

FED. SUPPLY CLASS

5320

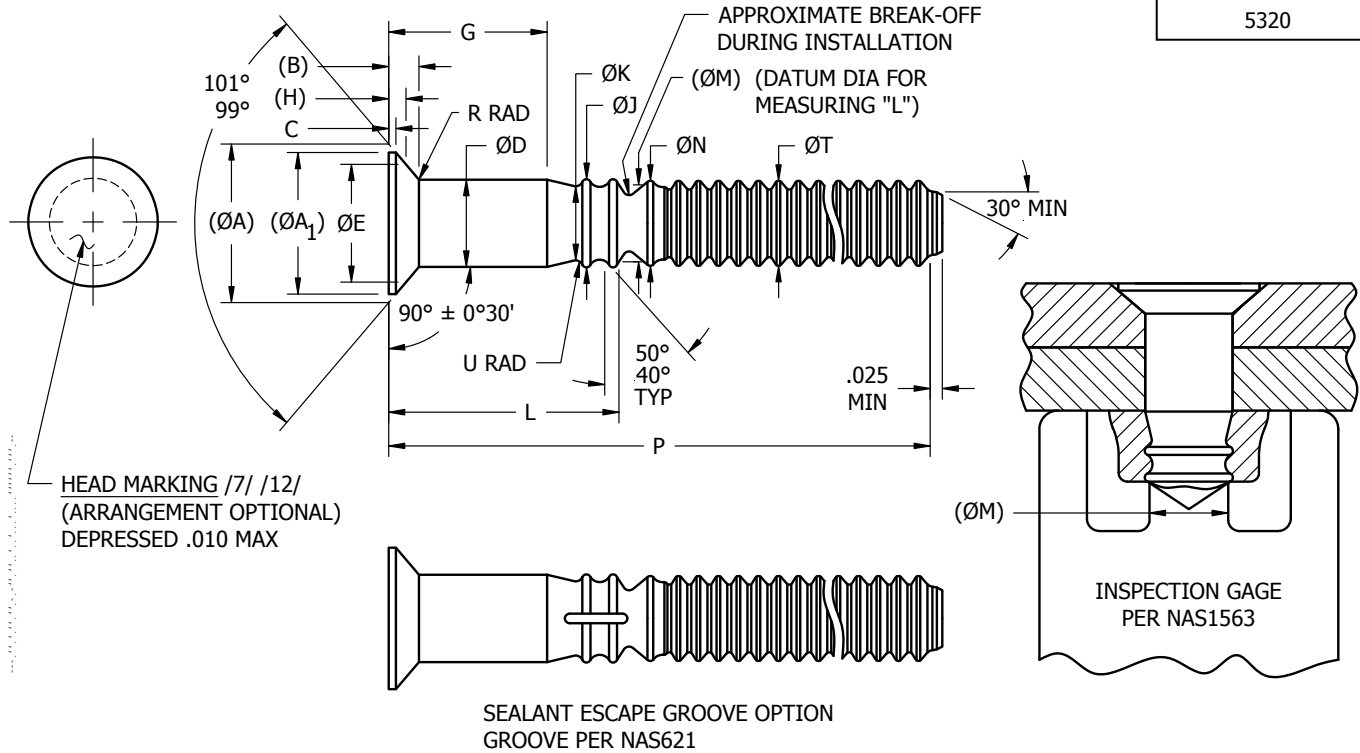


TABLE I – DIMENSIONS

BASIC PART NO.	STANDARD		OVERSIZE		(ØA) MAX /4/	(ØA ₁) MIN /4/	(B) MAX /4/ /5/	C MAX	GAGE			ØJ	ØK	(ØM) GAGE	ØN	R RAD	ØT MAX	U RAD MAX	V HEAD MARKING /7/
	NOM SIZE	ØD SHANK	NOM SIZE	ØD SHANK					+ .0002 - .0000 /6/	(H) PROT /6/ NOM ±TOL									
NAS2506	.190	.1895 .1890	.203	.2026 .2021	.305	.263	.049	.013	.2439	.0230	.0020	.185 .177	.151 .143	.164	.185 .169	.030 .020	.183	.020	NAS2506V
NAS2508	.250	.2495 .2490	.266	.2651 .2646	.399	.346	.064	.017	.3313	.0255	.0023	.246 .235	.201 .190	.224	.246 .221	.030 .020	.243	.020	NAS2508V
NAS2510	.312	.3120 .3115	.328	.3276 .3270	.479	.417	.070	.020	.4045	.0280	.0025	.298 .290	.247 .236	.268	.298 .276	.040 .030	.299	.025	NAS2510V
NAS2512	.375	.3745 .3740	.391	.3901 .3896	.566	.496	.081	.023	.4852	.0305	.0028	.369 .357	.300 .290	.339	.369 .336	.040 .020	.359	.025	NAS2512V

MATERIAL:

TITANIUM ALLOY – 6Al-4V (UNS R56400) PER PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-81200 or AMS2801:
95 KSI Fsu.

④ COMPLETELY REVISED

THIRD ANGLE PROJECTION	PROCUREMENT SPECIFICATION NAS621	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	TITLE BOLT, LOCK, SHEAR, 100° HEAD, STANDARD AND OVERSIZE, PULL-TYPE, TITANIUM ALLOY	④	REVISION 4

NAS2506 THRU
NAS2512
SHEET 1 OF 3

FINISH:

NO PROTECTIVE FINISH REQUIRED.

LUBRICATION:

CHLORINE FREE CETYL ALCOHOL.

CODE:

DASH NUMBER DESIGNATES MAXIMUM GRIP IN .0625 INCREMENTS.
ADD "V" AFTER BASIC PART NUMBER FOR 6Al-4V TITANIUM ALLOY.
ADD "H" AFTER BASIC NUMBER WHEN SEALANT ESCAPE GROOVE IS REQUIRED.
ADD "A" SUFFIX IF OVERSIZE IS REQUIRED

EXAMPLES OF PART NUMBER:

NAS2506V08 = Ø.190 6Al-4V TITANIUM ALLOY PIN, 100° FLUSH HEAD (SHEAR), PULL TYPE, .500 GRIP.
NAS2506VH08 = Ø.190 6Al-4V TITANIUM ALLOY PIN 100° FLUSH HEAD (SHEAR), SEALANT ESCAPE GROOVE, PULL TYPE, .500 GRIP.
NAS2506V08A = Ø.203 6Al-4V TITANIUM ALLOY PIN, 100° FLUSH HEAD (SHEAR), PULL TYPE, .500 GRIP, OVERSIZE SHANK DIAMETER.
NAS2506VH08A = Ø.203 6Al-4V TITANIUM ALLOY PIN, 100° FLUSH HEAD (SHEAR), SEALANT ESCAPE GROOVE, PULL TYPE, .500 GRIP, OVERSIZE SHANK DIAMETER.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY 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/ 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.
- /5/ OVERSIZE HEAD HEIGHT MAXIMUM IS .006 LESS THAN SHOWN IN COLUMN "B".
- /6/ GAGE PROTRUSION "(H)": SEE NAS621 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
- /7/ HEAD MARKING: "NAS" MAY BE INCLUDED IN HEAD MARKING AT OPTION OF FASTENER MANUFACTURER.
- (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.

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 09-01

④ COMPLETELY REVISED

REVISION
4
NAS2506 THRU NAS2512
SHEET 2



Documents

Document Sharing Hub