

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS S-J-1.101-GS/PL
		Former Designation: ESP-J-1.101-GS
TITLE: Split (Cotter) Pins – Extended Prong – English Series (Noun Code 6200)	CURRENT REV No.: 1506	DATE: June 2015
WRITTEN/EDITED BY: Materials Engineering	APPROVED BY: Materials Engineering	SUPERSEDES: ESP-J-1.101-GS - August 2006
PRINTED COPIES OF THIS DOCUMENT MUST BE VERIFIED FOR CURRENT REVISION		
<i>This specification may involve hazardous materials, equipment, and procedures. This specification does not purport to address all of the safety issues associated with its use. The user is responsible to consult appropriate safety and health practices and to determine the applicability of regulatory limits prior to use.</i>		
Change Notice: Changed to New MPAPS format; Combined GS, PP, NPP.		

1.0 GENERAL: This specification conforms in all essentials with ANSI B18.8.1. The inclusion of dimensional data is not intended to imply that all pins described are stock production sizes.

Metric series split (cotter) pins may be found on page MPAPS S-JM-1.101-GS/PL.

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3.0 POLICY FOR SELECTING PARTS FOR NEW DESIGN: Approved parts are so designated to reduce variety of parts and assure maximum availability, interchangeability and cost savings in volume buying.

For new design, parts shall be selected from "Approved" part list only.

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Nominal Sizes: 1/32, 1/16, 3/32, 1/8, 5/32, 3/16, and 1/4
 Lengths: See Chart Below (Based on sizes and length normally available.)
 Material: Steel (STL)
 Point: Extended Prong
 Finish: Plain (PLN)

Dimensions in inches:

Nominal Pin Length	Nominal Pin Size						
	1/32	1/16	3/32	1/8	5/32	3/16	1/4
1/4	x						
3/8	x	x					
1/2	x	x	x	x			
3/4	x	x	x	x	x	x	
1	x	x	x	x	x	x	x
1 - 1/4		x	x	x	x	x	x
1 - 1/2		x	x	x	x	x	x
1 - 3/4		x	x	x	x	x	x
2		x	x	x	x	x	x
2 - 1/4			x	x	x	x	x
2 - 1/2			x	x	x	x	x
2 - 3/4				x	x	x	x
3				x	x	x	x
3 - 1/2						x	x
4						x	x

The sizes marked x are normally carried in stock.

- 4.0 SERVICE PARTS SUBSTITUTION POLICY:** In the event that engineering does not indicate a "Do not substitute" in engineering specifications, the following substitutions may be implemented in service. This policy is the result of a proposal circulated April 20, 1981, and subsequently approved by engineering departments worldwide.

Split (Cotter) Pins - Extended Prong

To be Replaced	Service Replacement
Plain finish (PLN)	Because of the superior shelf life, zinc trivalent finish (ZN6A) is recommended for service.
Phosphate Coating Finish (PHC)	Zinc trivalent finish (ZN6A)

All lengths below one inch with 1/16th inch increments, sub the next longer 1/8th inch increment.
 Example: 3/8th inch for 5/16 inch.

All lengths above 1 inch with 1/8th inch increments sub the next longer 1/4 inch increment.
 Example: 1-1/4 inch for 1-1/8 inch.

- 5.0 HEAD:** The contour of the head will be optional with the manufacturer provided the specified dimensions are maintained and there is no sharp indentation at the juncture of head and shank.
- 6.0 POINTS:** The ends of points will not be open and any gaps occurring between the prongs along the shank portion of pins beyond the point will not exceed .015 inch. The lateral misalignment of prongs over the entire length of shank will not exceed .015 inch.

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