

REV.
A

AIR3277™

FEDERAL SUPPLY CLASS
5315

RATIONALE

REDRAW ENTIRE STANDARD FOR CLARITY.

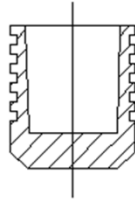


FIGURE 1A - PLUG

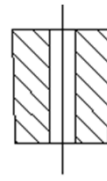


FIGURE 1B - TAPERED PIN

FIGURE 1 - PLUG AND PIN

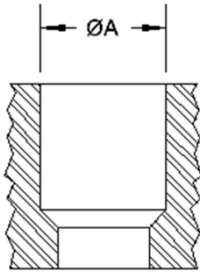


FIGURE 2A - HOLE FROM
AIR3276 TO BE PLUGGED

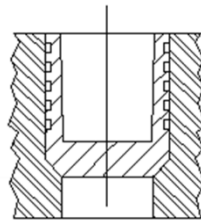


FIGURE 2B - INSERT PLUG INTO
HOLE (PLUG IS A SLIP FIT)

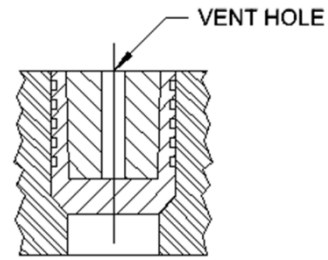
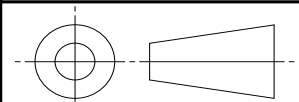


FIGURE 2C - DRIVE TAPERED PIN INTO PLUG
UNTIL EXPOSED ENDS ARE FLUSH

FIGURE 2 - PLUG AND PIN INSTALLATION

For more information on this standard, visit
<https://www.sae.org/standards/content/AIR3277A/>

THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



AEROSPACE INFORMATION REPORT

INSTALLATION PROCEDURES -
PIN/PLUG EXPANSION TYPE

AIR3277™
SHEET 1 OF 2

REV.
A

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NOTES:

1. FIRMLY SUPPORT THE ITEM TO BE PLUGGED.
2. HOLE A (SEE FIGURE 2A) AND PLUG (SEE FIGURE 1A) SHALL BE CLEAN AND DRY.
3. INSERT PLUG INTO HOLE A UNTIL IT IS FIRMLY SEATED ON THE SHOULDER AT THE BOTTOM OF THE REAMED HOLE (SEE FIGURE 2B). AN AXIAL LOAD 50 TO 100 POUNDS OR LIGHT AXIAL BLOWS APPLIED TO A PUNCH WHICH SEATS FIRMLY ON THE BOTTOM OF THE TAPERED HOLE IN THE PLUG CAN BE USED TO SEAT THE PLUG.
4. PLUG SHALL BE AT LEAST .010 BELOW SURFACE OF THE BOSS.
5. INSERT THE PIN (SEE FIGURE 1B), SMALL END FIRST, INTO THE PLUG (SEE FIGURE 2C). PINS ARE PREWAXED TO AID DRIVING, DO NOT DEGREASE. UNLESS OTHERWISE SPECIFIED, SUPPLEMENTARY LUBRICANT SHALL NOT BE USED.
6. PRESS OR DRIVE THE PIN, USING A VENTED DRIVER UNTIL THE LARGE END OF THE PIN IS .005 ABOVE TO .010 BELOW THE END OF LONG SERIES PLUGS OR .005 ABOVE TO .003 BELOW THE END OF SHORT SERIES PLUGS.
7. VENTED DRIVER DIAMETER: WHEN A HAND ARBOR PRESS IS USED TO INSTALL PINS, THE DRIVER DIAMETER SHALL BE LARGER THAN THE PIN BUT SMALLER THAN THE PLUG, THEN THE OPERATOR CAN FEEL WHEN THE PIN IS FLUSH. WHEN A HYDRAULIC OR MECHANICAL POWERED PRESS IS USED WHERE SEATING FORCES CANNOT BE FELT, A DRIVER SLIGHTLY SMALLER THAN THE PIN IS RECOMMENDED AND THE STROKE ADJUSTED TO PRESS THE PIN TO THE FLUSH POSITION. WHEN A HAMMER IS USED (RECOMMENDED FOR EXPERIMENTAL OR PROTOTYPE INSTALLATION ONLY), A DRIVER SMALLER THAN THE PIN SHOULD BE USED WITH A FEW HEAVY BLOWS (A SERIES OF LIGHT BLOWS WILL TEND TO MUSHROOM THE PIN).
8. ALL DIMENSIONS ARE IN INCHES, UNLESS OTHERWISE SPECIFIED. DIMENSIONS APPLY AFTER FINISH.
9. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

	AEROSPACE INFORMATION REPORT	AIR3277™	REV.
	INSTALLATION PROCEDURES - PIN/PLUG EXPANSION TYPE	SHEET 2 OF 3	A