

FED. SUPPLY CLASS

5315

SWAGED CHAMFER

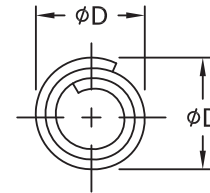
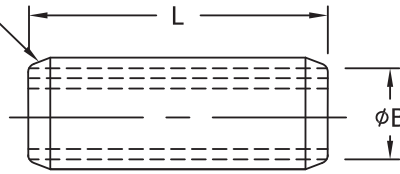


TABLE I – DASH NUMBERS AND DIMENSIONS

NOMINAL DIAMETER	ØD ACTUAL (FREE) STATE		ØB CHAMFER MAX	MINIMUM DOUBLE SHEAR STRENGTH (POUNDS)			RECOMMENDED HOLE SIZE	
	MAX	MIN		CRES 410 THRU 420 CARBON STEEL 1070 THRU 1095	ALLOY STEEL 6150	CRES 302	MAX	MIN
1/16	.070	.066	.059	450		350	.065	.061
5/64	.086	.082	.075	700		550	.081	.077
3/32	.103	.098	.091	1000		800	.097	.093
7/64	.118	.113	.106	1400		1125	.112	.108
1/8	.136	.130	.121	2100		1700	.129	.124
5/32	.168	.161	.152	3000		2400	.160	.155
3/16	.202	.194	.182	4400		3500	.192	.185
7/32	.235	.226	.214	5700		4600	.224	.217
1/4	.268	.258	.243	7700		6200	.256	.247
5/16	.334	.322	.304	11500		9200	.319	.308
3/8	.400	.386	.366	17600		14000	.383	.370
7/16	.466	.450	.427	22500		18000	.446	.431
1/2	.532	.514	.488	30000		24000	.510	.493
5/8	.658	.640	.613		46000		.635	.618
3/4	.784	.766	.738		66000		.760	.743

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS39086, REVISION B. PART NUMBERS REMAIN MS39086.

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		1	
PROCUREMENT SPECIFICATION	NASM10971	①	TITLE	CLASSIFICATION PART STANDARD	
				NASM39086	

PIN, SPRING, TUBULAR, COILED, HEAVY DUTY

NASM39086
SHEET 1 OF 6

MATERIAL:

STEEL, CARBON PER AIR4127, AISI 1070 (UNS G10700), AISI 1075 (UNS G10750), AISI 1078 (UNS G10780), AISI 1080 (UNS G10800), AISI 1084 (UNS G10840), AISI 1085 (UNS G10850), AISI 1086 (UNS G10860), AISI 1090 (UNS G10900) OR AISI 1095 (UNS G10950).
STEEL, ALLOY, PER AIR4127, AISI 6150 (UNS G61500).
STEEL, CORROSION RESISTING, PER AIR4127, 302 CRES (UNS S30200), 410 CRES (UNS S41000), 416 CRES (UNS S41600), 418 CRES (UNS S41800), OR 420 CRES (UNS S42000).

FINISH:

STEEL, CARBON, CADMIUM PLATED, PER AMS-QQ-P-416, TYPE II, CLASS 3.
STEEL, CARBON AND ALLOY, PHOSPHATE COATED IN ACCORDANCE WITH MIL-DTL-16232, TYPE Z, CLASS 2.
STEEL, CORROSION RESISTING, PASSIVATED PER AMS2700, METHOD 1, CLASS 4.

HARDNESS:

STEEL, CARBON, 46-53 HRC.
STEEL, ALLOY, 43-51 HRC.
STEEL, CORROSION RESISTING (410 THRU 420); 46-55 HRC.
STEEL, CORROSION RESISTING (302); WORK HARDENED.

TOLERANCES:

LENGTH L: ALL DIAMETERS THRU 3/8":
±.010" FOR LENGTHS THRU 2"
±.015" FOR LENGTHS OVER 2" THRU 3"
±.025" FOR LENGTHS OVER 3"
ALL DIAMETERS LARGER THAN 3/8":
±.025 FOR ALL LENGTHS.

CODE:

THE MS PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER.

EXAMPLE OF PART NUMBER: MS39086-1.

NOTES:

- (1) REMOVE ALL BURRS AND SHARP EDGES.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (4) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER EXISTING MATERIAL INVENTORY MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (5) FOR FUNCTIONAL LIMITATIONS ON USAGE OF SPRING PINS, SEE NASM33547.
- (6) ~~PATENT NUMBER 2737843, PATENTED 13 MARCH 1956. THE GOVERNMENT HAS A ROYALTY FREE LICENSE UNDER THIS PATENT FOR THE BENEFIT OF MANUFACTURERS OF THIS ITEM EITHER FOR THE GOVERNMENT OR FOR USE IN EQUIPMENT TO BE DELIVERED TO THE GOVERNMENT.~~
- /7/ NOT MANUFACTURED.
- /8/ INACTIVATED. DO NOT USE FOR NEW DESIGN.
- (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

1

NASM39086

SHEET 2

① COMPLETELY REVISED