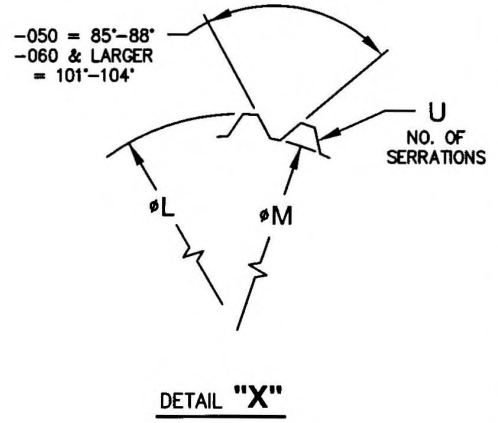
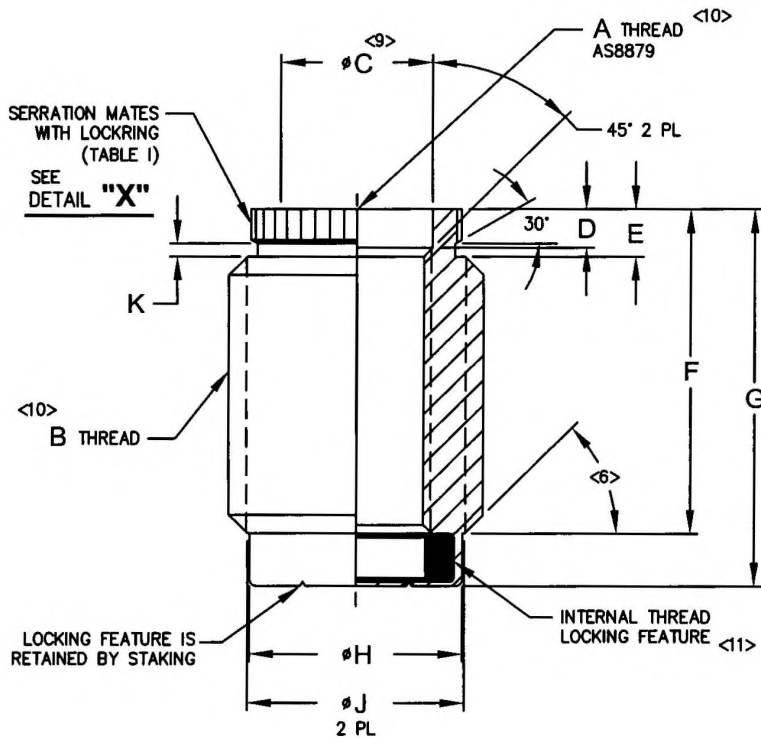
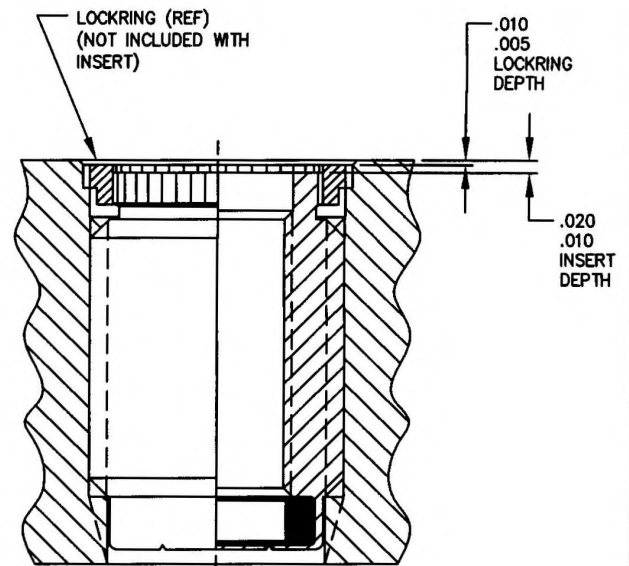
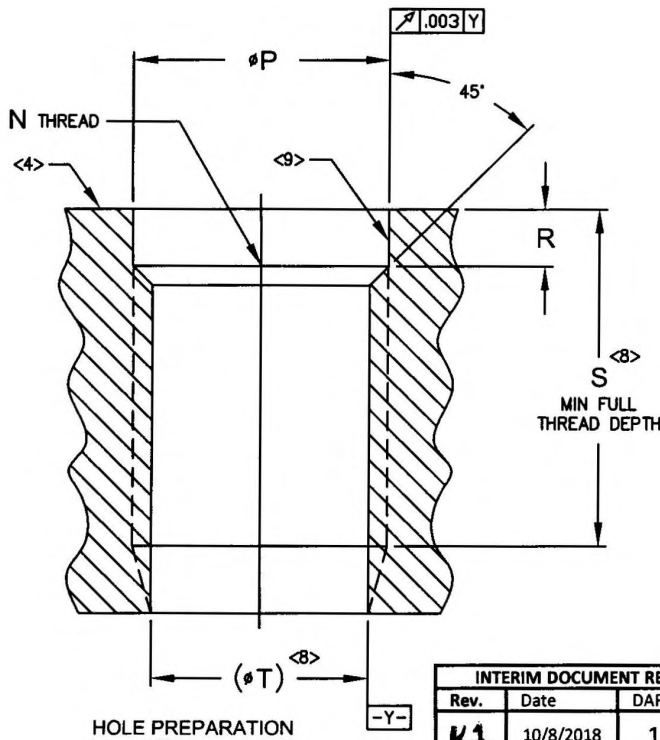


MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED



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PRODUCT DIMENSIONS NOTED ON THIS DRAWING ARE PROVIDED FOR ENVELOPE AND INSPECTION PURPOSES ONLY AND DO NOT INCLUDE DIMENSIONS NECESSARY FOR FABRICATION OF PRODUCT.

SCANNED

APPROVED DATE 75-09-18
REV. LETTER AND DATE K 08/25/06
DAF NUMBER 74891

CURRENT DESIGN ACTIVITY:



**ARCONIC**  
Arconic Fastening Systems  
Rosan Products  
3018 W. Lomita Blvd.  
Torrance, California 90505-5103

TITLE: INSERT - RING LOCKED, POLYIMIDE LOCK
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:
ANGLES = ±2° DECIMALS .XX = ±.02 .XXX = ±.010

CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
SALES DRAWING NO.
05-13008-000 SERIES
SHEET 1 OF 3

MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED

TABLE I:

INSERT PART NUMBER	A THREAD AS8879 CLASS-3B	B THREAD				φC +.007 -.002	D ±.005	E ±.010	F ±.010	G ±.015	φH MAX	φJ ±.007
		SIZE & PITCH	MAJOR DIA	ROSAN PD	MINOR DIA							
05-13008-050	.1900-32UNJF	.3750-24NS	.3750 .3684	.3498 .3479	.3257 .3185	.196	.075	.105	.390	.456	.297	.308
05-13008-060	.2500-28UNJF	.4375-20NS	.4375 .4303	.4073 .4053	.3784 .3700	.257	.083	.105	.504	.602	.360	.360
05-13008-070	.3125-24UNJF	.5000-20NS	.5000 .4928	.4698 .4678	.4409 .4325	.320	.097	.120	.640	.775	.417	.423
05-13008-080	.3750-24UNJF	.5625-18NS	.5625 .5543	.5290 .5268	.4969 .4873	.382	.097	.140	.824	.999	.480	.478

TABLE I: (CONTINUED)


INSERT PART NUMBER	K +.010 -.005	φL +.007 -.002	φM +.005 -.004	N THREAD CLASS-3B	φP +.005 -.000	R +.015 -.000	S MAX	U (NO. OF SERRATIONS)	ROTATIONAL RESISTANCE LB-IN MIN	RESISTANCE TO PULLOUT LBF MIN
05-13008-050	.025	.284	.255	.3750-24NF	.375	.109	.410	17	125	4250
05-13008-060	.025	.345	.316	.4375-20NF	.437	.109	.524	20	300	7750
05-13008-070	.035	.407	.380	.5000-20NF	.515	.125	.660	24	600	12300
05-13008-080	.035	.487	.456	.5625-18NF	.593	.141	.844	26	1100	18600

TABLE I: (CONTINUED)

INSERT PART NUMBER	MAXIMUM LOCKING TORQUE (lbf.in) ROOM TEMP.	MINIMUM BREAKAWAY TORQUE	(φT) DRILL SIZE	<7> MIN SHEAR ENGAGEMENT AREA (IN <sup>2</sup> )	TOOLING			LOCKRING
					STEP DRILL <5>	WRENCH	DRIVE TOOL	PART NO. REF
05-13008-050	18	32 ozf.in	Q (.332)	.1762	RCDC24-332	R1105W	R3605D	RL24SU5
05-13008-060	30	3.5 lbf.in	W (.386)	.3150	RCDC28-386	R1106W	R3606D	RL28SU5
05-13008-070	60	6.5 lbf.in	29/64 (.4531)	.4985	RCDC33-453	R1107X-W	R3607D	RL33SU6
05-13008-080	80	9.5 lbf.in	.506	.7714	RCDC38-506	R1108W	R3608D	RL38SU7

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APPROVED DATE 75-09-18	 CURRENT DESIGN ACTIVITY: Arconic Fastening Systems	TITLE: INSERT - RING LOCKED, POLYIMIDE LOCK	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
REV. LETTER AND DATE K 08/25/06		Rosan Products 3018 W. Lomita Blvd. Torrance, California 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:
DAF NUMBER 74891		ANGLES = ±2° DECIMALS .XX = ±.02 .XXX = ±.010	

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**NOTES:**

1. MATERIAL: INSERT: CRES, A286 PER AMS 5731 OR AMS 5734.  
LOCKING ELEMENT: POLYIMIDE PER AMS 3644, CLASS I.
2. HEAT TREAT: BRINELL 269 MIN.
3. FINISH: SOLID FILM LUBE PER AS5272 TYPE I, TIOLUBE 460.
- <4> WHEN PARENT MATERIAL SURFACE IS NOT FLAT OR IS NOT NORMAL TO AXIS OF HOLE, PROVIDE A SPOTFACE FOR PROPER LOCKRING ENTRY.
- <5> STEP DRILLS ARE DESIGNED FOR THRU HOLE DRILLING. WHEN USED TO DRILL A BLIND HOLE, IT MAY BE NECESSARY TO GRIND THE DRILL TO SUIT THE DEPTH REQUIRED.
- <6> THREAD CHAMFER ANGLES, 2 PLACES: 45° APPROX.
- <7> SHEAR ENGAGEMENT AREA IS THE ASSEMBLED DIMENSIONAL VALUE FOR THE OVERALL ENGAGED AREA OF MATING THREAD MEMBERS. IT DOES NOT REPRESENT A DIMENSION OF EITHER OF THE MEMBERS IN AN UNASSEMBLED CONDITION.
- <8> TAP DRILL DEPTH FOR BLIND TAPPING TO BE AS REQUIRED TO PROVIDE BOLT CLEARANCE. THE BOLT IS TO PASS THRU THE LOCKING FEATURE OF THE INSERT A MINIMUM OF TWO PITCHES INCLUDING CHAMFER.
- <9> THREAD MARKS PERMISSIBLE INSIDE COUNTERBORE.
- <10> THREAD DIMENSIONS ARE PRIOR TO THE ADDITION OF SOLID FILM LUBE.
- <11> OVERSPRAY OF SOLID FILM LUBE PERMISSIBLE ON INTERNAL THREAD LOCKING FEATURE.
- <12> RESISTANCE TO PULLOUT SHALL BE TESTED PER MIL-I-45910 (RINGLOCKED SCREW THREAD INSERT) IN AN AMS 4284 (356-T6) OR 6061-T6 (AMS 4150, AMS 4113 OR AMS 4027) TEST BLOCK.
13. 100% FLUORESCENT PENETRANT INSPECTION REQUIRED ON INSERT BODY PRIOR TO ASSEMBLY.

**QUALIFICATION TEST:**

- a. TEST BOLT TO BE OF BARE 718 MATERIAL AND HAVE THREADS PER AS8879.
- b. REUSABILITY TEMPERATURE TO BE 375°F FOR 6 HOURS BETWEEN CYCLES.
- c. MAXIMUM LOCKING TORQUE AND MINIMUM BREAKAWAY TORQUE LIMITS TO BE PER TABLE I.
- d. TEMPERATURE REUSABILITY TEST SHALL BE REPEATED FOR A TOTAL OF 50 TIMES AND MINIMUM PREVAILING TORQUE SHALL BE RECORDED EVERY FIVE CYCLES. TEST BOLTS MAY BE REPLACED WHEN WORN PROVIDED A MINIMUM OF TEN TEST CYCLES HAVE BEEN PERFORMED ON THE BOLT AND SHALL BE NOTED IN THE TEST REPORT. ELONGATION SHALL BE .0075 FOR 2.00 SPACERS, .0057 FOR 1.50 SPACERS AND .0038 FOR 1.00 SPACERS. ALL PARTS TESTED SHALL MEET THE REQUIREMENTS OF TABLE I AT THE COMPLETION OF THE TEST. ALL PARTS TESTED SHALL MEET THE REQUIREMENTS OF TABLE I FOR AT LEAST 45 CYCLES AND 80% OF TESTED PARTS SHALL MEET THE REQUIREMENTS AT THE COMPLETION OF THE TEST. USE OF MIL-PRF-7808L OIL AS ASSEMBLY AID IS OPTIONAL.

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DAF NUMBER 74891		ANGLES = ±2° DECIMALS .XX = ±.02 .XXX = ±.010	05-13008-000 SERIES SHEET 3 OF 3