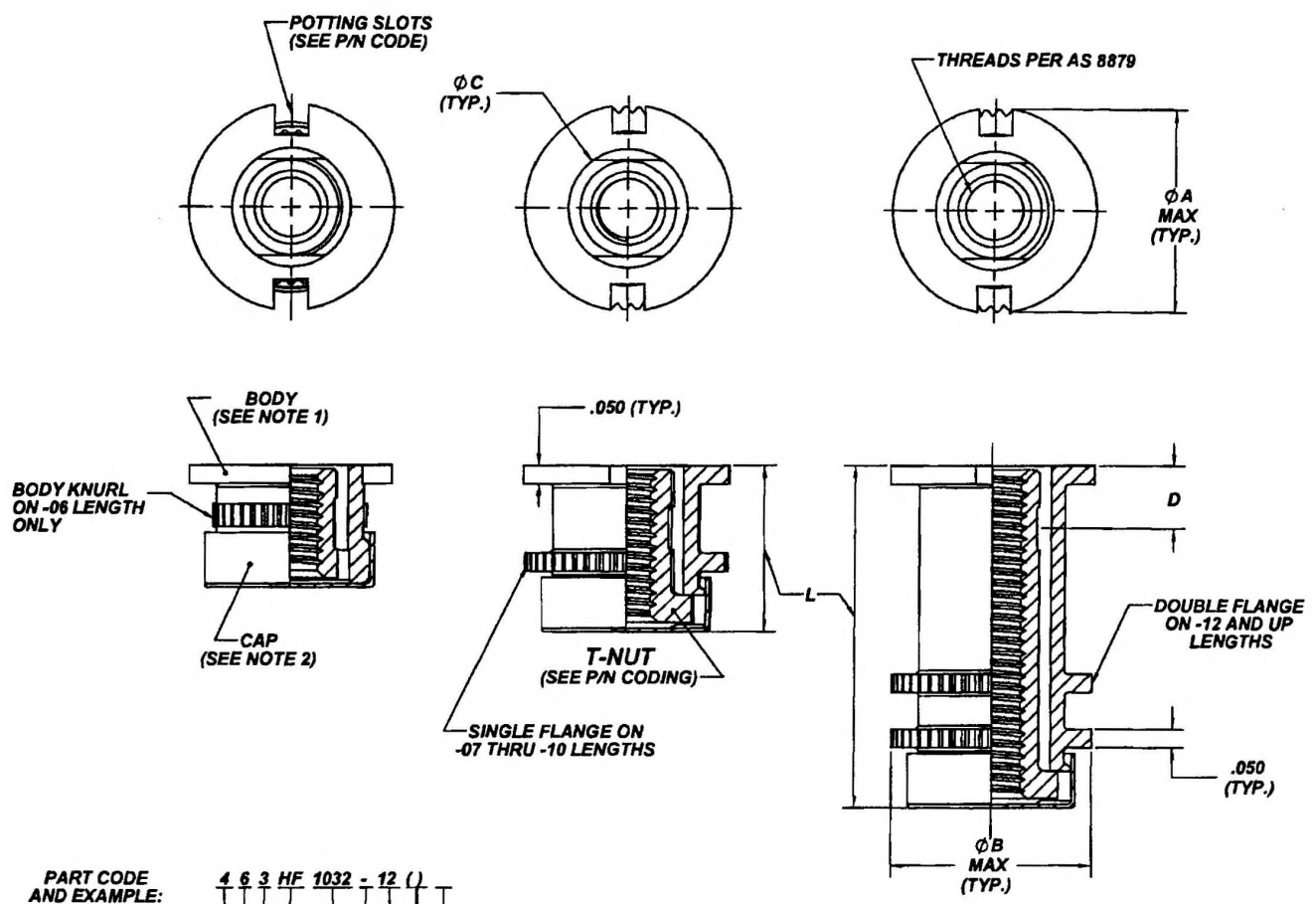


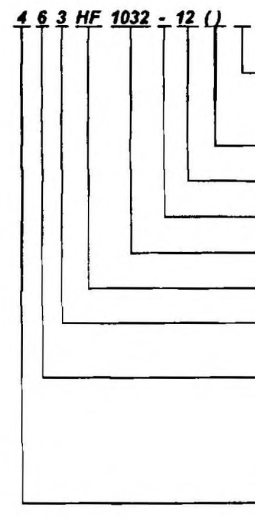
Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi - Shan

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

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PART CODE AND EXAMPLE:



- INSTALLATION TAB: BLANK = SUPPLY WITH PLASTIC OR METAL TAB.  
-MT = SUPPLY WITH METAL TAB.  
-PT = SUPPLY WITH PLASTIC TAB.
- ADD "NS" WHEN SLOTS NOT REQUIRED.
- LENGTH DASH NUMBER (SEE TABLE 2)
- REPLACE WITH "M" FOR MoS2 DRY FILM LUBRICANT ON NUT.
- THREAD SIZE CODE (SEE TABLE 1)
- FLUSH HEAD STYLE, FLOATING NUT, POTTING SLOTS
- THREAD TYPE: 3 = THREADED ONLY  
5 = CRIMP LOCK PER NASM 25027
- NUT MATERIAL AND FINISH: 6 = 303 CRES STEEL PER AMS 5640, ASTM-A-592. PASSIVATE PER AMS 2700, FLASH SILVER PLATE PER ASTM-B-700 ON SELF-LOCKING NUTS ONLY UNLESS "M" FINISH IS REQUIRED.  
9 = CARBON STEEL PER ASTM-A-108/AMS-STD-66. CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.
- SERIES PREFIX

NOTES; UNLESS OTHERWISE SPECIFIED:

1. BODY MATERIAL AND FINISH = 2024-T4 OR T351 ALUMINUM ALLOY PER AMS-QQ-A-225. ALODINE PER MIL-DTL-5541.
2. CAP MATERIAL AND FINISH = BRASS, CADMIUM PLATED OR ALUMINUM, ANODIZED AT MANUFACTURER'S OPTION.
3. BURRS PERMISSIBLE AT KNURLED AREAS AND UNDERSIDE OF HEAD AT SLOTS.
4. ALL INSERTS HAVE A .031 MINIMUM RADIAL FLOAT.
- <5> ADHESIVE BACKED INSTALLATION TABS ARE FURNISHED WITH EACH SLOTTED PART.
6. CONSULT ALCOA FASTENING SYSTEM'S ENGINEERING DEPARTMENT FOR AVAILABILITY OF OPTIONAL MATERIALS, FINISHES, AND SIZES.

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
E1	10/8/2018	117431

ORIGINAL DESIGN ACTIVITY: CAGE CODE 29372

APPROVED DATE 25 SEP 1978	CURRENT DESIGN ACTIVITY: <b>ARCONIC</b> Arconic Fastening Systems	TITLE: <b>INSERT, POTTED-IN TYPE FLOATING NUT</b>	CURRENT DESIGN ACTIVITY: <b>CAGE CODE: 83324</b>
REV. LETTER AND DATE E 15 APR 2010	<b>ROSAN PRODUCTS</b> 3018 W. LOMITA BLVD. TORRANCE, CA 90505	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	<b>SALES DRAWING NO.</b>
DAF NUMBER 91993 SAB		ANGLES DECIMALS XX = ±.2° XX = ±.02 XXX = ±.010	<b>400 HF SERIES</b>
			<b>SHEET 1 OF 2</b>

Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Vol - Shan

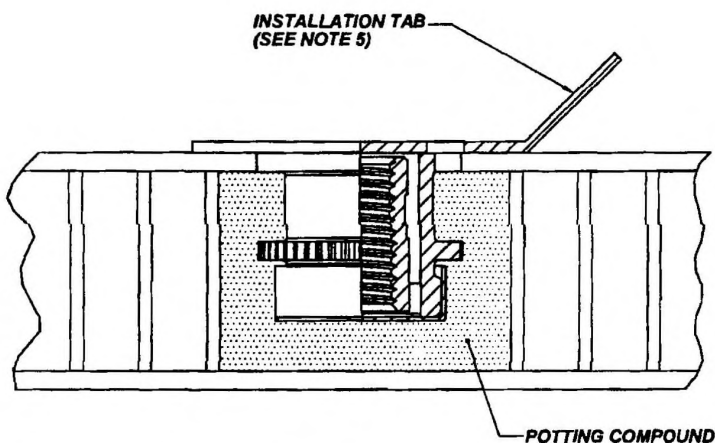
MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED

**TABLE 1**

SIZE CODE	THREAD SIZE PER AS8879	Ø A	Ø B	C	INSTALLATION DRILL DIA.
440	.1120-40UNJC-3B	.499	.489	.323	.500-.505
632	.1380-32UNJC-3B	.499	.489	.323	.500-.505
832	.1640-32UNJC-3B	.561	.551	.323	.562-.567
1032	.1900-32UNJF-3B	.561	.551	.323	.562-.567
428	.2500-28UNJF-3B	.686	.676	.437	.687-.692
524	.3125-24UNJF-3B	.811	.801	.437	.812-.817
624	.3750-24UNJF-3B	.936	.926	.515	.937-.942

**TABLE 2**

DASH NO.	L	D	MINIMUM FULL THREAD LENGTH						
			440	632	832	1032	428	524	624
-06	.335	.14			.292		SIZE NOT AVAILABLE		
-07	.395					.350	.350	.350	.350
-08	.455						.410	.410	.410
-10	.565	.17	.224	.276	.328		.520	.520	.520
-12	.690					.380			.625
-14	.812						.500	.625	
-16	.935								.750



**TABLE 3**

THREAD SIZE	INSTALLATION TAB NUMBER
440	T13
632	T13
832	T6
1032	T6
428	T9
524	T11
624	T27

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
E1	10/8/2018	117431

ORIGINAL DESIGN ACTIVITY: CAGE CODE 29372

APPROVED DATE <b>25 SEP 1978</b>	CURRENT DESIGN ACTIVITY: <b>ARCONIC</b> Arconic Fastening Systems <b>ROSAN PRODUCTS</b> 3018 W. LOMITA BLVD. TORRANCE, CA 90505	TITLE: <b>INSERT, POTTED-IN TYPE                  FLOATING NUT</b>	CURRENT DESIGN ACTIVITY: <b>CAGE CODE: 83324</b> <b>SALES DRAWING NO.</b>  <b>400 HF SERIES</b>
REV. LETTER AND DATE <b>E 15 APR 2010</b>	DAF NUMBER <b>91993</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	ANGLES DECIMALS .XX = .12" .XXX = .02" .XXXX = .010"
			SHEET 2 OF 2

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