

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

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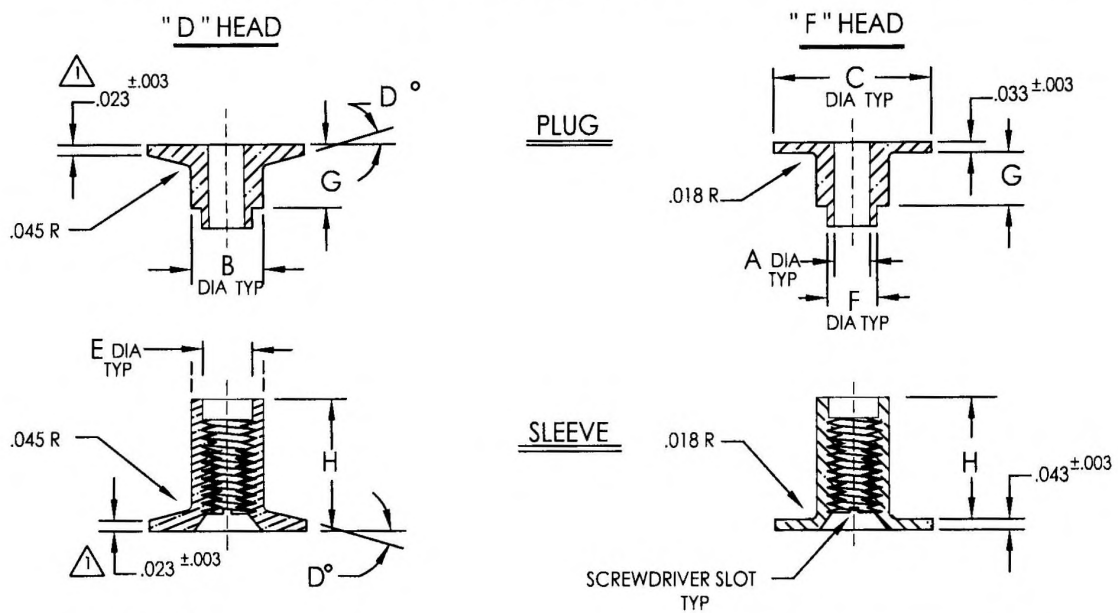


TABLE I

SIZE		THREAD PER AS8879	A ±.003 DIA TYP	B ±.003 DIA TYP	C DIA TYP	D°	E DIA	F DIA
PLUG	SLEEVE							
6	632	.1380-32 UNJC-3B	.144	.309	.500	13°	.224	.227
8	832	.1640-32 UNJC-3B	.169	.309	.500	13°	.224	.227
10	1032	.1900-32 UNJF-3B	.194	.341	.625	13°	.256	.259
25	428	.2500-28 UNJF-3B	.257	.403	.750	14°	.313	.316
31	524	.3125-24 UNJF-3B	.318	.497	.875	14°	.406	.409

NOTES: (UNLESS OTHERWISE SPECIFIED)

- 1. .033 ON 524 SIZE.
- 2. CONSULT ALCOA ENGR. DEPT. FOR AVAILABILITY OF OPTIONAL MATERIAL, FINISH AND SIZES.
- 3. SLEEVE AND PLUG FORM A TELESCOPIC PRESS FIT.
- 4. HEAD STYLES MAY BE COMBINED BETWEEN PLUGS AND SLEEVES WITHIN THE SAME SIZE.
- 5. AVAILABLE IN LONGER LENGTHS USING FACTORY INSTALLED SLEEVE EXTENSIONS.
- 6. PART CODE SYSTEM :
 S 1 0 6 F 4 2 8 - 0 8
 P 1 0 6 D 2 5 - 0
 ADD SUFFIX "NF" TO PART NUMBER IF NO FINISH IS REQUIRED.
 LENGTH DASH NUMBER . * SEE SHEET 2
 SIZE: SEE TABLE I.
 HEAD STYLE : D = FLUSH HEAD
 F = NON - FLUSH HEAD
 TYPE: THREADED ALL METAL SELF LOCKING COILTHREAD PER NASM8846.
 MATERIAL: 0 = 2024-T4 OR T351 PER AMS-QQ-A-225/6, ALODINE PER MIL-DTL-5541.
 6 = CRES STEEL PER AMS 5640 , ASTM-A-581/ ASTM-A-582 ,PASSIVATE PER AMS2700 .
 9 = CARBON STEEL PER ASTM-A-108/ CAD PLATE PER AMS -QQ-P-416 TYPE II, CLASS 2.
 SERIES 100: GROMMET TYPE PANEL INSERT
 PART TYPE: P = PLUG
 S = SLEEVE

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
B1	10/8/2018	117431

APPROVED DATE 02/06/1978	CURRENT DESIGN ACTIVITY: ARCONIC Arconic Fastening Systems	TITLE: INSERT GROMMET TYPE SELF- LOCKING HELICAL COIL	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324 SALES DRAWING NO.
REV. LETTER AND DATE B 06/06/2011	Rosan Products 3018 W. Lomita Blvd. Torrance, California 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	106 SERIES
DAF NUMBER 97042	<i>SAB</i>	ANGLES = ±3° DECIMALS .XX = ±.02 .XXX = ±.010	SHEET 1 OF 3

EXAMINED

LENGTH TABULATION

TABLE II 632 , 832 , 1032 , & 428 SIZES

SLEEVE DASH No.	PLUG DASH No.		-X	-0	-01	-1	-11	-2	-21	-3	-31
	H	G		.085	.100	.116	.131	.147	.162	.179	.194
-03											
-04											
-06											
-08	.415			.500	.515	.531	.546	.562	.577	.594	.609
-10	.540			.625	.640	.656	.671	.687	.702	.719	.734
-12	.665			.750	.765	.781	.796	.812	.827	.844	.859
-14	.790			.875	.890	.906	.921	.937	.952	.969	.984
-16	.915			1.000	1.015	1.031	1.046	1.062	1.077	1.094	1.109
-18	1.040			1.125	1.140	1.156	1.171	1.187	1.202	1.219	1.234
-20	1.165			1.250	1.265	1.281	1.296	1.312	1.327	1.344	1.359

⚠

TABLE III 524 SIZE

SLEEVE DASH No.	PLUG DASH No.		-X	-0	-01	-1	-11	-2	-21	-3	-31
	H	G		.248	.264	.279	.295	.310	.326	.341	.357
-03											
-04											
-06											
-08											
-10											
-12											
-14	.627			.875	.890	.906	.922	.938	.953	.969	.985
-16	.752			1.000	1.016	1.031	1.047	1.063	1.078	1.094	1.110
-18	.877			1.125	1.140	1.156	1.172	1.188	1.203	1.219	1.235
-20	1.002			1.250	1.266	1.281	1.297	1.312	1.328	1.343	1.359
-22	1.127			1.375	1.391	1.406	1.422	1.437	1.453	1.468	1.484
-24	1.250			1.498	1.514	1.529	1.545	1.560	1.576	1.591	1.607

⚠⚠ PANEL THICKNESS

SELECT SLEEVE AND PLUG DASH NUMBERS BY DETERMINING THE THICKNESS CLOSEST TO BUT NOT GREATER THAN PANEL TO BE USED.

⚠ -08 NOT AVAILABLE IN 428 SIZE

EXAMPLES:

- REQUIREMENTS : 632 THREAD SIZE , CARBON STEEL , FLUSH HD. FOR A .500 OVERALL PANEL .
FROM TABLE SELECT :
- 0 PLUG = P196D6 -0
- 08 SLEEVE = S196D632-08
- REQUIREMENTS : 524 THREAD SIZE , AL . ALLOY , NON -FLUSH HD FOR A .890 OVERALL PANEL .
FROM TABLE SELECT :
- 01 PLUG = P106F31-01
- 14 SLEEVE = 106F524 -14

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INDICATES NOT AVAILABLE

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REV. LETTER AND DATE B 06/06/2011	Rosan Products 3018 W. Lomita Blvd. Torrance, California 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO. 106 SERIES
DAF NUMBER 97042		ANGLES = ±3° DECIMALS .XX = ±.02 .XXX = ±.010	SHEET 2 OF 3

SCANNED

INSTALLATION

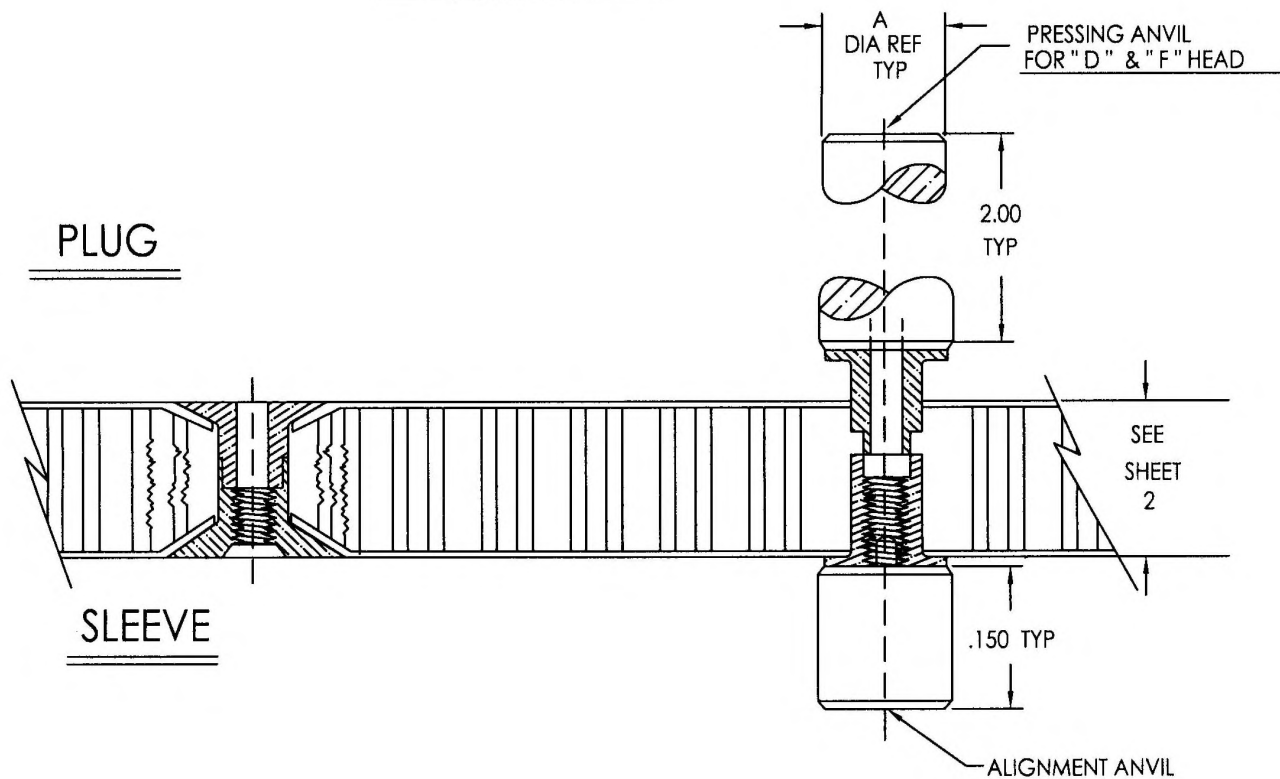


TABLE IV

SIZE	THRU HOLE IN PANEL	TOOL KIT "D" & "F" HEAD	TOOL COMPONENTS		A DIA. TYP REF
			PRSNNG ANVIL	ALIGN. ANVIL	
632	(P) .323	1617-1	1613-1	1617-1-2	.50
832	(P) .323	1617-2	1614-2-1	1617-2-2	.56
1032	(T) .358	1617-3	1614-3-1	1617-3-2	.62
428	(27/64) .421	1617-4	1614-4-1	1617-4-2	.75
524	(33/64) .515	1617-5	1614-5-1	1617-5-2	.87

INSTALLATION NOTES:

1. INSTALLATION PRESSURE IS A VARIABLE DEPENDENT UPON TYPE OF PANEL BEING USED.
2. ANVILS ARE LOW CARBON STEEL WITH A COMMERCIAL CORROSION INHIBITING COATING.

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