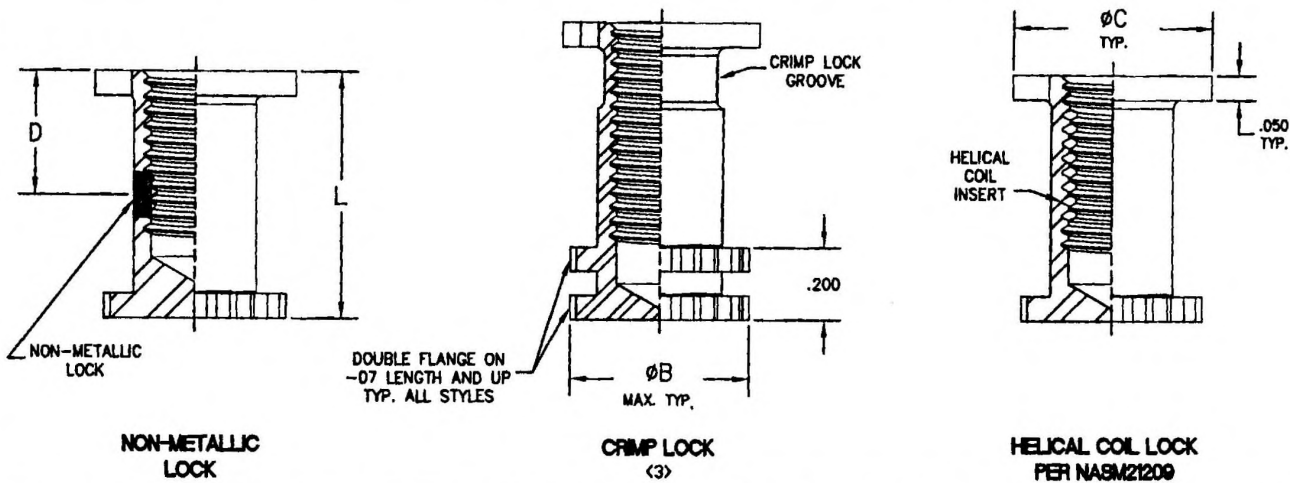
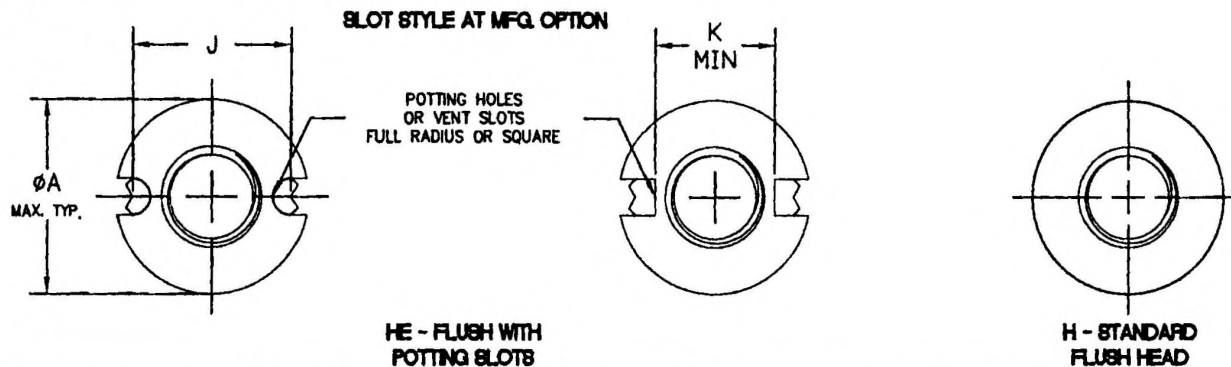


Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi-Shan

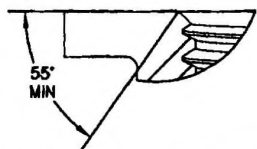
MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED



HEAD STYLES:



DETAIL 1 SLOT OPTION



OPTION FOR SHORT PARTS:

SHORT LENGTH INSERTS MAY INCORPORATE SAME MATERIAL AND FINISH SHIM OR DISK TO PROVIDE FULL THREADS

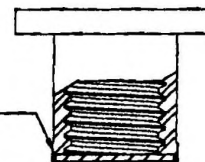


TABLE 1

SIZE	THREAD	A DIA MAX	B DIA MAX	C DIA REF	D	J	K MIN	INSTALLATION TAB NO.	INSTALLATION DRILL DIA. +.005 -.000
440	.1120-40 UNJC-3B	.374	.322	.195	.100	.280	.173	PT16 OR T16	.375
632	.1380-32 UNJC-3B	.436	.385	.230	.120	.343	.236	PT21 OR T21	.437
832	.1640-32 UNJC-3B	.499	.447	.290	.120	.405	.298	PT4 OR T4	.500
1032	.1900-32 UNJF-3B	.499	.447	.290	.120	.405	.298	PT4 OR T4	.500
428	.2500-28 UNJF-3B	.561	.510	.353	.140	.467	.360	PT8 OR T8	.562
524	.3125-24 UNJF-3B	.686	.635	.460	.150	.591	.484	PT9 OR T9	.687
624	.3750-24 UNJF-3B	.811	.697	.550	.160	.718	.611	PT11 OR T11	.812

GENERAL NOTES:

- BURRS PERMISSIBLE AT KNURLED AREAS AND ON UNDERSIDE OF HEAD AROUND POTTING SLOTS.
- ADHESIVE BACKED INSTALLATION TABS PER TABLE 1 ARE FINISHED WITH INSERTS.
- CRIMP LOCK AVAILABLE IN A-286 CRES. 303 CRES AND CARBON STEEL ONLY.
- PLATING OR SOLID FILM LUBE IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.
- CLOSE OUT DISC MAY BE REQUIRED IN SOME LENGTHS TO PROVIDE MINIMUM FULL THREAD.
- LOCATE LOCKING PELLET NO CLOSER THAN 10" FROM EDGE OF EITHER POTTING SLOT.
- CONSULT ALCOA ENGINEERING DEPARTMENT FOR AVAILABILITY OF OPTIONAL MATERIALS, FINISHES OR SIZES.
- SURFACE FINISH TO BE 125 MICRONS.

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
H1	10/8/2018	117431

APPROVED DATE

24 JUN 05

REV. LETTER AND DATE

H 07 FEB 2012

DAF NUMBER

99711

SAB

CURRENT DESIGN ACTIVITY:



ARCONIC

Arconic Fastening Systems

Rosan Products
3018 W. Lomita Blvd.
Torrance, California 90505-5103

TITLE:

INSERT
POTTED-IN
BLIND THREAD

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES &
ASME Y14.5M TOLERANCES:

ANGLES = ±J
DECIMALS .XX = ±.02
.XXX = ±.010

CURRENT DESIGN ACTIVITY:

CAGE CODE: 83324

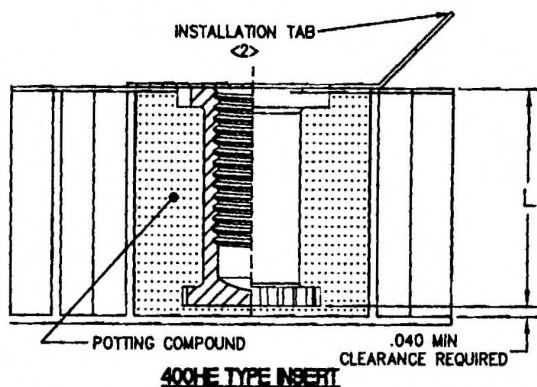
SALES DRAWING NO.

400(H AND HE) SERIES

SHEET 1 OF 2

THIS DRAWING EMPLOYS A CONFIDENTIAL, PROPRIETARY DESIGN & ALL DESIGN, MANUFACTURING PRODUCTION USE & SALE RIGHTS REGARDING SAME ARE EXPRESSLY RESERVED.

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

TABLE 2 "X" INDICATES NOT AVAILABLE

LENGTH DASH NO.	L	MIN. FULL THREAD LENGTH (EXCEPT HELICAL COIL)						
		440	632	632	1032	488	684	684
-04	.220	.170	.170	.170	.170	X	X	X
-05	.285	.190	.190	.190	.190	.235	X	X
-06	.335	.225	.235	.235	.235	.250	X	X
-07	.395	.250	.280	.280	.280	.250	X	X
-08	.455	.250	.280	.330	.330	.330	.320	X
-10	.565	.250	.280	.330	.380	.420	.430	.425
-12	.690	.250	.280	.330	.380	.500	.550	.550
-14	.815	.250	.280	.330	.380	.500	.625	.625
-16	.935	.250	.280	.330	.380	.500	.625	.750

TABLE 3 "X" INDICATES NOT AVAILABLE

LENGTH DASH NO.	L	HELICAL COIL MIN. FULL THREAD LENGTH						
		440	632	632	1032	488	684	684
-04	.220	X	X	X	X	X	X	X
-05	.285	X	X	X	X	X	X	X
-06	.335	.112	X	X	X	X	X	X
-07	.395	.168	.138	X	X	X	X	X
-08	.455	.224	.207	.164	.190	X	X	X
-10	.565	.224	.276	.246	.285	.250	X	X
-12	.690	.224	.276	.328	.380	.375	.312	X
-14	.815	.224	.276	.328	.380	.500	.469	.375
-16	.935	.224	.276	.328	.380	.500	.469	.562

THIS DRAWING EMBODIES A CONFIDENTIAL PROPRIETARY DESIGN & ALL DESIGN, MANUFACTURING PRODUCTION, USE & SALE RIGHTS REGARDING SAME ARE EXPRESSLY RESERVED.

PART CODE AND EXAMPLE:

4 6 5 HE 428 -12

INSTALLATION TAB BLANK = SUPPLY WITH PLASTIC OR METAL TAB.
-MT = SUPPLY WITH METAL TAB.

LENGTH DASH NUMBER (SEE TABLE 2 OR TABLE 3)
THREAD SIZE: (SEE TABLE 1)

HEAD STYLE H = STANDARD FLUSH
HE = FLUSH WITH POTTING SLOTS

THREAD TYPE: 3 = THREADED ONLY
4 = NYLON LOCK
5 = CRIMP LOCK PER NASM 25027
6 = SELF-LOCKING HELICAL COIL INSERT PER NASM21209.

MATERIAL AND STANDARD FINISH: 0 = ALUMINUM ALLOY 2024-T4 OR T-351 PER AMS-QQ-A-225/6 ALODINE PER MIL-DTL-5541.
5 = A286 CRES PER ASTM5731, PASSIVATE PER AMS2700.
6 = CRES 303 PER ASTM-A-581/ASTM-A582. AMS5640 PASSIVATE PER AMS2700
9 = CARBON STEEL PER ASTM-A-108 CADMIUM PLATE PER AMS-QQ-P-416. TYPE II CLASS 2, COLOR YELLOW/GOLD

SERIES 400 POTTED-IN TYPE INSERT

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
H1	10/8/2018	117431

APPROVED DATE 24 JUN 05
REV. LETTER AND DATE H 20 AUG. 07
DAF NUMBER 99711

CURRENT DESIGN ACTIVITY:

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

TITLE:
INSERT POTTED-IN BLIND THREAD

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:

ANGLES = ±3°
DECIMALS .XX = ±.02
.XXX = ±.010

CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
SALES DRAWING NO.
400(H AND HE) SERIES
SHEET 2 OF 2