

FED. SUPPLY CLASS

5320

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

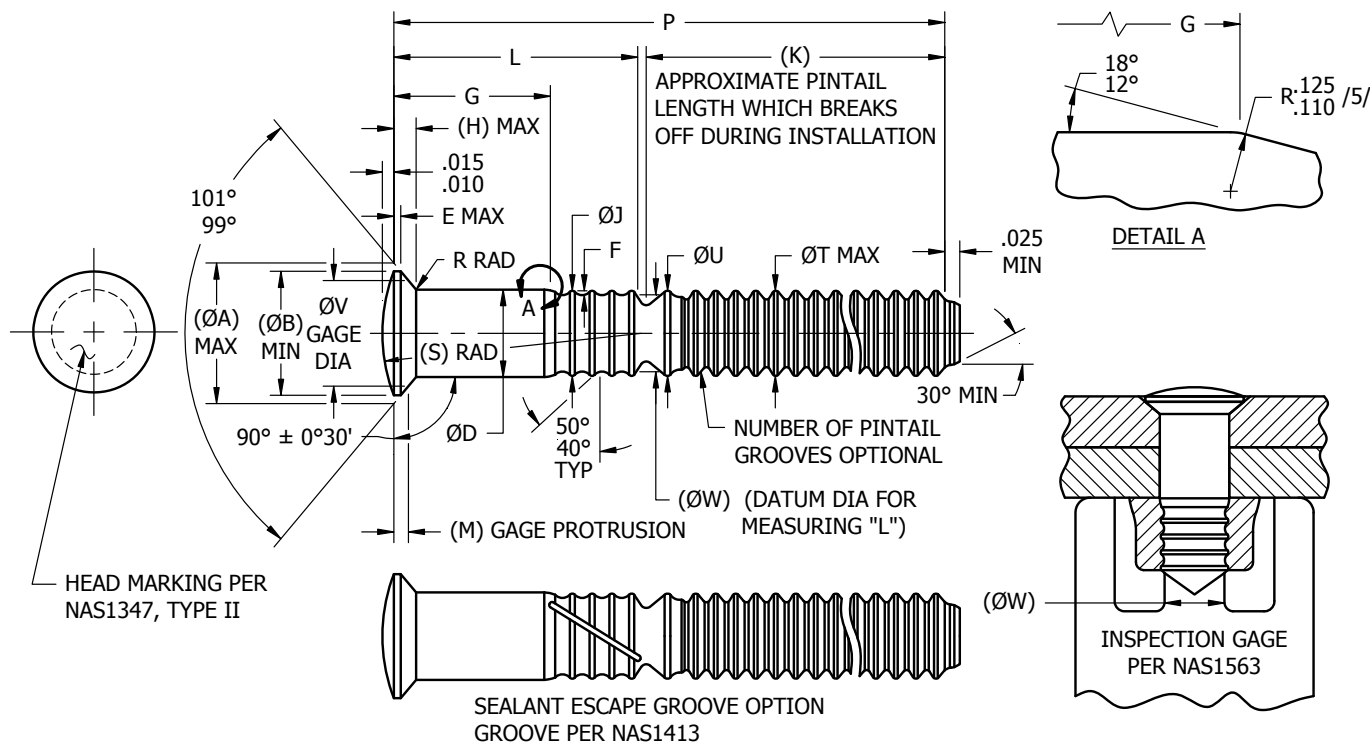


TABLE I – DIMENSIONS

APPROVED CALLOUT	NOM DIA	(ØA) MAX /8/	(ØB) MIN /8/	ØD	E MAX	F	(H) MAX /8/	ØJ	(K)	(M) GAGE PROT /9/	R RAD	(S) RAD	ØT MAX	ØV GAGE	ØU	(ØW) GAGE	Z /10/
NAS6913-06-()	.1900	.305	.263	.1895 .1890	.013	.015 .010	.048	.185 .177	P - L	.0382 .0342	.030 .020	.82	.183	.2441 .2439	.185 .169	.164	4
NAS6913-08-()	.2500	.399	.346	.2495 .2490	.017	.018 .014	.063	.242 .235		.0427 .0387	.030 .020	1.40	.243	.3272 .3270	.242 .221	.224	4
NAS6913-10-()	.3125	.479	.417	.3120 .3115	.020	.023 .017	.070	.305 .294		.0438 .0398	.040 .030	2.07	.299	.4047 .4045	.305 .276	.268	5
NAS6913-12-()	.3750	.566	.496	.3745 .3740	.023	.027 .021	.080	.368 .361		.0464 .0424	.040 .030	2.89	.359	.4854 .4852	.368 .336	.339	5

MATERIAL:

PH13-3Mo (UNS S13800) PER AMS5629.

HEAT TREATMENT:

SOLUTION AND PRECIPITATION HEAT TREATED TO CONDITION H1000.
MINIMUM SHEAR STRENGTH 125 KSI.

② COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NAS1413	TITLE PIN, SWAGE LOCKING, PH13-8Mo CRES, 100° CROWN HEAD, SHEAR, PULL-TYPE	CLASSIFICATION PART STANDARD



NAS6913
SHEET 1 OF 3

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FINISH:

PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

LUBRICATION:

DRY FILM LUBRICANT PER MIL-PRF-46010 AS5272, TYPE I AND CETYL ALCOHOL PER MIL-L-87132 AS87132.

CODE:

FIRST DASH NUMBER DESIGNATES NOMINAL DIAMETER IN .03125 INCREMENTS.
SECOND DASH NUMBER DESIGNATES MAXIMUM GRIP LENGTH IN .062 INCREMENTS.
ADD "H" AFTER BASIC NUMBER WHEN SEALANT ESCAPE GROOVE IS REQUIRED.

EXAMPLES OF PART NUMBER:

NAS6913-08-08 = Ø.2500, PH13-8Mo CRES, 100° CROWN HEAD, PULL-TYPE, .500 GRIP.
NAS6913H08-08 = Ø.2500, PH13-8Mo CRES, 100° CROWN HEAD, SEALANT ESCAPE GROOVE, PULL-TYPE, .500 GRIP.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (2) FOR RECOMMENDED HOLE SIZE, SEE NAS618.
- (3) FOR COLLAR SELECTION, MINIMUM TENSILE STRENGTH, AND INSPECTION GAGE, SEE NAS1080.
- (4) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- /5/ RADIUS TO BE TANGENT TO SHANK AND 18°/12° ANGLE.
- (6) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (7) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- /8/ DIMENSIONS "(ØA)", "(ØB)", AND "(H)": INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY, NOT FOR INSPECTION PURPOSES. VALUES "(ØA)", "(ØB)", AND "(H)": CALCULATED LIMITS RESULTING FROM TOLERANCES ON "E", "ØD", "ØV", "(M)" AND HEAD ANGLE.
- /9/ GAGE PROTRUSION "(M)": SEE NAS1413 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
- /10/ NUMBER OF LOCKING GROOVES.
- (11) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION
2
NAS6913
SHEET 2

(2) COMPLETELY REVISED



NAS6913
SHEET 2

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