

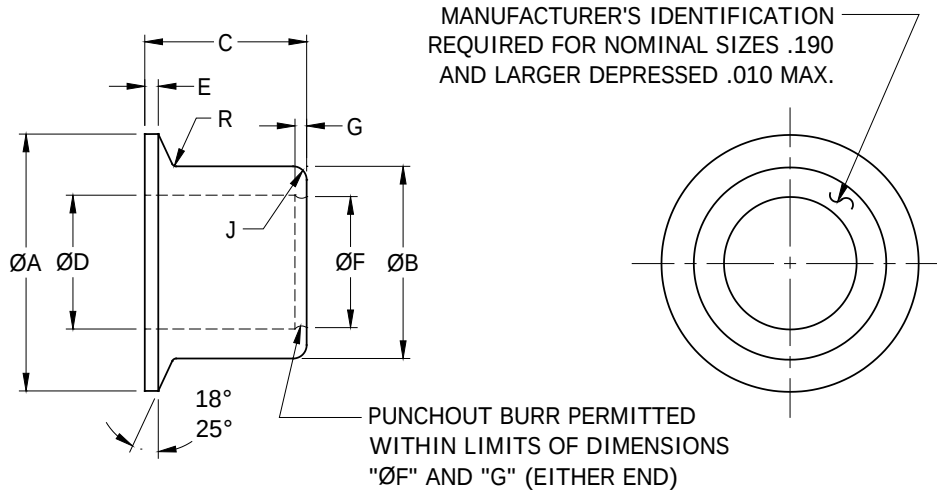


FIGURE 1 - COLLAR

TABLE I - DIMENSIONS

PART NUMBER	NOMINAL SIZE	ØA	ØB	C	ØD	E	ØF	G	J MIN	R	INSTALL WITH
NAS2013-05	.164	.334 .314	.248 .244	.235 .215	.1655 .1625	.030 .020	.159	.016	.010	.018 .008	NAS2015, NAS2025, NAS2035, NAS2045, NAS2055, NAS2065
NAS2013-06	.190	.388 .368	.274 .270	.240 .220	.1910 .1880	.030 .020	.186	.016	.015	.018 .008	NAS2016, NAS2026, NAS2036, NAS2046, NAS2056, NAS2066
NAS2013-08	.250	.477 .457	.357 .353	.300 .280	.2515 .2485	.035 .025	.246	.016	.025	.018 .008	NAS2018, NAS2028, NAS2038, NAS2048, NAS2058, NAS2068
NAS2013-10	.312	.604 .584	.448 .444	.370 .350	.3130 .3100	.035 .025	.308	.031	.025	.023 .013	NAS2020, NAS2030, NAS2040, NAS2050, NAS2060, NAS2070
NAS2013-12	.375	.701 .681	.533 .529	.420 .400	.3755 .3725	.040 .030	.370	.031	.025	.023 .013	NAS2022, NAS2032, NAS2042, NAS2052, NAS2062, NAS2072

① COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NAS2014	TITLE COLLAR, GROOVED, PIN-RIVET, TITANIUM, (COMPOSITE APPLICATIONS)	CLASSIFICATION PART STANDARD



NAS2014
SHEET 1 OF 3
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MATERIAL:

CP TITANIUM, PER ASTM B348.

LUBRICATION:

DRY FILM PER AS5272 PLUS CHLORINE FREE CETYL ALCOHOL, PER AS87132.

CODE:

DASH NUMBER DESIGNATES INTERNAL DIAMETER "ØD" IN .0625 INCREMENTS.

EXAMPLE OF PART NUMBER:

NAS2013-6 = .190 DIA CP TITANIUM, COLLAR, GROOVED, PIN-RIVET.

NAS2013-10 = .312 DIA CP TITANIUM, COLLAR, GROOVED, PIN-RIVET.

NOTES:

- /1/ PERMISSIBLE PUNCHOUT FLASH NOT TO EXCEED .015 IN LENGTH (PERMISSIBLE ON EITHER END OF DOUBLE ENDED AND FLANGE COLLARS).
- /2/ PUNCHOUT INTERRUPTION IN CONTINUITY OF THIS SURFACE IS PERMISSIBLE.
- /3/ PERMISSIBLE PUNCHOUT BURR PERMITTED AS INDICATED AND LIMITED ON INDIVIDUAL COLLAR STANDARDS.
- /4/ CIRCUMFERENTIAL LAPS IN THE ENDS OF COLLARS ARE ACCEPTABLE FABRICATION CHARACTERISTICS PROVIDED THEY DO NOT EXTEND IN A DIRECTION PARALLEL TO THE AXIS OF THE COLLAR TO A DEPTH GREATER THAN THE WALL THICKNESS OF THE COLLAR.
- /5/ RADIAL DISCONTINUITIES HAVING A DEPTH OR WIDTH IN EXCESS OF 2.5 PERCENT OF THE I.D. OF THE COLLAR AND EXTENDING FROM THE INSIDE DIAMETER TO THE OUTSIDE DIAMETER ARE NOT ACCEPTABLE.
- /6/ .020 MAXIMUM DEPTH CHAMFER (OR AS INDICATED AND LIMITED ON INDIVIDUAL COLLAR STANDARD SHEET) PERMITTED ON ONE END OR BOTH ENDS OF COLLAR.
- /7/ PERMISSIBLE O.D. FLASH NOT TO EXCEED .015 IN LENGTH (EITHER END) BLENDED RADIUS PERMITTED AT JUNCTURE OF O.D. AND ANGLE.
- /8/ BLENDED RADIUS PERMITTED AT JUNCTURE OF O.D. AND ANGLE.
- /9/ PERMISSIBLE COLD-HEAD UNDERFILL OF ANGLE NOT TO EXCEED .001 INCH IN DEPTH PER .062 INCH OF I.D.
- (10) SUGGESTED TEMPERATURE LIMITATIONS: ROOM TEMPERATURE TO 250 °F.
- (11) DIMENSIONS IN INCHES AND APPLY PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (12) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

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REVISION

1

NAS2013

SHEET 2

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