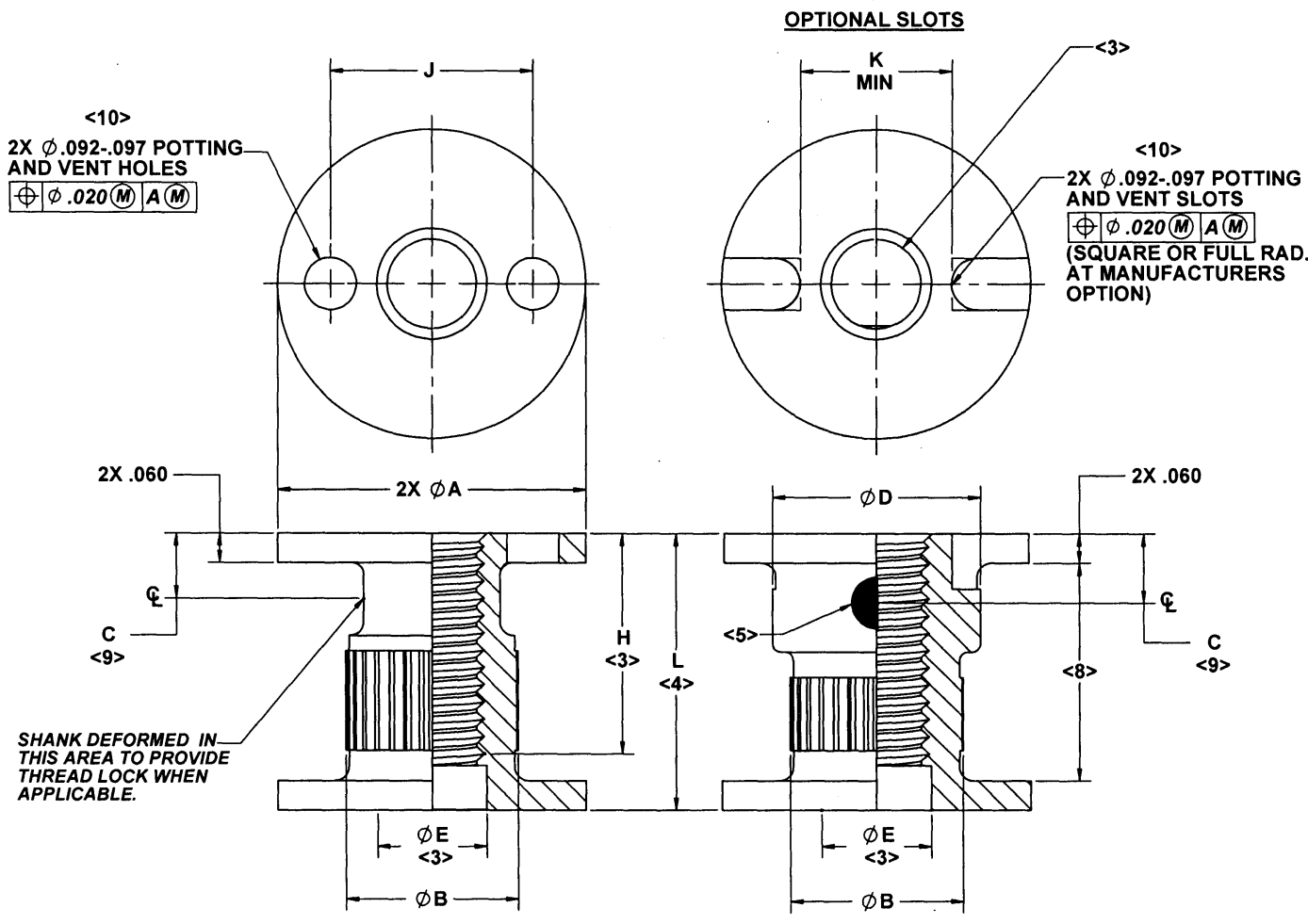


MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED

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ALL STEEL AND CRES SELF-LOCKING AND NONSELF-LOCKING; OR NONSELF-LOCKING ALUMINUM STYLE
 ALUMINUM SELF-LOCKING STYLE; OR ALTERNATE NONSELF-LOCKING ALUMINUM STYLE

FIRST DASH NO.	THREAD CLASS 3B MINOR DIA - A -	Ø A +.000 -.010	Ø B	C	Ø D	Ø E	H MIN	J BASIC	K MIN	L MIN <4>	INSTALLATION HOLE SIZE
-06	.1380-32 UNJC	.560	.30	.12	.375	.139-.145	.276	.367	.260	.250	.561-.566
-08	.1640-32 UNJC	.560	.30	.12	.375	.168-.174	.328	.367	.260	.250	.561-.566
-3	.1900-32 UNJF	.560	.30	.12	.375	.195-.201	.380	.367	.260	.250	.561-.566
-4	.2500-28 UNJF	.685	.37	.14	.440	.256-.263	.500	.467	.360	.312	.686-.691
-5	.3125-24 UNJF	.685	.47	.16	.500	.315-.322	.625	.467	.360	.312	.686-.691
-6	.3750-24 UNJF	.841	.50	.22	.550	.376-.383	.750	.591	.484	.375	.842-.847

- NOTES:
 1. MATERIAL:
 1.1 CARBON STEEL PER ASTM-A108, ASTM-A576, OR MATERIAL COMPOSITION PER AIR4127, ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM.
 1.2 303 CRES PER ASTM-A582/A582M.
 1.3 ALUMINUM ALLOY 2024-T4 OR T351 PER AMS-QQ-A-225/6.

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2. FINISH:
 2.1 CARBON STEEL: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
 2.2 303 CRES: PASSIVATE PER AMS2700, METHOD 1, CLASS 4; SILVER PLATE PER AMS2410 OR AMS2411; OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
 2.3 ALUMINUM ALLOY: ANODIZE PER MIL-A-8625, TYPE 1, CLASS OPTIONAL.
 2.4 OPTIONAL FINISH: SOLID FILM LUBRICANT PER AS5272, TYPE 1. APPLIED TO THREADS ONLY.
 2.5 PLATING OR DRY FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.

(EQUIV TO NAS1833)

APPROVED DATE N/A	ARCONIC Arconic Fastening Systems ROSAN PRODUCTS 3018 W. LOMITA BLVD. TORRANCE, CA 90505	TITLE: INSERT, MOLDED-IN, THRU-THREADED, SELF-LOCKING & NONSELF-LOCKING	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
REV. LETTER AND DATE L 10 DEC 2012		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO.
DAF NUMBER T02867 SAB		ANGLES = ±3° DECIMALS .XX = ± .02 .XXX = ± .010	D1833 SERIES

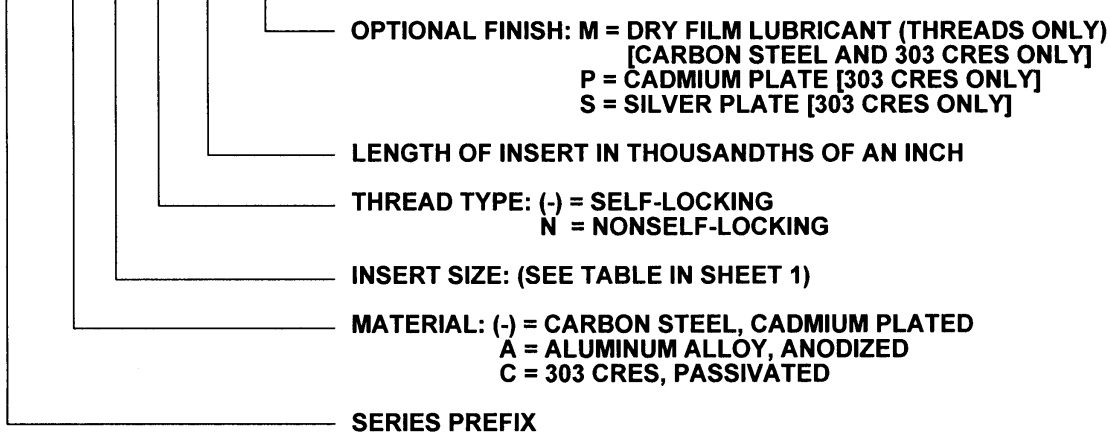
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NOTES (CONTINUED);

- <3> **THREADS:**
 - 3.1 SHALL BE IN ACCORDANCE WITH AS8879.
 - 3.2 MINIMUM THREAD WHEN LENGTH PERMITS SHALL BE 2X DIAMETER OF THREAD.
 - 3.3 LENGTHS SHORTER THAN 2X DIAMETER OF THREAD SHALL BE THREADED THE ENTIRE LENGTH.
 - 3.4 LENGTHS LONGER THAN 2X DIAMETER MAY HAVE A THREAD RELIEF SHOWN BY Ø"E " AND "H" OR MAY BE THREADED THE ENTIRE LENGTH (MANUFACTURER'S OPTION).
 - 3.5 MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
- <4> **LENGTH REQUIREMENTS:**
 - 4.1 LENGTH OF INSERTS SHALL BE DEFINED BY A THREE DIGIT DASH NUMBER IN THOUSANDTHS OF AN INCH. EXAMPLE: -625 = .625 INCH; -385 = .385 INCH.
 - 4.2 FOR MINIMUM LENGTH WHICH MAY BE SPECIFIED, SEE TABLE IN SHEET 1.
- <5> **LOCKING TORQUE:**
 - 5.1 SHALL BE IN ACCORDANCE WITH NASM25027, EXCEPT SELF-LOCKING CORROSION RESISTANT STEEL INSERT WITHOUT PLATING OR LUBRICATION WILL BE TESTED USING A SILVER PLATED BOLT OR SCREW.
 - 5.2 LOCATE LOCKING PELLET NO CLOSER THAN 10° FROM EDGE OF EITHER POTTING HOLE.
- 6. **BURRS CAUSED BY DRILLING POTTING HOLES PERMISSABLE UNDER FLANGE.**
- 7. **AN ADHESIVE BACKED INSTALLATION TAB (PLASTIC OR ALUMINUM) SHALL BE FURNISHED WITH EACH INSERT.**
 NOTE: WHEN TAB MATERIAL PREFERENCE IS DESIRED PROCURING ACTIVITY SHALL SPECIFY.
- <8> **EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375 INCH.**
- <9> **CENTERLINE OF THREAD LOCK WHEN APPLICABLE.**
- <10> **POTTING AND VENT HOLES OR SLOTS (MANUFACTURER'S OPTION).**
- 11. **ALL DIAMETERS SHALL BE WITHIN .002 CIRCULAR RUNOUT TO DATUM A.**
- 12. **DIMENSIONAL LIMITS APPLY AFTER PLATING AND PRIOR TO SOLID FILM LUBE.**
- 13. **PART NUMBER CODE:**

D1833 - 08 - 625 M



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APPROVED DATE N/A	CURRENT DESIGN ACTIVITY: ARCONIC Arconic Fastening Systems	TITLE: INSERT, MOLDED-IN, THRU-THREADED, SELF-LOCKING & NONSELF-LOCKING	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324 SALES DRAWING NO. D1833 SERIES
REV. LETTER AND DATE L 10 DEC 2012	ROSAN PRODUCTS 3018 W. LOMITA BLVD. TORRANCE, CA 90505	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	ANGLES DECIMALS .XX = ± .02 .XXX = ± .010
DAF NUMBER 102867			SHEET 2 OF 2