



AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1250 EYE STREET, N.W.
WASHINGTON, D.C. 20005

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE
SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS
FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

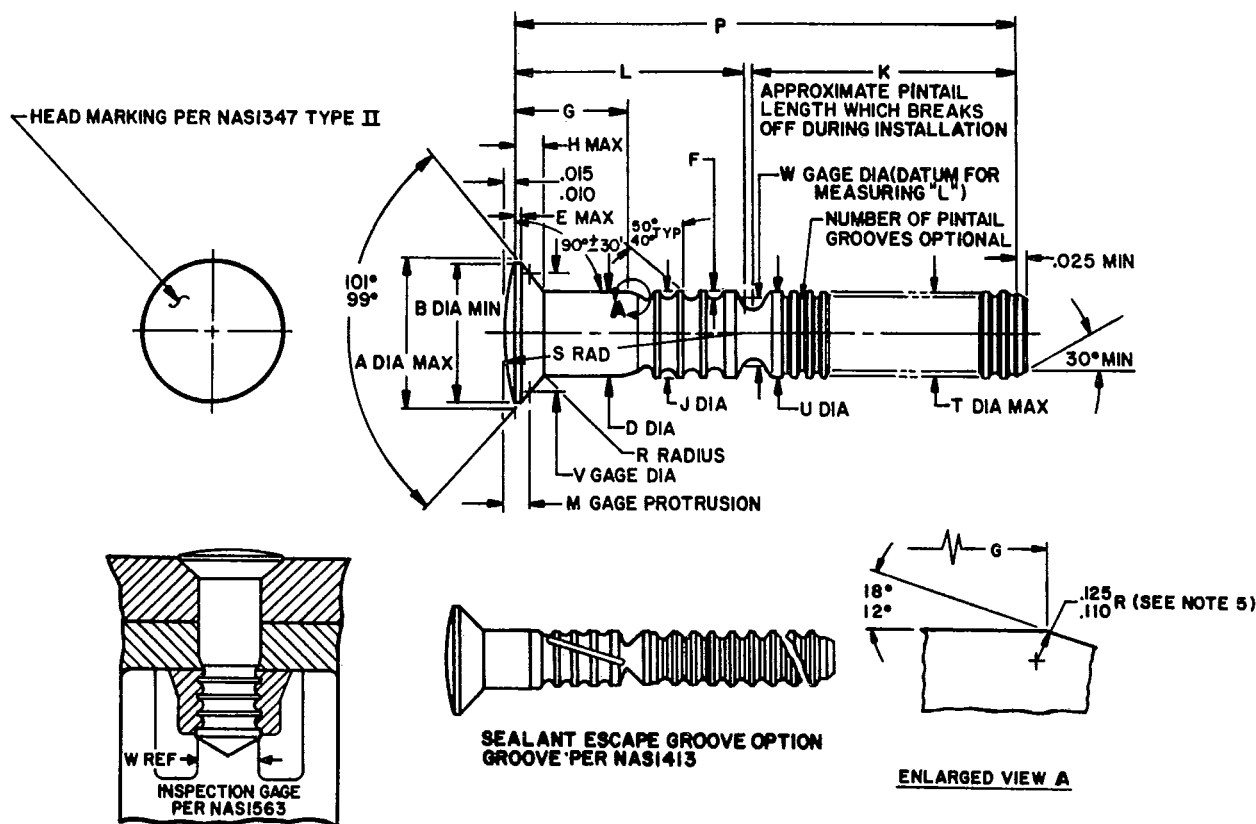


TABLE I

APPROVED CALLOUT	NOM DIA	A/ DIA MAX	B/ DIA MIN	D DIA	E MAX	F	H/ MAX	J DIA	K REF	b/ M GAGE PROT	R RAD	S RAD REF	T DIA MAX	U DIA	V GAGE DIA	W GAGE DIA	z/ Z
NAS6910-08-()	.2500	.507	.455	.2495 .2490	.017	.018 .014	.109	.242 .235	"P" MINUS "L"	.0445 .0410	.030 .020	2.15	.243	.242 .221	.4320 .4318	.224	4
NAS6910-10-()	.3125	.634	.574	.3120 .3115	.020	.023 .017	.135	.305 .294	"P" MINUS "L"	.0510 .0472	.040 .030	3.82	.299	.305 .276	.5451 .5449	.268	5
NAS6910-12-()	.3750	.762	.693	.3745 .3740	.023	.027 .021	.162	.368 .361	"P" MINUS "L"	.0565 .0525	.040 .030	5.55	.359	.368 .336	.6582 .6580	.339	5

- a/ DIMENSIONS A, B, AND H: INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY, NOT FOR INSPECTION PURPOSES.
VALUES A, B AND H: CALCULATED LIMITS RESULTING FROM TOLERANCES ON E, D, V, M AND HEAD ANGLE.
b/ GAGE PROTRUSION (M): SEE NAS1413 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
c/ NUMBER OF LOCKING GROOVES.

LIST OF CURRENT SHEETS			
NO	REV	NO	REV
1	1		
2	1		

① INACTIVE FOR NEW DESIGN AFTER JUNE 1, 1991. NO SUPERSEDING STANDARD.

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE		THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION NAS1413	TITLE PIN, SWAGE LOCKING, PH13-8Mo CRES, 100° CROWN HEAD, TENSION, PULL-TYPE	CLASSIFICATION STANDARD PART	
		NAS 6910 Documents SHEET 1 OF 2	



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- ① **MATERIAL:** PH13-8Mo PER AMS5629 (UNS S13800)
HEAT TREATMENT: SOLUTION AND PRECIPITATION "HEAT TREATED TO CONDITION H1000," MINIMUM SHEAR STRENGTH 125 KSI
FINISH: PASSIVATE IN ACCORDANCE WITH QQ-P-35
LUBRICATION: DRY FILM LUBRICANT PER MIL-L-46010 AND CETYL ALCOHOL PER MIL-L-87132
CODE: FIRST DASH NUMBER DESIGNATES NOMINAL DIAMETER IN .03125 INCREMENTS. SECOND DASH NUMBER DESIGNATES NOMINAL GRIP LENGTH IN .062 INCREMENTS. ADD "H" AFTER BASIC NUMBER WHEN SEALANT ESCAPE GROOVE IS REQUIRED

EXAMPLES OF PART NUMBERS:

NAS6910-10-08 - .3125 DIA, PH13-8Mo CRES, 100° CROWN HEAD, PULL-TYPE, .500 GRIP.
 NAS6910H10-08 - .3125 DIA, PH13-8Mo CRES, 100° CROWN HEAD, SEALANT ESCAPE GROOVE, PULL-TYPE, .500 GRIP.

NOTES:

1. DIMENSIONS IN INCHES.
2. FOR RECOMMENDED HOLE SIZE, SEE NAS618.
3. FOR COLLAR SELECTION, MINIMUM TENSILE STRENGTH, AND INSPECTION GAGE, SEE NAS1080.
4. DIMENSIONS ARE PRIOR TO APPLICATION OF LUBRICANTS.
5. RADIUS TO BE TANGENT TO SHANK AND 12°/18° ANGLE.
6. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
7. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

TABLE II. DASH NUMBERS.

GRIP DASH NUMBER	GRIP NOM	GRIP RANGE		G +.010 -.015	.2500 DIA		.3125 DIA		.3750 DIA	
		MIN	MAX		L ±.010	P +.20 -.00	L ±.010	P +.20 -.00	L ±.010	P +.20 -.00
03	.188	.157	.219	.188	.499	1.45	.627	1.64	.734	1.80
04	.250	.220	.281	.250	.562	1.51	.690	1.70	.797	1.86
05	.312	.282	.344	.312	.624	1.57	.752	1.77	.859	1.92
06	.375	.345	.406	.375	.687	1.70	.815	1.83	.922	1.98
07	.437	.407	.469	.438	.749	1.83	.877	1.89	.984	2.05
08	.500	.470	.531	.500	.812	2.01	.940	1.95	1.047	2.11
09	.562	.532	.594	.562	.874	2.14	1.002	2.09	1.109	2.17
10	.625	.595	.656	.625	.937	2.32	1.065	2.22	1.172	2.23
11	.687	.657	.719	.688	.999	2.45	1.127	2.39	1.234	2.30
12	.750	.720	.781	.750	1.062	2.63	1.190	2.52	1.297	2.43
13	.812	.782	.844	.812	1.125	2.76	1.252	2.69	1.359	2.60
14	.875	.845	.906	.875			1.315	2.82	1.422	2.73
15	.937	.907	.969	.938			1.377	2.99	1.484	2.85
16	1.000	.970	1.031	1.000			1.440	3.12	1.547	3.03
17	1.062	1.032	1.094	1.062					1.609	3.15
18	1.125	1.095	1.156	1.125					1.672	3.28
19	1.187	1.157	1.219	1.188					1.734	3.45
20	1.250	1.220	1.281	1.250					1.797	3.58
21	1.312	1.282	1.344	1.312					1.859	3.75
22	1.375	1.345	1.406	1.375					1.922	3.88
23	1.437	1.407	1.469	1.438					1.984	4.01

APPROVAL DATE August 1995 REVISION ① 25 June 1991