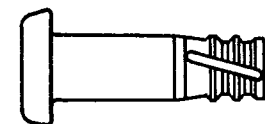
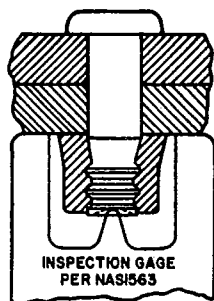
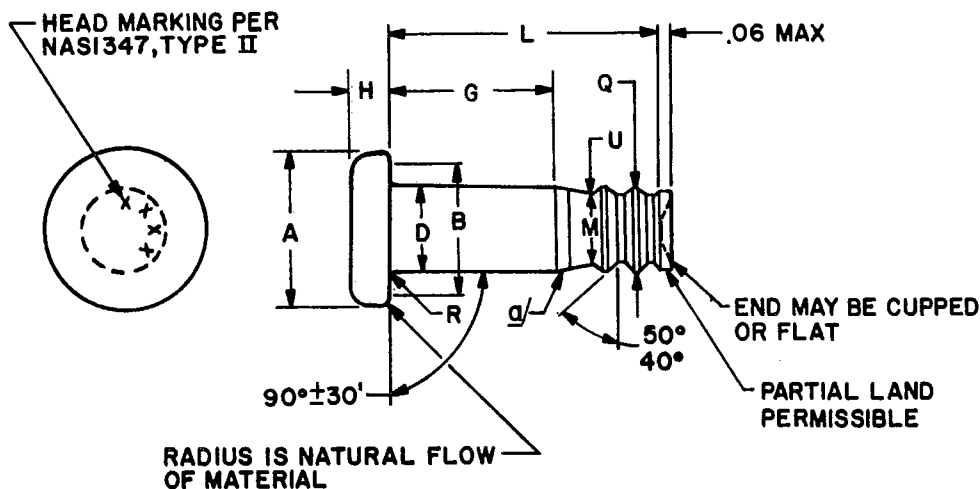




AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1250 EYE STREET, N.W.
WASHINGTON, D.C. 20005

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.



SEALANT ESCAPE GROOVE OPTION
GROOVE PER NAS1413

TABLE I

APPROVED CALLOUT	NOM DIA	A DIA	B DIA MIN	D DIA	H DIA	M DIA	Q DIA	R RAD	U RAD MAX
NAS6912-05-()	.1640	.249 .235	.215	.1635 .1630	.048 .036	.135 .129	.160 .154	.025 .015	.020
NAS6912-06-()	.1900	.302 .288	.260	.1895 .1890	.056 .044	.151 .143	.185 .177	.025 .015	.020
NAS6912-08-()	.2500	.377 .363	.309	.2495 .2490	.070 .058	.201 .191	.246 .235	.025 .015	.020
NAS6912-10-()	.3125	.471 .455	.374	.3120 .3115	.079 .067	.256 .245	.298 .290	.030 .020	.025
NAS6912-12-()	.3750	.565 .549	.436	.3745 .3740	.089 .077	.316 .304	.369 .357	.030 .020	.025

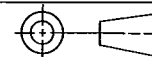
a/ SLIGHT HOOK PERMITTED WHERE TAPER OF LOCKING GROOVE MEETS TAPER OF
ORIGINAL BLANK.

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,
PROTRUDING HEAD, SHEAR, STUMP-TYPE

CLASSIFICATION
STANDARD PART

NAS 6912

Documents

SHEET 1 OF 2



- 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:

NAS6912-06-08 - .190 DIA, PH13-8% CRES, PROTRUDING HEAD, STUMP-TYPE, .500 GRIP.

NAS6912H06-08 - .190 DIA, PH13-8% CRES, PROTRUDING 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	.261	—	—	—
02	.125	.063	.125	.125	.298	.323	.376	.395	.438
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.