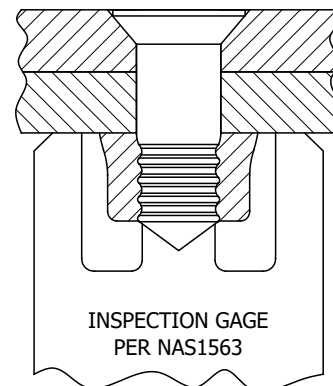
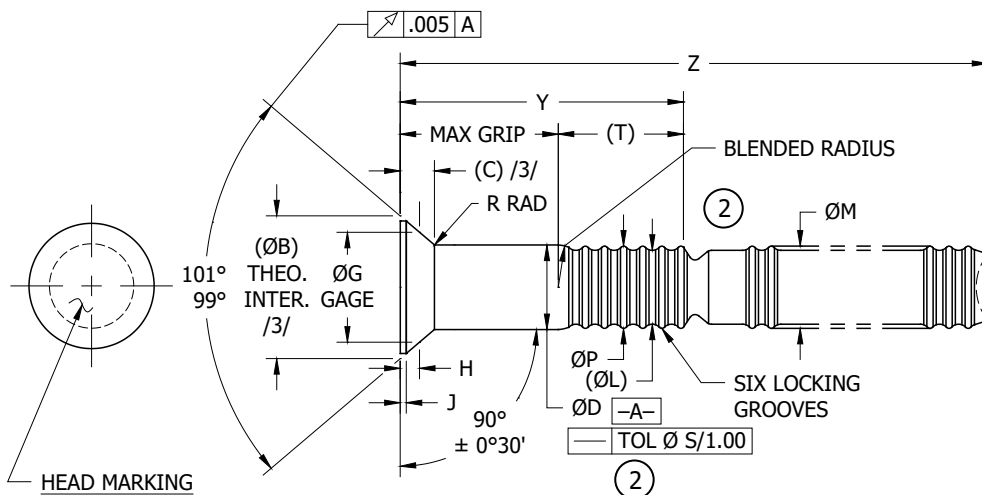


FED. SUPPLY CLASS

5320

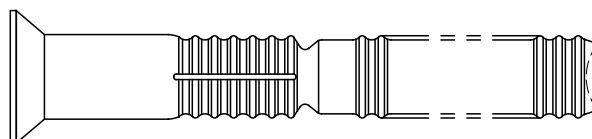
AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209



INSPECTION GAGE
PER NAS1563

HEAD MARKING
(ARRANGEMENT OPTIONAL)
DASH PLUS MANUFACTURER'S
IDENTIFICATION
DEPRESSED .010 MAX.

SEALANT ESCAPE GROOVE:
SAME AS ABOVE PLUS
RAISED OR DEPRESSED DOT
.010 MAX.



SEALANT ESCAPE GROOVE OPTION
GROOVE PER NAS2014

(2)

TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK		(ØB) HEAD /3/	(C) HEAD HEIGHT /3/	ØG GAGE		H GAGE HEIGHT		J MAX	(ØL)	ØM MAX	ØP MAX	R RADIUS		S	(T)
		MAX	MIN			MAX	MIN	MAX	MIN					MAX	MIN		
NAS2025	.1640	.1635	.1630	.332	.073	.2832	.2830	.0202	.0175	.010	.126	.156	.156	.025	.015	.0045	.175
NAS2026	.1900	.1895	.1890	.383	.084	.3272	.3270	.0230	.0200	.013	.150	.184	.184	.030	.020	.0045	.176
NAS2028	.2500	.2495	.2490	.510	.110	.4320	.4318	.0322	.0288	.017	.187	.244	.244	.030	.020	.0045	.244
NAS2030	.3125	.3120	.3115	.637	.137	.5451	.5449	.0378	.0342	.020	.244	.306	.306	.040	.030	.0045	.313
NAS2032	.3750	.3745	.3740	.765	.165	.6582	.6580	.0439	.0401	.023	.298	.368	.370	.040	.030	.0060	.374

MATERIAL:

6Al-4V TITANIUM ALLOY (UNS R56400) PER AMS4967.

LUBRICATION:

CETYL ALCOHOL LUBE (CHLORINE FREE) PER MIL-L-87132 AS87132, TYPE I.

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: APRIL 30, 2019

ISSUE DATE: JUNE 1991

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2	
		CLASSIFICATION PART STANDARD	
PROCUREMENT SPECIFICATION NAS2014	TITLE PIN, RIVET, GROOVED, TITANIUM, COMPOSITE APPLICATIONS, 100° FLUSH HEAD, PULL-TYPE	NAS2025 THRU NAS2032	
		SHEET 1 OF 3	

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CODE:

(2)

NAS2028 H 10

DASH NUMBER DESIGNATES NOMINAL GRIP RANGE IN .0625 INCREMENTS PER TABLE II

H = SEALANT ESCAPE GROOVE
"–" = NO SEALANT ESCAPE GROOVE

BASIC PART NUMBER PER TABLE I

EXAMPLES OF PART NUMBER:

NAS2026-08 = Ø.1900 TITANIUM PIN, RIVET, GROOVED, 100° FLUSH HEAD, PULL-TYPE, .500 GRIP.
NAS2028H10 = Ø.2500 TITANIUM PIN, RIVET, GROOVED, 100° FLUSH HEAD, SEALANT ESCAPE GROOVE, PULL-TYPE, .625 GRIP.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (2) FOR RECOMMENDED HOLE SIZE, SEE NAS618.
- /3/ DIMENSIONS "(ØB)" AND "(C)" FOR ENGINEERING REFERENCE ONLY, NOT FOR INSPECTION PURPOSES.
- (4) MINIMUM SHEAR STRENGTH: 95 KSI.
- (5) SURFACE ROUGHNESS: BEARING SURFACE, HEAD TO SHANK RADIUS, AND SHANK AND LEAD-IN RADIUS: 32 MICROINCHES Ra; ALL OTHER SURFACES: 125 MICROINCHES Ra PER ASME B46.1.
- (6) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (7) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (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) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

2

NAS2025 THRU
NAS2032

SHEET 2



Documents

Document Sharing Hub

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