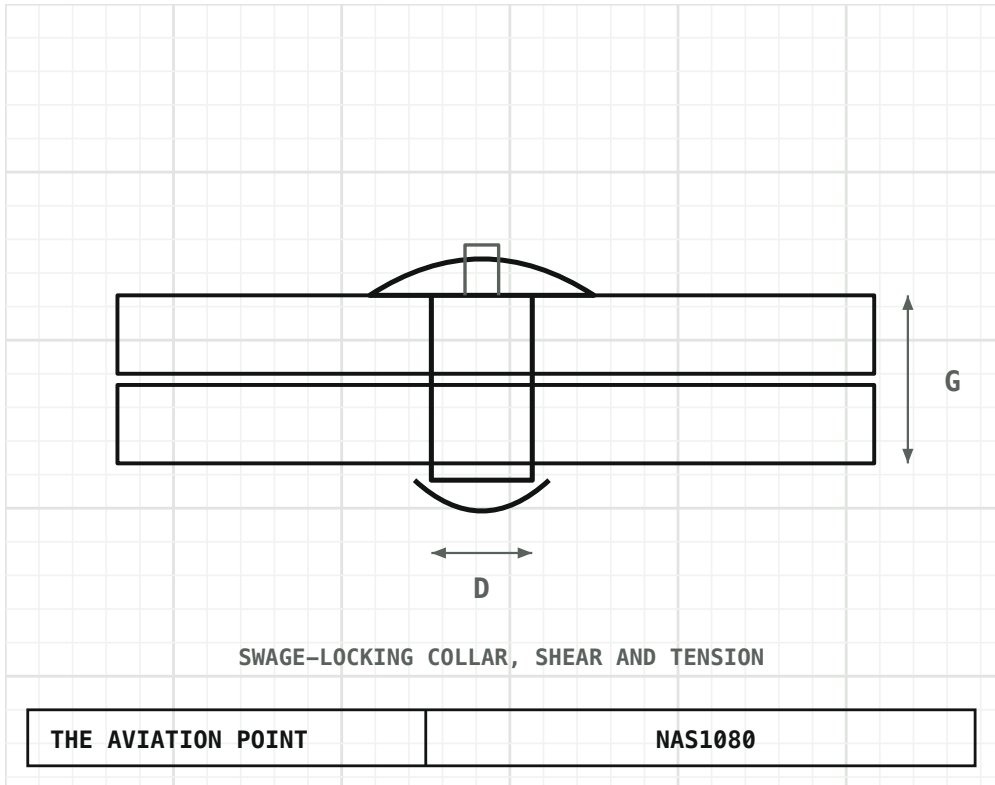
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NAS1080 — swage-locking collar, shear and tension

Collar, swage-locking, for pull-type lockbolts, shear and tension: nominal sizes, grip ranges and commonly stocked part numbers.



Engineering drawing · dimensions in inches

Specification

Item	Value
Type	Swage-locking collar
Material	Aluminum or carbon steel, by code letter
Status	Listing data: sizes and part numbers commonly stocked. The standard or manufacturer drawing governs; check its current issue before design use.

Dimensions by size

Dimension, in	.164	.190	.250
D — Nominal size, as printed	.164	.190	.250

Nominal sizes as printed; collar dimensions come from the standard.

Part numbers

.190 6 part numbers

Part no.	Use	Material	Total length min, in	Total length max, in
NAS1080C06	Shear	2024 aluminum	.185	.205
NAS1080E06	Shear	Carbon steel	.185	.205
NAS1080G06	Shear	2024 aluminum alloy	.185	.205
NAS1080AG06	Shear	2219 aluminum	.185	.205
NAS1080-06	Tension	2024 aluminum	.233	.263
NAS1080R06	Tension	Carbon steel	.233	.263

.250 6 part numbers

Part no.	Use	Material	Total length min, in	Total length max, in
NAS1080C08	Shear	2024 aluminum	—	—
NAS1080E08	Shear	Carbon steel	—	—
NAS1080G08	Shear	2024 aluminum alloy	—	—
NAS1080AG08	Shear	2219 aluminum	—	—
NAS1080-08	Tension	2024 aluminum	.305	.335
NAS1080R08	Tension	Carbon steel	.305	.335

.164 3 part numbers

Part no.	Use	Material	Total length min, in	Total length max, in
NAS1080-05	Tension	2024 aluminum	.170	.200
NAS1080AT05	Tension	2219 aluminum alloy	.170	.200
NAS1080R05	Tension	Carbon steel	.170	.200

How to read the part number

Part	Meaning
C	Material: Shear: 2024 aluminum
E	Material: Shear: carbon steel
G	Material: Shear: 2024 aluminum alloy
AG	Material: Shear: 2219 aluminum
R	Material: Tension: carbon steel
AT	Material: Tension: 2219 aluminum alloy
Example	NAS1080R06 — tension collar, carbon steel, .190 nominal size, total length .233-.263 in

Notes

- Shear collars: C = 2024 aluminum, E = carbon steel, G = 2024 aluminum alloy, AG = 2219 aluminum. Tension collars: no letter = 2024 aluminum, R = carbon steel, AT = 2219 aluminum alloy. The last two digits are the nominal size (05 = .164, 06 = .190, 08 = .250).
- Shear collars of nominal size .250 (08): the listing prints two total-length ranges, .220-.236 and .230-.250, without saying which part numbers each applies to; the length cells of those four rows are left blank.

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- The listing shows separate type C and type E collar drawings; their dimensions are not legible and are not given here.
- Approved data governs. Use the fastener the SRM, drawing or IPC calls for.

SOURCES · NAS1080 — Collar, swage-locking, for pull-type lockbolts, shear and tension

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/blind-fasteners/nas1080/

Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.