



Aerospace
Industries
Association

AIA/NAS NAS*6911 91 0318743 0007753 7

NATIONAL AEROSPACE STANDARD

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FED. SUP CLASS
5320

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

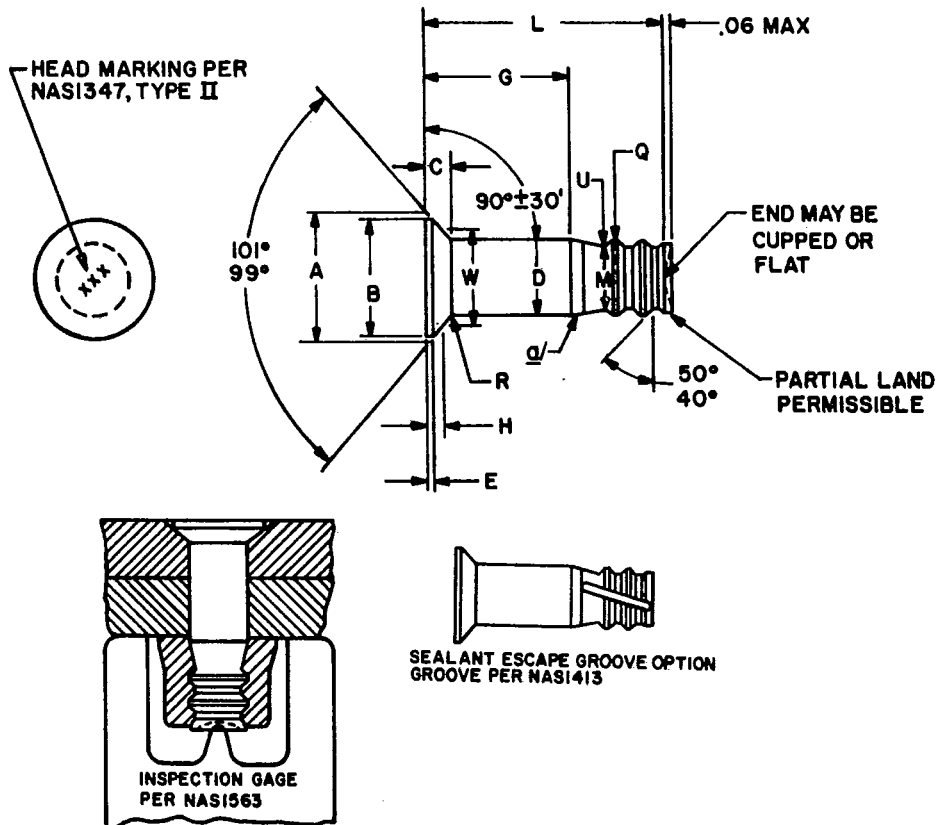


TABLE I

APPROVED CALLOUT	NOM DIA	A DIA MAX	B DIA MIN	C MAX	D DIA	E MAX	H GAGE PROTRUSION NOM	M DIA	Q DIA	R RAD	U RAD MAX	W GAGE DIA +.0002 -.0000
NAS6911-05-()	.1640	.256	.220	.042	.1635 .1630	.011	.0220 .0186	.135 .129	.160 .154	.025 .015	.020	.2026
NAS6911-06-()	.1900	.305	.262	.049	.1895 .1890	.013	.0250 .0210	.151 .143	.185 .177	.030 .020	.020	.2439
NAS6911-08-()	.2500	.399	.344	.063	.2495 .2490	.017	.0278 .0232	.201 .191	.246 .235	.030 .020	.020	.3313
NAS6911-10-()	.3125	.479	.416	.071	.3120 .3115	.020	.0305 .0255	.256 .245	.298 .290	.040 .030	.025	.4045
NAS6911-12-()	.3750	.566	.494	.081	.3745 .3740	.023	.0333 .0277	.316 .304	.369 .357	.040 .030	.025	.4852

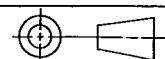
- a/ SLIGHT HOOK PERMITTED WHERE TAPER OF LOCKING GROOVE MEETS TAPER OF ORIGINAL BLANK.
b/ DIMENSIONS A, B, AND C INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY, NOT FOR INSPECTION PURPOSES. VALUES A, B AND C CALCULATED LIMITS RESULTING FROM TOLERANCES ON D, W, H, E AND HEAD ANGLE.
c/ GAGE PROTRUSION (H), SEE NAS1413 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.

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° HEAD, SHEAR, STUMP-TYPE**

CLASSIFICATION
STANDARD PART

NAS 6911

Documents
SHEET 1 OF 2



AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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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.

- ① **MATERIAL:** PH13-8% 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
① **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:

NAS6911-06-08 - .190 DIA, PH13-8% CRES, 100° FLUSH HEAD, STUMP-TYPE, .500 GRIP.

NAS6911H06-08 - .190 DIA, PH13-8% CRES, 100° FLUSH HEAD, SEALANT ESCAPE GROOVE, STUMP-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. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
6. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

TABLE II. DASH NUMBERS.

GRIP DASH NUMBER	MAX GRIP	GRIP RANGE		G +.010	L ±.005				
		MIN	MAX		.164 DIA	.190 DIA	.250 DIA	.312 DIA	.375 DIA
01	.062	(a) —	.062	.062	.236	—	—	—	—
02	.125	.063	.125	.125	.298	.323	.376	—	—
03	.188	.126	.188	.188	.361	.386	.439	.458	.501
04	.250	.189	.250	.250	.423	.448	.501	.520	.563
05	.312	.251	.312	.312	.486	.511	.564	.583	.626
06	.375	.313	.375	.375	.548	.574	.626	.645	.688
07	.438	.376	.438	.438	.611	.637	.689	.708	.751
08	.500	.439	.500	.500	.673	.699	.751	.770	.813
09	.562	.501	.562	.562	.736	.762	.814	.833	.876
10	.625	.563	.625	.625	.798	.824	.876	.895	.938
11	.688	.626	.688	.688	.861	.887	.939	.958	1.001
12	.750	.689	.750	.750	.923	.949	1.001	1.020	1.063
13	.812	.751	.812	.812	.986	1.012	1.064	1.083	1.126
14	.875	.813	.875	.875	1.048	1.074	1.126	1.145	1.188
15	.938	.876	.938	.938	1.111	1.137	1.189	1.208	1.251
16	1.000	.939	1.000	1.000	1.173	1.199	1.251	1.270	1.313
17	1.062	1.001	1.062	1.062	—	1.261	1.314	1.333	1.376
18	1.125	1.063	1.125	1.125	—	1.323	1.376	1.395	1.438
19	1.188	1.126	1.188	1.188	—	1.386	1.439	1.458	1.501
20	1.250	1.189	1.250	1.250	—	1.448	1.501	1.520	1.563
21	1.312	1.251	1.312	1.312	—	1.511	1.564	1.583	1.626
22	1.375	1.313	1.375	1.375	—	1.574	1.626	1.645	1.688
23	1.438	1.376	1.438	1.438	—	1.637	1.689	1.708	1.751
24	1.500	1.439	1.500	1.500	—	1.699	1.751	1.770	1.813
25	1.562	1.501	1.562	1.562	—	1.762	1.814	1.833	1.876
26	1.625	1.563	1.625	1.625	—	1.824	1.876	1.895	1.938
27	1.688	1.626	1.688	1.688	—	1.887	1.939	1.958	2.001
28	1.750	1.689	1.750	1.750	—	1.949	2.001	2.020	2.063
29	1.812	1.751	1.812	1.812	—	2.012	2.064	2.083	2.126
30	1.875	1.813	1.875	1.875	—	2.074	2.126	2.145	2.188
31	1.938	1.876	1.938	1.938	—	2.137	2.189	2.208	2.251
32	2.000	1.939	2.000	2.000	—	2.199	2.251	2.270	2.313

(a) MINIMUM GRIP FOR -01 VARIES WITH MATERIAL TO BE FASTENED TOGETHER.

APPROVAL DATE August 1996 REVISION ① 25 June 1991