

FED. SUPPLY CLASS

5315

HEAD MARKING PER
NAS1347, TYPE III
EXCEPT "NAS" PREFIX
NOT REQUIRED.

MATERIAL CODE:
"S" - FOR 4140,
4340 OR 8740

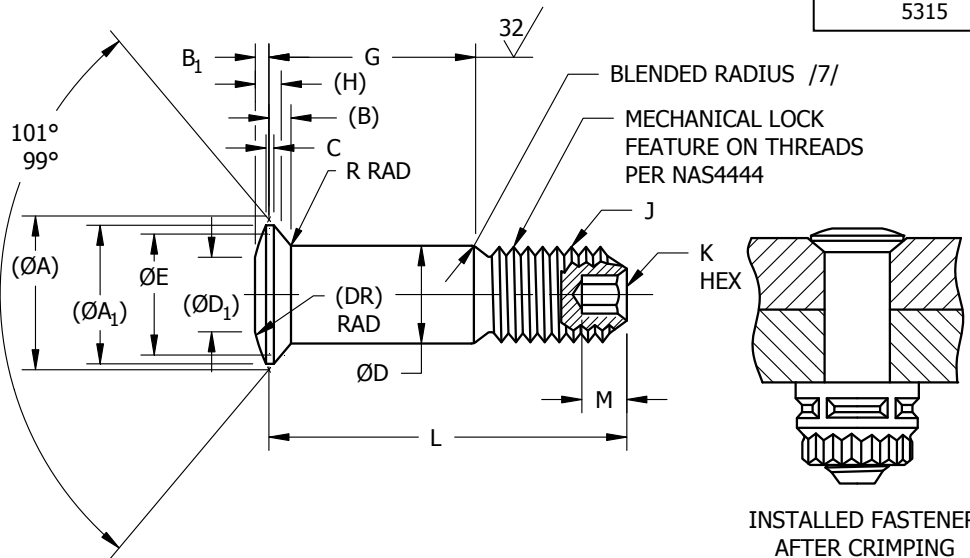


TABLE I - DIMENSIONS

BASIC PART NUMBER	NOM SIZE	ØD SHANK	(ØD ₁) /4/	(DR) RAD /4/	(ØA) /4/	(ØA ₁) MIN /4/	(B) /4/	B ₁	C MAX	GAGE			J THREAD /6/	K HEX SOCKET	M MIN	R RAD
										ØE + .0002 - .0000 /5/	(H) PROTRUSION /5/					
											NOM	±TOL				
NAS4466()05	.1640	.1635 .1625	.125	.125	.252	.229	.036	.0155 .0185	.014	.2026	.0365	.0025	.1640-32 UNJC-3A	.0645 .0635	.030	.025 .015
NAS4466()06	.1900	.1895 .1885	.140	.203	.301	.269	.045	.0145 .0175	.017	.2439	.0378	.0028	.1900-32 UNJF-3A	.0806 .0791	.045	.030 .020
NAS4466()08	.2500	.2495 .2485	.188	.312	.401	.361	.061	.0175 .0205	.022	.3313	.0450	.0030	.2500-28 UNJF-3A	.0967 .0947	.065	.030 .020
NAS4466()10	.3125	.3120 .3110	.312	.188	.484	.440	.073	.0195 .0230	.026	.4045	.0550	.0035	.3125-24 UNJF-3A	.1295 .1270	.085	.040 .030
NAS4466()12	.3750	.3745 .3735	.375	.156	.579	.537	.086	.0360 .0400	.030	.4852	.0775	.0040	.3750-24 UNJF-3A	.1617 .1582	.105	.040 .030

MATERIAL:

ALLOY STEEL: 4140 (UNS G41400) PER AMS6382, 4340 (UNS G43406) PER AMS6415 OR AMS6484, OR 8740 (UNS G87400) PER AMS6322, AMS6325 OR AMS6327.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES WITH CONTROLS PER AMS2759:
108 KSI MINIMUM SHEAR.

FINISH:

CADMIUM PLATE PER AMS-QQ-P-416, TYPE II CLASS 2.
NICKEL-CADMIUM PLATING PER AMS2416.

(2) COMPLETELY REVISED

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		2	
		TITLE		CLASSIFICATION PART STANDARD	
PROCUREMENT SPECIFICATION		PIN, CRIMP, 100° CROWN SHEAR/TENSION HEAD		NAS4466	
NAS4444				SHEET 1 OF 3	

LUBRICATION:

NONE; OR
CHLORINE FREE CETYL ALCOHOL PER MIL-L-87132 AS87132, TYPE I, GRADE A.

CODE:

FIRST DASH NUMBER DESIGNATES PIN DIAMETER IN .0312 INCREMENTS.
SECOND DASH NUMBER DESIGNATES MAXIMUM GRIP IN .0625 INCREMENTS.
MATERIAL CODE PRECEDING FIRST DASH NUMBER:
"S" – 4140, 4340 OR 8740 ALLOY STEEL
FINISH CODE BETWEEN FIRST AND SECOND DASH NUMBER:
"- " – CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
"N" – DIFFUSED NICKEL-CADMIUM PLATE PER AMS2416
LUBRICATION CODE FOLLOWING SECOND DASH NUMBER:
"P" – CHLORINE FREE CETYL ALCOHOL

EXAMPLES OF PART NUMBER:

NAS4466S06-08P = Ø.1900, 4140, 4340 OR 8740 ALLOY STEEL CRIMP PIN, 100° CROWN
SHEAR/TENSION HEAD, .500 GRIP, TYPE II CADMIUM PLATE, CHLORINE FREE
CETYL ALCOHOL LUBE.
NAS4466S06N08 = Ø.1900, 4140, 4340 OR 8740 ALLOY STEEL CRIMP PIN, 100° CROWN
SHEAR/TENSION HEAD, .500 GRIP, NICKEL-CADMIUM PLATE.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED. PARTS WITH NICKEL-CADMIUM MAY HAVE DIMENSIONS INCREASED BY .0005 EXCEPT FOR THREADS.
- (2) FOR CRIMP NUT SELECTIONS AND STRENGTH DATA, SEE NAS4445.
- (3) UNLESS OTHERWISE SPECIFIED, SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICROINCHES Ra PER ASME B46.1 AND SURFACE TEXTURE SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36M.
- /4/ DIMENSIONS "(ØA)", "(ØA₁)", "(B)", "(ØD₁)" & "(DR) RAD": INCLUDED FOR ENGINEERING REFERENCE ONLY, NOT FOR INSPECTION PURPOSES, VALUES "(ØA)", "(ØA₁)", "(B)", "(ØD₁)" & "(DR) RAD": CALCULATED LIMITS RESULTING FROM TOLERANCE ON "B₁", "C", "ØD", "ØE", "H" & HEAD ANGLE.
- /5/ GAGE PROTRUSION ON "(H)": SEE PROCUREMENT SPECIFICATION FOR RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
- /6/ THREAD FORM PER AS8879 MODIFIED BY MECHANICAL LOCK FEATURE. MAJOR THREAD DIAMETER MUST BE .0035 TO .0085 SMALLER THAN "ØD".
- /7/ BLENDED RADIUS REQUIRED AT INTERSECTION OF "ØD" AND ENTRY ANGLE.
- (8) CONCENTRICITY OF CONICAL SURFACE OF HEAD TO "ØD" SHALL BE WITHIN .005 FIM.
- (9) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

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

② COMPLETELY REVISED

REVISION
2
NAS4466
SHEET 2



NAS4466

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