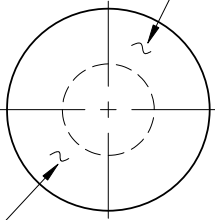
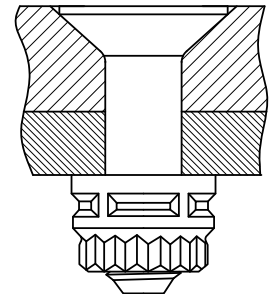
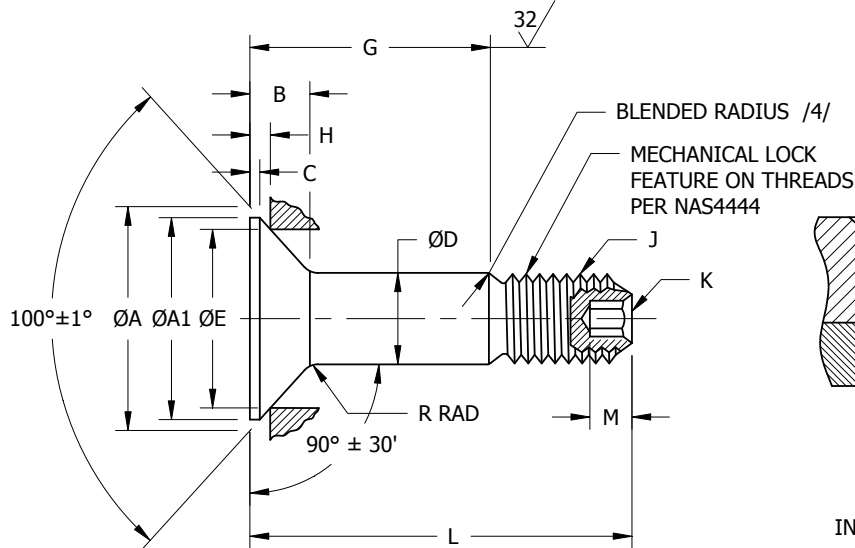


FED. SUPPLY CLASS
5315

HEAD MARKING PER
NAS1347, TYPE III
EXCEPT "NAS" PREFIX
NOT REQUIRED. ADD
"R" FOR OVERSIZE.



MATERIAL CODE:
S = 8740 OR 4340
H = H-11
V = 6AL-4V



INSTALLED FASTENER
AFTER CRIMPING

TABLE I – DIMENSIONS

BASIC PART NUMBER	NOM. SIZE	ØD STANDARD SHANK DIA		ØD OVERSIZE ▲ SHANK DIA		ØA MAX DIA /1/	ØA1 MIN DIA /1/	B MAX /1/ /6/	C MAX	GAGE			J THREAD /3/	K SOCKET	M MIN	R RAD
		ALLOY STEEL	6AL-4V TI	ALLOY STEEL	6AL-4V TI					ØE /2/ +.0002 - .0000	H /2/ PROTRUSION					
											NOM	±TOL				
NAS4452(*)05	.164	.1635 .1625	.1635 .1630	NONE		.256	.220	.040	.011	.2026	.0203	.0017	.1640-32 UNJC-3A	.0645 .0635	.090	.025 .015
NAS4452(*)06	.190	.1895 .1885	.1895 .1890	.2026 .2016	.2026 .2021	.305	.263	.049	.013	.2439	.0230	.0020	.1900-32 UNJF-3A	.0806 .0791	.115	.030 .020
NAS4452(*)08	.250	.2495 .2485	.2495 .2490	.2651 .2641	.2651 .2646	.399	.346	.063	.017	.3313	.0255	.0023	.2500-28 UNJF-3A	.0967 .0947	.120	.030 .020
NAS4452(*)10	.312	.3120 .3110	.3120 .3115	.3276 .3266	.3276 .3271	.492	.456	.077	.020	.4045	.0335	.0025	.3125-24 UNJF-3A	.1295 .1270	.140	.040 .030
NAS4452(*)12	.375	.3745 .3735	.3745 .3740	.3901 .3891	.3901 .3896	.588	.517	.091	.023	.4852	.0395	.0028	.3750-24 UNJF-3A	.1617 .1582	.170	.040 .030

MATERIAL: S = 8740 ALLOY STEEL (UNS G87400) PER PROCUREMENT SPECIFICATION OR
4340 ALLOY STEEL (UNS G43400) PER PROCUREMENT SPECIFICATION
H = H-11 ALLOY STEEL (UNS T20811) PER PROCUREMENT SPECIFICATION
V = 6AL-4V TITANIUM ALLOY (UNS R56400) PER PROCUREMENT SPECIFICATION

HEAT TREATMENT:

S = 108 KSI MINIMUM SHEAR
H = 156 KSI MINIMUM SHEAR
V = 95 KSI MINIMUM SHEAR

FINISH: S = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
OR NICKEL-CADMIUM PLATING PER AMS2416
H = NICKEL-CADMIUM PLATING PER AMS2416
V = NONE

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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: JUNE 30, 2014

ISSUE DATE: JANUARY 1964

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION NAS4444	TITLE PIN, CRIMP, 100° FLUSH SHEAR HEAD	CLASSIFICATION PART STANDARD
		NAS4452 SHEET 1 OF 3

CODES: FIRST DASH NUMBER = NOMINAL PIN DIAMETER IN .03125 INCH INCREMENTS
SECOND DASH NUMBER = GRIP LENGTH IN .0625 INCH INCREMENTS

***MATERIAL CODE:** PRECEDING FIRST DASH NUMBER:
"S" - 8740 OR 4340 ALLOY STEEL
"H" - H-11 ALLOY STEEL
"V" - 6AL-4V TITANIUM ALLOY

FINISH CODE: BETWEEN FIRST AND SECOND DASH NUMBERS:
"N" - DIFFUSED NICKEL-CADMIUM PLATE
(FOR HIGH STRENGTH AND/OR TEMPERATURES OVER 450 °F)

LUBRICATION CODE: FOLLOWING SECOND DASH NUMBER:
"E" - DRY FILM LUBRICATION PER AS5272, TYPE I OR
MOLYBDENUM DISULFIDE CONFORMING TO AMS-M-7866
"P" - CHLORINE FREE CETYL ALCOHOL PER AS87132, TYPE I, GR A

▲ OVERSIZE CODE: FOLLOWING SECOND DASH NUMBER IN ALPHABETICAL SEQUENCE:
"R" - OVERSIZE /10/

EXAMPLE OF PART NUMBER:

NAS4452S06-08 = .190 DIAMETER 8740 OR 4340 ALLOY STEEL CRIMP PIN, 100° FLUSH SHEAR HEAD,
.500 GRIP, TYPE II CADMIUM PLATE.

NAS4452S06N08 = .190 DIAMETER 8740 OR 4340 ALLOY STEEL CRIMP PIN, 100° FLUSH SHEAR HEAD,
.500 GRIP, NICKEL-CADMIUM PLATE.

NAS4452H06-08E = .190 DIAMETER H-11 ALLOY STEEL CRIMP PIN, 100° FLUSH SHEAR HEAD,
.500 GRIP, NICKEL-CADMIUM PLATE, DRY FILM LUBRICATION.

NAS4452V06-08P = .190 DIAMETER 6AL-4V TITANIUM ALLOY CRIMP PIN, 100° FLUSH SHEAR HEAD,
.500 GRIP, CETYL ALCOHOL LUBE.

NAS4452S06-08R = .203 DIAMETER 8740 OR 4340 ALLOY STEEL CRIMP PIN, 100° FLUSH SHEAR HEAD,
.500 GRIP, TYPE II CADMIUM PLATE, OVERSIZE SHANK DIAMETER.

NOTES:

- /1/ DIMENSIONS ØA, ØA1, & B: INCLUDED FOR ENGINEERING REFERENCE ONLY, NOT FOR INSPECTION PURPOSES. VALUES ØA, ØA1, & B: CALCULATED LIMITS RESULTING FROM TOLERANCE ON C, ØD, ØE, H & HEAD ANGLE.
- /2/ GAGE PROTRUSION ON "H": SEE PROCUREMENT SPECIFICATION.
- /3/ THREAD FORM TO BE PER AS8879 MODIFIED BY MECHANICAL LOCK FEATURE. MAJOR THREAD DIAMETER MUST BE .0035 TO .0085 SMALLER THAN "ØD" FOR STANDARD SHANK DIAMETER.
- /4/ BLENDED RADIUS REQUIRED AT INTERSECTION OF SHANK DIAMETER AND THREAD ENTRY ANGLE.
- (5) CONCENTRICITY OF CONICAL SURFACE OF HEAD TO "ØD" SHALL BE WITHIN .005 FIM.
- /6/ DIMENSION "B" IS .007 LESS FOR OVERSIZE DIAMETER, CODE "R" PARTS.
- (7) DIMENSIONS, IN INCHES, TO BE MET AFTER PLATING: EXCEPT PARTS WITH NICKEL-CADMIUM MAY HAVE DIMENSIONS INCREASED BY .0005 EXCEPT FOR THREADS.
- (8) FOR CRIMP NUT SELECTIONS AND STRENGTH DATA, SEE NAS4445.

REVISION

4

NAS4452
SHEET 2



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FORM 12-01