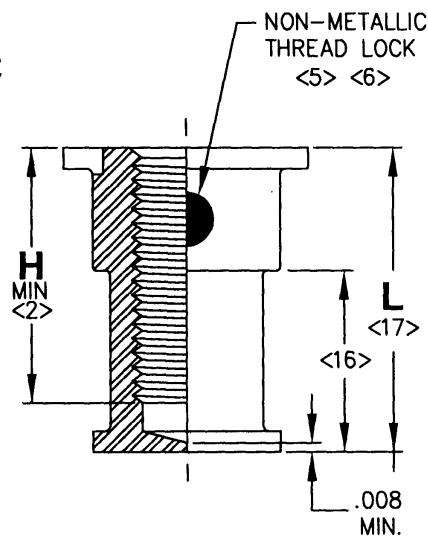
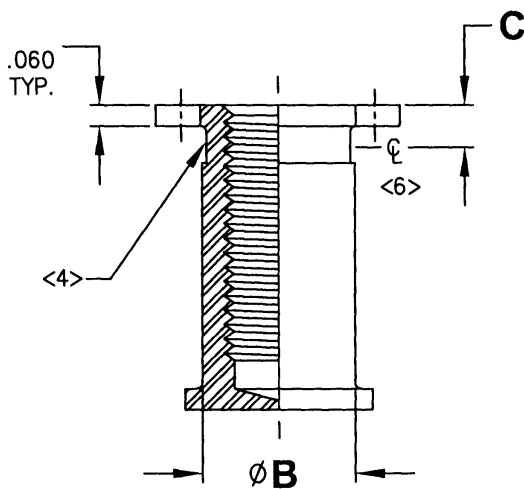
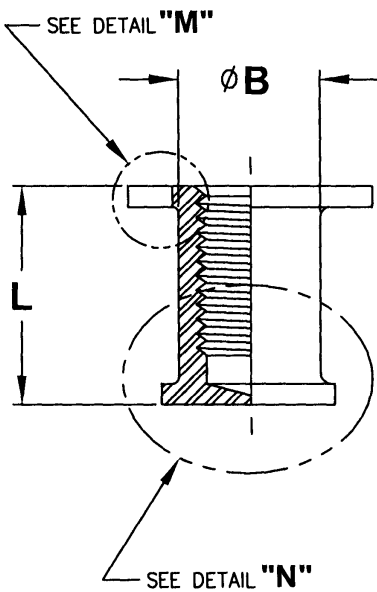
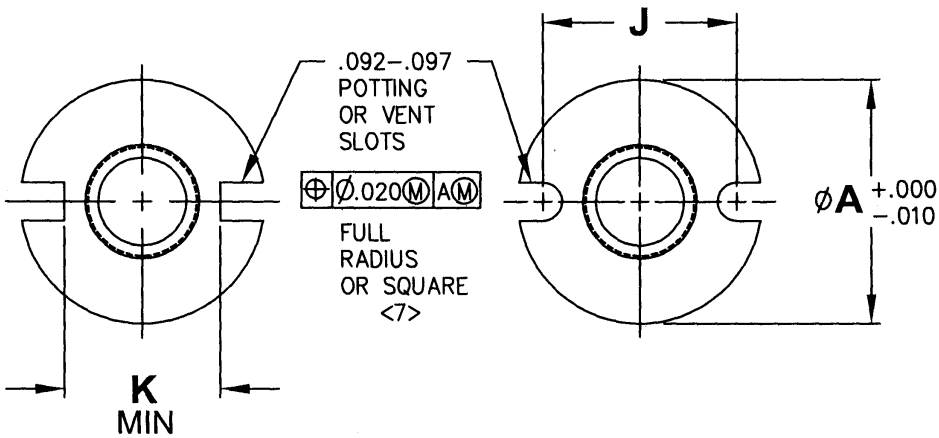


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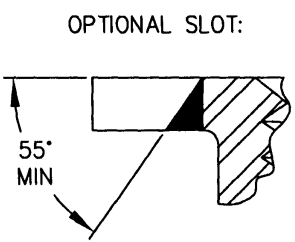
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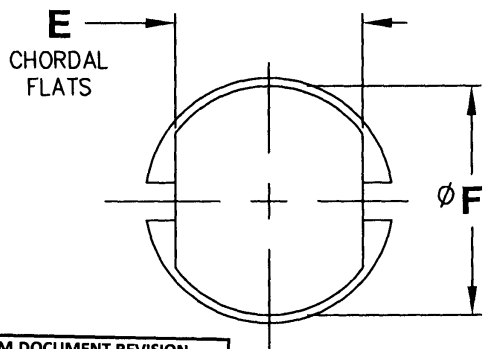
THREADED ONLY

CRIMP LOCK
(CARBON STEEL AND CRES ONLY)

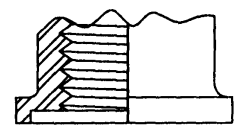
NON-METALLIC LOCK
(ALUMINUM ONLY)



OPTIONAL SLOT:
55° MIN
DETAIL "M"
CONFIGURATION WITHIN THIS AREA
(MANUFACTURER'S OPTION)



OPTIONAL BASE CONFIGURATION



DETAIL "N"
SHIM TO PROVIDE MAX. THREADS ON SHORT LENGTH INSERT

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SCANNED

APPROVED DATE 4-30-80	CURRENT DESIGN ACTIVITY: ARCONIC Arconic Fastening Systems	TITLE: INSERT, MOLDED-IN, BLIND THREAD, SELF & NON SELF-LOCKING, LIGHTWEIGHT (INCH AND METRIC)	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
REV. LETTER AND DATE H 06/23/2011	Rosan Products 3018 W. Lamita Blvd. Torrance, California 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	PROJECT NO: SALES DRAWING NO.
DAF NUMBER 97263 SAB		ANGLES = ±2° DECIMALS .XX = ±0.02 .XXX = ±0.010	D1836 SERIES SHEET 1 OF 4

TABLE I

FIRST DASH NO.	THREAD <3>	ØA + .000 - .010 +(0,00) -(0,25)	ØB	C	E	ØF MAX	H MIN <2>	J BASIC	K MIN	L MIN <13>
04	.1120-40UNJC-3B	.451	.250	.12	.260	.45	.187	.358	.251	.217
M2	M2x0.4-4H6H	(11,46)	(6,35)	(3,0)	(6,60)	(11,4)	(4,75)	(9,09)	(6,38)	(5,54)
06	.1380-32 UNJC-3B	.451	.250	.12	.260	.45	.187	.358	.251	.217
M3	M3x0.5-4H6H	(11,46)	(6,35)	(3,0)	(6,60)	(11,4)	(4,75)	(9,09)	(6,38)	(5,54)
08	.1640-32 UNJC-3B	.451	.250	.12	.260	.45	.187	.358	.251	.217
M4	M4x0.7-4H6H	(11,46)	(6,35)	(3,0)	(6,60)	(11,4)	(4,75)	(9,09)	(6,38)	(5,54)
3	.1900-32 UNJF-3B	.451	.250	.12	.260	.45	.187	.358	.251	.217
M5	M5x0.8-4H6H	(11,46)	(6,35)	(3,0)	(6,60)	(11,4)	(4,75)	(9,09)	(6,38)	(5,54)
4	.2500-28 UNJF-3B	.498	.300	.14	.312	.49	.250	.405	.298	.279
M6	M6x1-4H6H	(12,65)	(7,62)	(3,6)	(7,92)	(12,4)	(6,35)	(10,29)	(7,09)	(7,14)



TABLE II

MATERIAL CODE	MATERIAL	FINISH
A	ALUMINUM ALLOY 2024-T4 OR T351 PER AMS-QQ-A-225/6	ANODIZE PER AMS-A-8625, TYPE I
C	CORROSION RESISTANT STEEL 303 PER ASTM A582/A582M	PASSIVATE PER AMS 2700, TYPE 2
(-)	CARBON STEEL PER ASTM A108, ASTM A576 OR MATERIAL COMPOSITION PER AIR 4127	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

TABLE III

FINISH CODE	OPTIONAL FINISH
M	SOLID FILM LUBE PER AS5272, TYPE I, INTERNAL THREADS ONLY
P	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 (CRES ONLY)
S	SILVER PLATE PER AMS 2410 OR AMS 2411 (CRES ONLY)

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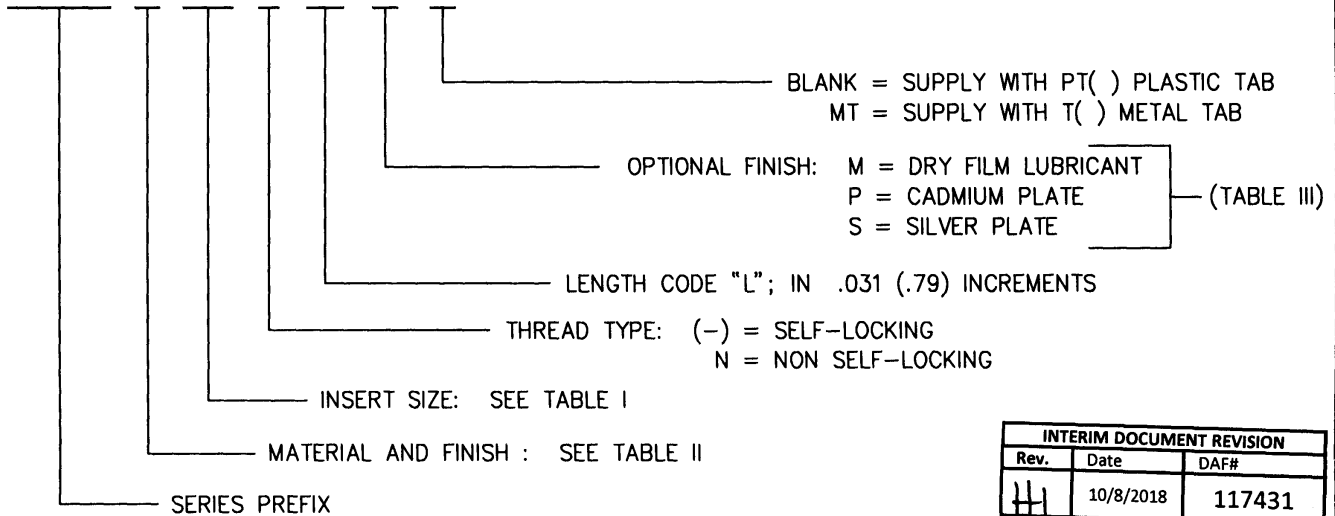
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NOTES:


1. PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.
- <2> THREADS: MINIMUM THREAD "H" IN SHORT LENGTHS. WHERE LENGTH PERMITS SHALL BE 2 X DIAMETER.
- <3> INCH THREAD PER AS8879. METRIC THREAD PER LN9163 OR FED-STD-H28.
- <4> SHANK DEFORMED TO PROVIDE THREAD LOCK FOR CARBON STEEL AND CRES PARTS.
- <5> LOCATE LOCKING PELLET NO CLOSER THAN 10' FROM EDGE OF EITHER POTTING SLOT.
- <6> LOCKING TORQUE: INCH THREAD PER NASM25027 EXCEPT SELFLOCKING CRES INSERT WITHOUT PLATING OR LUBRICANT WILL BE TESTED USING A SILVER PLATED BOLT OR SCREW. METRIC THREAD PER NAO009.
- <7> BURRS CAUSED BY MACHINING POTTING SLOTS PERMISSIBLE UNDER FLANGE.
8. SELECT A LENGTH WHICH ALLOWS A MINIMUM OF .040 CLEARANCE BETWEEN BOTTOM OF INSERT AND INSIDE SURFACE OF BOTTOM SKIN.
9. FOR MINIMUM THREAD LENGTH, SEE TABLE 1 ON SHEET 2.
10. MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
11. MAXIMUM BOLT ENGAGEMENT SHOULD NOT EXCEED "L" MINUS .060 (1,5).
12. AN ADHESIVE BACKED INSTALLATION TAB (ALUMINUM OR PLASTIC) SHALL BE FURNISHED WITH EACH INSERT. NOTE: WHEN TAB MATERIAL PREFERENCE IS DESIRED, PROCURING ACTIVITY SHALL SPECIFY (SEE PART NUMBER EXAMPLE IN NOTE 17).
- <13> MINIMUM LENGTH WHICH MAY BE SPECIFIED
14. ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUN OUT TO DATUM
15. DIMENSIONAL LIMITS APPLY AFTER PLATING, AND PRIOR TO SOLID FILM LUBE.
- <16> EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375 .
- <17> PART NUMBER EXAMPLE:

D1836 - 3 - 07 M

D1836 - M5 - 07 P



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INSTALLATION DATA

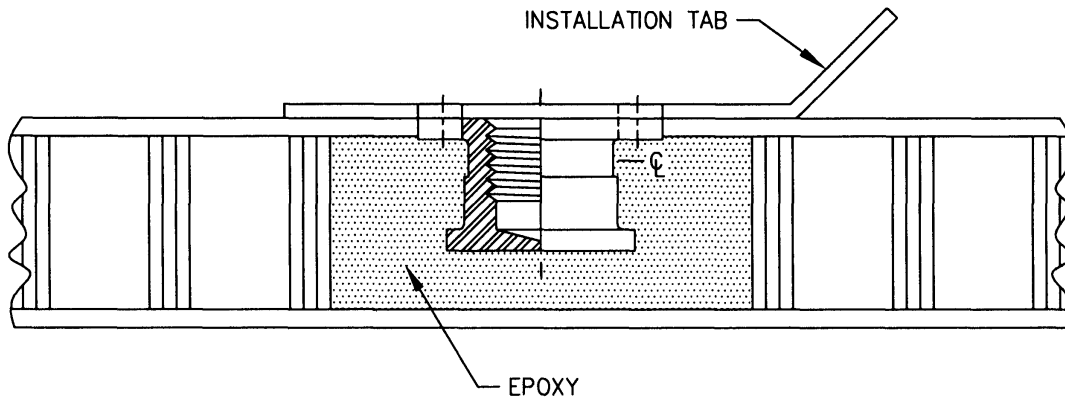



TABLE IV

INSTALLATION DATA		
FIRST DASH NO.	INSTALLATION HOLE SIZE	INSTALLATION TAB
04/M2	.452-.457 (11,48-11,61)	PT2 OR T2
06/M3		
08/M4		
3/M5		
4/M6	.499-.504 (12,67-12,80)	PT4 OR T4

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