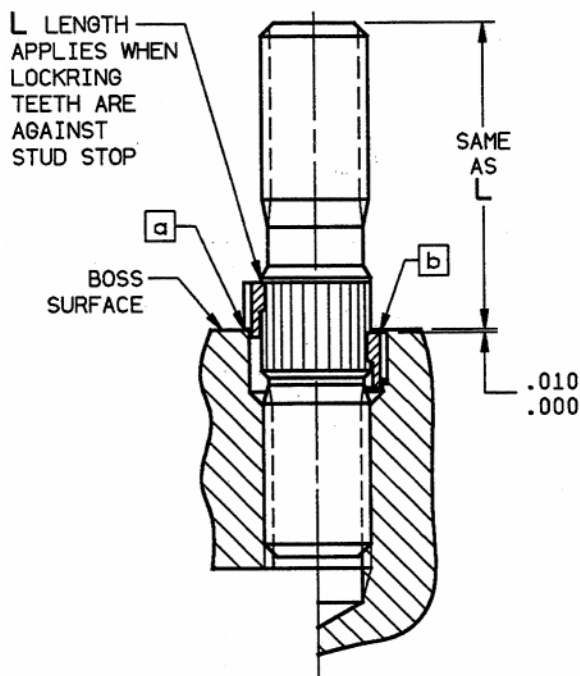


INSTALLATION:

- a. Thread in stud until locking contacts boss and locking is against stud stop.
- b. Drive locking to depth shown using proper locking drive tool.

REMOVAL:

- c. Cut the stud off approximately flush with the surface of the parent material or at top of stud serration.
- d. Center punch the remaining stud.
- e. Using the proper primary removal drill per Table V locate the noted drill directly over the center of the part and drill into the stud to the depth shown below boss surface.
- f. Center the secondary removal drill over the small hole and drill to the depth noted below boss surface. This should cut the engagement between stud serrations and the internal serrations of the locking.
- g. The remaining locking will have a very thin wall. A sharp punch will easily break it away from the parent material. Remove all pieces of the locking.
- h. Drive "ezy out" into the small hole in the stud and apply a removal torque.
- j. Clean the hole.



INSTALLATION

TABLE V

STUD PART NUMBER REF	PRIMARY REMOVAL DRILL		SECONDARY REMOVAL DRILL	
	DIAMETER	DEPTH ±.050	DIAMETER	DEPTH ±.015
SFC164()	1/16	.350	3/16	.080
SFC190()	1/16	.390	7/32	.090
SFC250()	3/32	.500	19/64	.105
SFC312()	1/8	.500	.339	.120
SFC375()	1/8	.500	13/32	.120

REINSTALLATION:

- k. These studs are unique in that the same size stud can be reinstalled. Use the same part number as specified on the original equipment.
- l. A .002 maximum thickness shim shall be used between the locking and the broached surface to prevent premature engagement of serrations. Screw the stud into the prepared hole until the top of the locking has stopped against the upper part of the stud serrations and the lower points of the locking external serrations rest on the shim surfaces. This will automatically provide the proper stud projection.
- m. Remove shim. If the locking external serrations align with the serrations in the counterbore, drive the locking using the applicable locking drive tool. If the serrations do not align, turn the stud clockwise until they do, then drive the locking. The locking will be installed flush to .010 below the boss surface.

INSTALLATION, REMOVAL AND REINSTALLATION, SFC()
STUD - RING LOCKED, & SFCH ()
SIZE-ON-SIZE SERIES