

FED. SUPPLY CLASS

5315

SWAGED CHAMFER

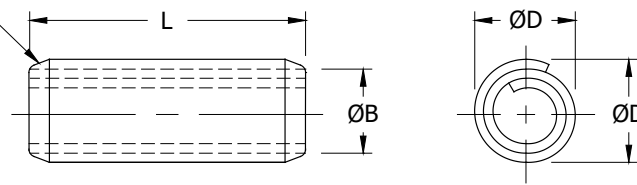


TABLE I – DIMENSIONS

NOMINAL DIA	ØD ACTUAL (FREE) STATE		ØB CHAMFER MAX	MINIMUM DOUBLE SHEAR STRENGTH			RECOMMENDED HOLE SIZE	
	LBF							
	MAX	MIN		CRES 410 THRU 420 CARBON STEEL 1070 THRU 1095	ALLOY STEEL 6150	CRES 302	MAX	MIN
.031	.035	.033	.029	75 /1/		60	.032	.031
.039	.044	.041	.037	120 /1/		100	.040	.039
.047	.052	.049	.045	170 /1/		140	.048	.046
.052	.057	.054	.050	230 /1/		190	.053	.051
.063	.072	.067	.059	300		250	.065	.061
.078	.088	.083	.075	475		400	.081	.077
.094	.105	.099	.091	700		550	.097	.093
.109	.120	.114	.106	950		750	.112	.108
.125	.138	.131	.121	1250		1000	.129	.124
.156	.171	.163	.152	1925		1550	.160	.155
.188	.205	.196	.182	2800		2250	.192	.185
.219	.238	.228	.214	3800		3000	.224	.217
.250	.271	.260	.243	5000		4000	.256	.247
.313	.337	.324	.304	7700		6200	.319	.308
.375	.403	.388	.366	11200		9000	.383	.370
.438	.469	.452	.427	15200		13000	.446	.431
.500	.535	.516	.488	20000		16000	.510	.493
.625	.661	.642	.613		31000		.635	.618
.750	.787	.768	.738		45000		.760	.743

MATERIAL:

CARBON STEEL - 1070 THRU 1095 PER AIR4127.
ALLOY STEEL - 6150 PER AIR4127.
CRES - 302 OR 410 THRU 420 PER AIR4127.

FINISH:

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

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51923, REVISION C. PART NUMBERS REMAIN MS51923.

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		2	
PROCUREMENT SPECIFICATION		TITLE		CLASSIFICATION	
				PART STANDARD	
NASM10971		PIN, SPRING, TUBULAR, COILED, STANDARD DUTY		NASM51923	
				SHEET 1 OF 4	

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY CONFORMANCE OF ITEMS PRODUCED UNDER NATIONAL AEROSPACE STANDARDS. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF ITEMS FOR ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABILITY THERETO OF PATENT OR TRADEMARKS RIGHTS.

HARDNESS:

CARBON STEEL: 46-53 HRC.
ALLOY STEEL: 43-51 HRC.
CRES (410 THRU 420): 46-55 HRC.
CRES (302): WORK HARDENED.

CODE:

THE MS PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER FROM TABLE II.

EXAMPLE OF PART NUMBER:

MS51923-37 = PIN, SPRING, TUBULAR, COILED, STANDARD DUTY, CARBON STEEL, Ø.063, .188 LONG, CADMIUM PLATED.

NOTES:

- /1/ CRES 410 THRU 420 ONLY.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (3) REMOVE ALL BURRS AND SHARP EDGES.
- (4) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (5) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (6) 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.
- (7) FOR FUNCTIONAL LIMITATIONS ON USAGE OF SPRING PINS, SEE NASM33547.
- (8) ~~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.~~
- /9/ NOT MANUFACTURED
- /10/ INACTIVATED. DO NOT USE FOR NEW DESIGN. FOR DESCRIPTION OF STATUS NOTES SEE NAS380.
- (11) DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994.
- (12) TOLERANCES:

LENGTH L	DIAMETERS	
	THRU .375	LARGER THAN .375
THRU 2.000	±.010	±.025
OVER 2.000 THRU 3.000	±.015	
OVER 3.000	±.025	

REVISION

2

② COMPLETELY REVISED

NASM51923
SHEET 2

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY CONFORMANCE OF ITEMS PRODUCED UNDER NATIONAL AEROSPACE STANDARDS. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF ITEMS FOR ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABILITY THERETO OF PATENT OR TRADEMARKS RIGHTS.