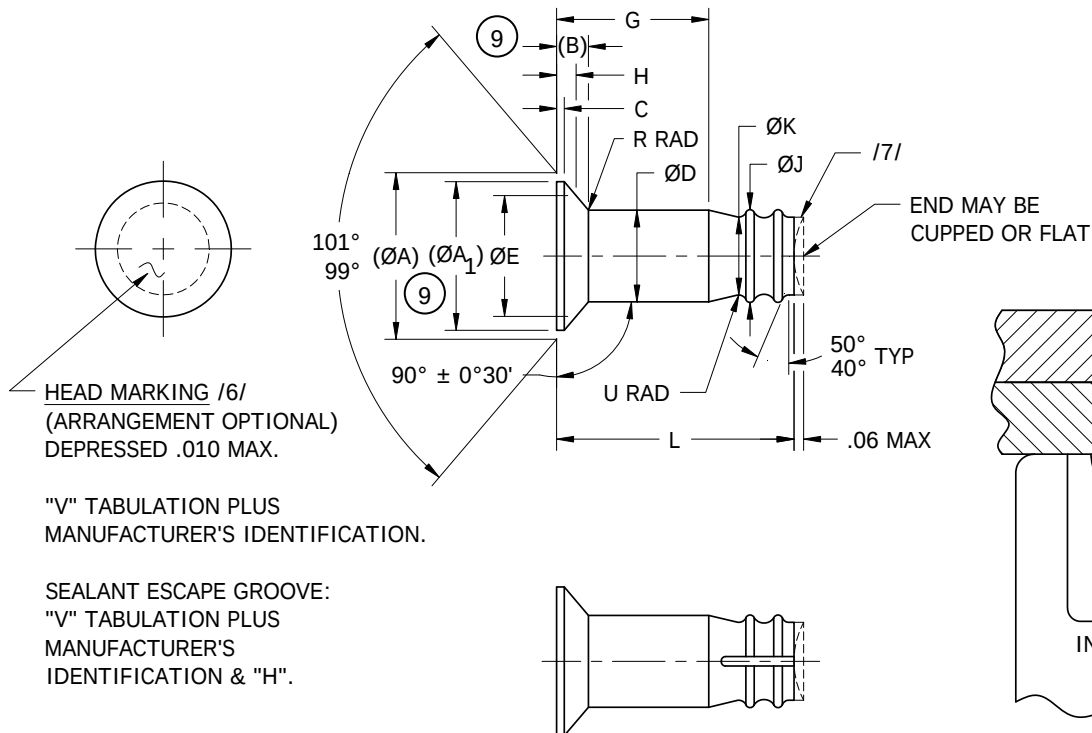


FED. SUPPLY CLASS

5320



SEALANT ESCAPE GROOVE OPTION
GROOVE PER NAS621

9

TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK	(ØA) MAX /4/	(ØA ₁) MIN /4/	(B) MAX /4/	C MAX	GAGE			ØJ	ØK	R RAD	U RAD MAX	V HEAD MARKING /6/
							ØE +.0002 -.0000 /5/	H PROTRUSION /5/						
								NOM	± TOL					
NAS2705	.164	.1635 .1630	.256	.220	.040	.011	.2026	.0203	.0017	.160 .154	.135 .129	.025 .015	.020	2705V
NAS2706	.190	.1895 .1890	.305	.263	.049	.013	.2439	.0230	.0020	.185 .177	.151 .143	.030 .020	.020	2706V
NAS2708	.250	.2495 .2490	.399	.346	.063	.017	.3313	.0255	.0023	.246 .235	.201 .190	.030 .020	.020	2708V
NAS2710	.312	.3120 .3115	.479	.417	.070	.020	.4045	.0280	.0025	.300 .290	.255 .246	.040 .030	.025	2710V
NAS2712	.375	.3745 .3740	.566	.496	.081	.023	.4852	.0305	.0028	.369 .354	.315 .303	.040 .030	.025	NAS2712V

MATERIAL:

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

HEAT TREATMENT:

MINIMUM SHEAR STRENGTH 95 KSI.

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.

REVISION DATE: DECEMBER 18, 2015

ISSUE DATE: NOVEMBER 1957

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 9
PROCUREMENT SPECIFICATION NAS621	TITLE BOLT, LOCK, SHEAR, 100 DEGREES HEAD, STUMP-TYPE, TITANIUM ALLOY	CLASSIFICATION PART STANDARD
		NAS2705 THRU NAS2712
		SHEET 1 OF 3

LUBRICATION:

CHLORINE FREE CETYL ALCOHOL, PER MIL-L-87132 AS87132.

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.

EXAMPLES OF PART NUMBERS:

NAS2706V08 = Ø.190, 6AL-4V TITANIUM ALLOY PIN, 100 DEGREES FLUSH HEAD,
STUMP TYPE, .500 GRIP.
NAS2706VH08 = Ø.190, 6AL-4V TITANIUM ALLOY PIN, 100 DEGREES FLUSH HEAD,
SEALANT ESCAPE GROOVE, STUMP TYPE, .500 GRIP.

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.
- ⑨ 1/4/ 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.
- 1/5/ GAGE PROTRUSION (H): SEE NAS621 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
- 1/6/ HEAD MARKING: "NAS" MAY BE INCLUDED IN HEAD MARKING AT OPTION OF FASTENER MANUFACTURER.
- 1/7/ CHAMFER OR RADIUS PERMISSIBLE .06 MAX.
- 1/8/ MINIMUM GRIP FOR "01" VARIES WITH MATERIAL TO BE FASTENED TOGETHER.
- (9) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (10) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- ⑨ (11) 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.
- (12) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

9

NAS2705
THRU NAS2712
SHEET 2



Documents

Document Sharing Hub