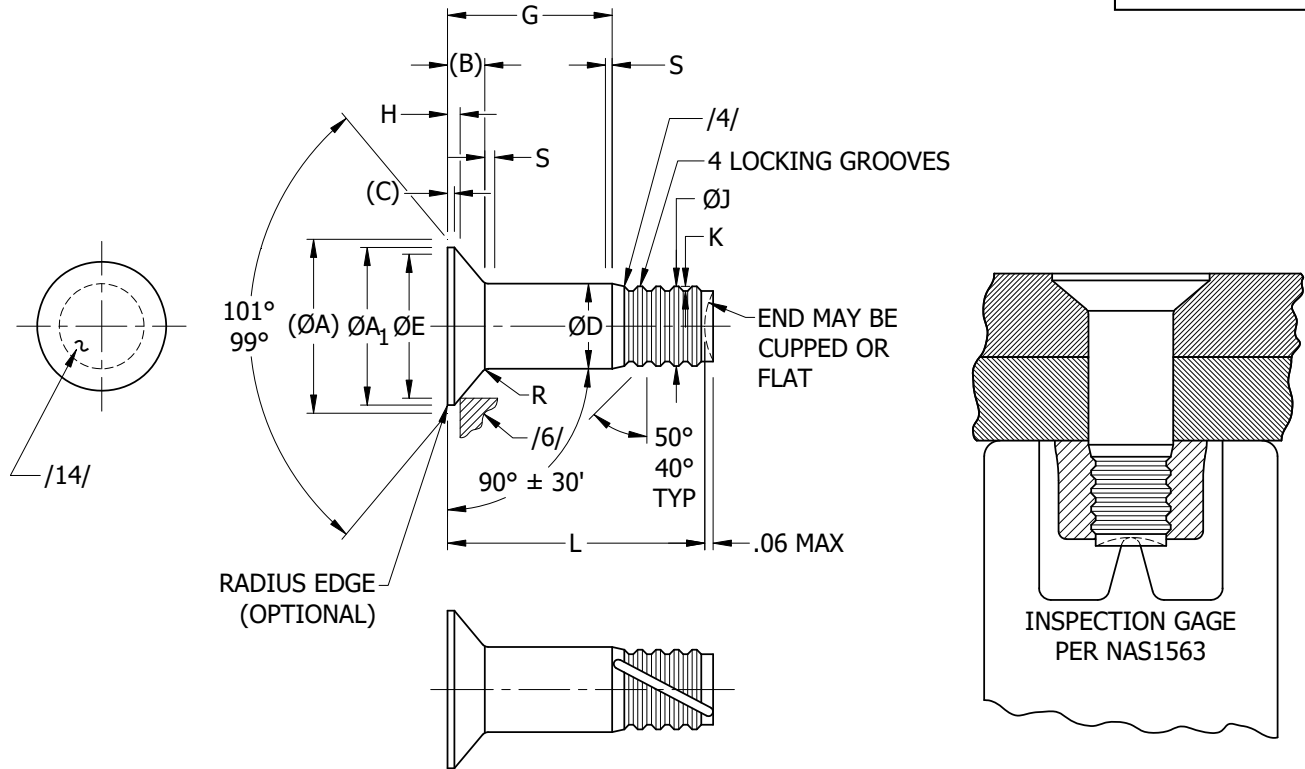


FED. SUPPLY CLASS

5320



SEALANT ESCAPE GROOVE OPTION
GROOVE PER NAS1413

TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK	(ØA) MAX /5/	ØA ₁ MIN	(B) MAX /5/	(C) MAX /5/	GAGE			ØJ	K	R RAD	S MAX /7/
							ØE +.0002 -.0000 /6/	H PROTRUSION /6/					
								NOM	± TOL				
NAS1546	.190	.1895 .1880	.386	.344	.084	.013	.3270	.0224	.0019	.185 .175	.014 .010	.020 .010	.031
NAS1548	.250	.2495 .2480	.507	.455	.110	.017	.4318	.0290	.0020	.242 .231	.018 .017	.020 .010	.042
NAS1550	.312	.3120 .3105	.634	.574	.137	.020	.5449	.0346	.0021	.305 .293	.023 .017	.025 .010	.052
NAS1552	.375	.3745 .3730	.762	.693	.165	.023	.6580	.0404	.0024	.368 .354	.027 .021	.030 .010	.062

④ COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION NAS1413	TITLE PIN, SWAGE LOCKING, ALUMINUM ALLOY, 100° HEAD (NASM24694), TENSION, STUMP-TYPE	CLASSIFICATION PART STANDARD NAS1413

MATERIAL:

7075 ALUMINUM ALLOY PER PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

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.

EXAMPLES OF PART NUMBERS:

- ④ NAS1546-08 = Ø.190, 7075 ALUMINUM ALLOY PIN, 100° FLUSH HEAD (NASM24694), STUMP-TYPE, .500 GRIP.
- ④ NAS1546H08 = Ø.190, 7075 ALUMINUM ALLOY PIN, 100° FLUSH HEAD (NASM24694), SEALANT ESCAPE GROOVE, STUMP-TYPE, .500 GRIP.

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.
- ④ /5/ DIMENSIONS (ØA), (B) & (C) ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY, AND ARE NOT TO BE USED FOR INSPECTION.
(ØA), (ØE) & (H) VALUES ARE CALCULATED LIMITS RESULTING FROM THE ACCUMULATED TOLERANCE ON THE SHANK DIAMETER, HEAD ANGLE, AND THE APPLICABLE HEAD PROTRUSION AND GAGE DIAMETER.
- ④ /6/ FLUSHNESS GAGE PROTRUSION SHALL BE INSPECTED PER NAS1413.
- /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) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (9) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

REVISION

4

NAS1546-1552
SHEET 2



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