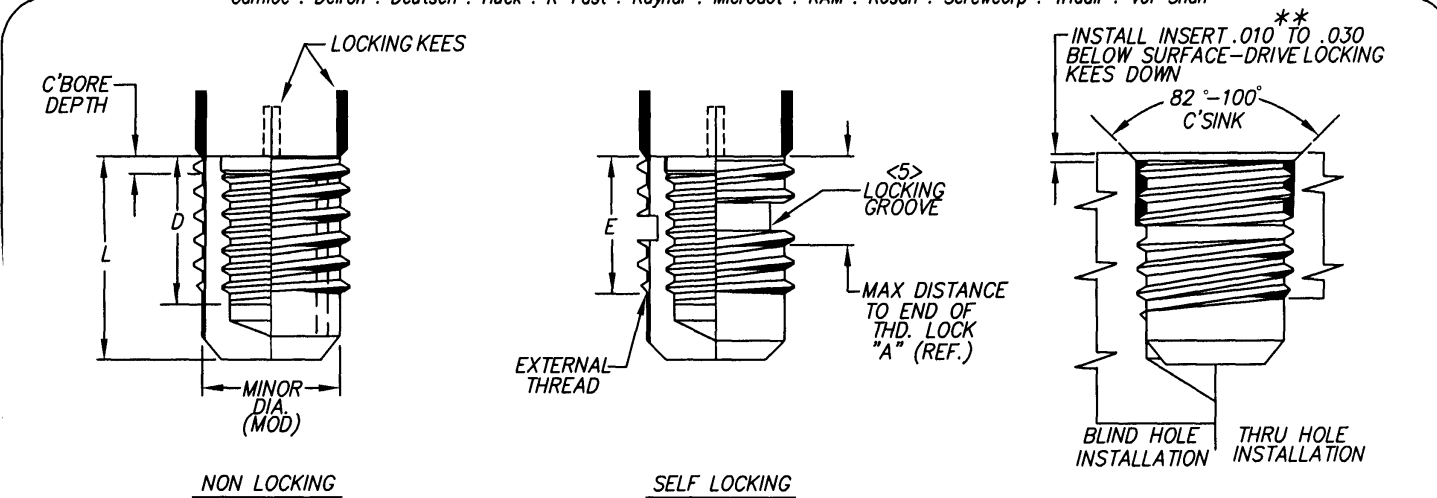


Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi-Shan

MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE
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PART No. <3>		DIMENSIONS								INSTALLATION DATA						REMOVAL DATA	
		INTERNAL THREAD CLASS 3B	EXTERNAL (MOD) THREAD		L	"D"INT. THD. DEPTH MIN.	"E" EXT. THD. LGTH.	C'BORE DEPTH	A (REF)	TAP DRILL DIA.	C'SINK DIA. +.010 -.000	THREAD TAP		INSTALLATION TOOL PART NUMBER	DRILL		
			SIZE CLASS 2A	SHEAR ENGAG.								SIZE CLASS 2B	MIN. DEPTH.		SIZE	DEPTH	
MINIATURE	KNCB(L)0256J	2-56	* 8-32	^{.0418} (.0181)	.24	.13	.18	C'SINK	.10	.134	.166	8-32	.24	TKNC 02	.113	.062	
	KNCB(L)0440J	4-40	* 10-32	^{.0634} (.0342)	.31	.17	.22	C'SINK	.12	.161	.194	10-32	.28	TKNC 04	.136	.093	
	KNCB(L)0632J	6-32	* 12-28	^{.0736} (.0376)	.39	.21	.22	C'SINK	.12	.187	.220	12-28	.28	TKNC 06	.159		
	KNCB(L)0832J	8-32	.250-28	^{.1002} (.0537)	.43	.25	.24	C'SINK	.13	.228	.255	.250-28	.30	TKNC 08	.199		
LIGHTWEIGHT	KNB(L)1032J	10-32	.3125-18	^{.1517} (.0945)	.50	.31	.31	.07	^{.31}	.272	.323	.3125-18	.37	TD 1032L	.218	.156	
	KNB(L)1024J	10-24		^{.31}							TD 1024L						
	KNB(L)428J	.250-28	.375-16	^{.2371} (.1726)	.62	.37	.37	.07	^{.33} _{.36}	.332	.385	.375-16	.43	TD 428L	.281	.187	
	KNB(L)420J	.250-20		^{.3049} (.2321)	.75	.43	.43	.07	^{.34} _{.37}	.397	.447	.4375-14	.50	TD 420L			
	KNB(L)524J	.3125-24	.4375-14	^{.4299} (.3366)	.81	.50	.50	.07	^{.36} _{.40}	.453	.510	.500-13	.56	TD 524L	.343		
	KNB(L)518J	.3125-18												^{.375-24} (.2321)			
	KNB(L)624J	.375-24	.500-13	^{.4299} (.3366)	.81	.50	.50	.07	^{.36} _{.40}	.453	.510	.500-13	.56	TD 624L	.406		
	KNB(L)616J	.375-16												^{.4299} (.3366)			
	KNB(L)720J	.4375-20	.5625-12	^{.5665} (.4606)	.87	.56	.56	.07	^{.41} _{.45}	.516	.572	.5625-12	.62	TD 720L	.468		
	KNB(L)714J	.4375-14		^{.5665} (.4606)						TD 714L							
	KNB(L)820J	.500-20	.625-11	^{.7172} (.5831)	1.06	.62	.62	.07	^{.42} _{.47}	.578	.635	.625-11	.68	TD 820L	.531		
	KNB(L)813J	.500-13		^{.7172} (.5831)						TD 813L							
HEAVY DUTY	KNHB(L)0832J	8-32	.3125-18	^{.1517} (.0945)	.50	.31	.31	.04	.31	.272	.323	.3125-18	.37	THD 0832L	.218	.125	
	KNHB(L)1032J	10-32	.375-16	^{.1901} (.1156)	.56	.31	.31	.07	^{.31}	.332	.385	.375-16	.37	THD 1032L	.281		
	KNHB(L)1024J	10-24		^{.31}							THD 1024L						
	KNHB(L)428J	.250-28	.4375-14	^{.2842} (.1970)	.62	.37	.37	.07	^{.33} _{.36}	.397	.447	.4375-14	.43	THD 428L	.343	.187	
	KNHB(L)420J	.250-20		^{.3588} (.2608)	.75	.43	.43	.07	^{.34} _{.37}	.453	.510	.500-13	.50	THD 420L	.406		
	KNHB(L)524J	.3125-24	.500-13	^{.4975} (.3843)	.81	.50	.50	.07	^{.37} _{.41}	.516	.572	.5625-12	.56	THD 524L			
	KNHB(L)518J	.3125-18												^{.3588} (.2608)			
	KNHB(L)624J	.375-24	.5625-12	^{.4975} (.3843)	.81	.50	.50	.07	^{.37} _{.41}	.516	.572	.5625-12	.56	THD 624L	.468		
	KNHB(L)616J	.375-16		^{.4975} (.3843)						THD 616L							
	KNHB(L)720J	.4375-20	.625-11	^{.7172} (.5831)	1.00	.62	.62	.10	^{.42} _{.46}	.578	.635	.625-11	.68	THD 720L	.531		
	KNHB(L)714J	.4375-14		^{.7172} (.5831)						THD 714L							
	KNHB(L)820J	.500-20	.6875-11	^{.8884} (.7368)	1.06	.68	.68	.10	^{.42} _{.47}	.641	.700	.6875-11	.75	THD 820L	.593		
	KNHB(L)813J	.500-13		NS						THD 813L							
	KNHB(L)918J	.5625-18	.8125-16	^{1.2493} (1.0247)	1.25	.81	.81	.10	^{.48} _{.54}	.766	.822	.8125-16	.94	THD 918L	.718		
	KNHB(L)912J	.5625-12		^{1.2493} (1.0247)						THD 912L							
	KNHB(L)1018J	.625-18	.875-14	^{1.4866} (1.2415)	1.31	.87	.87	.10	^{.49} _{.57}	.828	.885	.875-14	1.00	THD 1018L	.781		
	KNHB(L)1011J	.625-11		^{1.4866} (1.2415)						THD 1011L							
	KNHB(L)1216J	.750-16	1-.125-12	^{2.7905} (2.4478)	1.75	1.25	1.25	.10	^{.68} _{.75}	1.062	1.145	1-.125-12	1.44	THD 1216L	.968		
	KNHB(L)1210J	.750-10		^{2.7905} (2.4478)						THD 1210L							
	KNHB(L)1414J	.875-14	1-.250-12	^{3.4747} (3.0775)	1.94	1.37	1.37	.10	^{.69} _{.77}	1.187	1.270	1-.250-12	1.56	THD 1414L	1-.093		
	KNHB(L)1409J	.875-9		^{3.4747} (3.0775)						THD 1409L							
	KNHB(L)1612J	1-12	1-.375-12	^{4.2282} (3.7929)	2.12	1.50	1.50	.10	^{.78} _{.86}	1.312	1.395	1-.375-12	1.68	THD 1612L	1-.218		
	KNHB(L)1608J	1-8		^{4.2282} (3.7929)						THD 1608L							

* STANDARD CLASS 2A EXTERNAL THREADS, NO MODIFIED MINOR DIAMETER.
** .005 TO .015 FOR MINIATURES.

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
NR1	10/8/2018	117431

APPROVED DATE 10/19/2011	CURRENT DESIGN ACTIVITY: ARCONIC Arconic Fastening Systems	TITLE: KEENSERT INSERT, BLIND END	IGN ACTIVITY: PAGE CODE: 29372
REV. LETTER AND DATE NR 10/19/2011	Tridair Products 3000 W. Lomita Blvd. Torrance, California 90505	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO. KNB SERIES
DAF NUMBER 98602		ANGLES DECIMALS = ±3° .XX = ±.02 .XXX = ±.010	SHEET 1 OF 2

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NOTES:

1 MATERIAL CODES:

1.1 STANDARD MATERIAL IS 303 CRES PER AMS 5640 OR ASTM-A-582, OR 303SE PER AMS 5640,AMS 5738 OR ASTM-A-582.

1.2 OPTIONAL MATERIALS WITH THEIR DESIGNATED FINISH:

F= C1215 CARBON STEEL OR EQUIVALENT, COATED WITH PARKERIZE.

M= CHROME MOLY STEEL, TYPE 4140 PER AMS 6382 OR TYPE 8740 PER AMS 6322, 125 KSI MINIMUM TENSILE STRENGTH, IDENTIFIED BY TWO NON-PARALLEL DASH MARKS ON TOP OF INSERT. CAD PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

MX=CHROME MOLY STEEL, TYPE 4140 PER AMS 6382 OR TYPE 8740 PER AMS 6322, 160 KSI MINIMUM TENSILE STRENGTH. IDENTIFIED BY TWO PARALLEL DASH MARKS ON TOP OF INSERT. CAD PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

NIT=ARMCO, NITRONIC 60 CRES PER ASTM-A-479 OR AMS 5848, PASSIVATE PER AMS 2700. IDENTIFIED BY FOUR (4) DASH MARKS APPROXIMATELY 90° APART.

T= A286 CRES PER AMS 5731, AMS 5732 OR AMS 5737. 140 KSI MINIMUM TENSILE STRENGTH, IDENTIFIED BY ONE DASH MARK ON TOP OF INSERT. PASSIVATE PER AMS 2700.

TX= A286 CRES PER AMS 5731, 160 KSI MINIMUM TENSILE STRENGTH. IDENTIFIED BY LETTER "H" ON TOP OF INSERT. PASSIVATE PER AMS 2700.

1.3 KEE MATERIAL FOR ALL STANDARD AND SPECIAL MATERIAL INSERTS IS 302 CRES PER ASTM-A-580 (CHEMISTRY ONLY).

2. FINISH CODES:

NO CODE: PASSIVATE PER AMS 2700.

SP=SILVER PLATE PER ASTM-B-700, TYPE I, GRADE A, CLASS N.

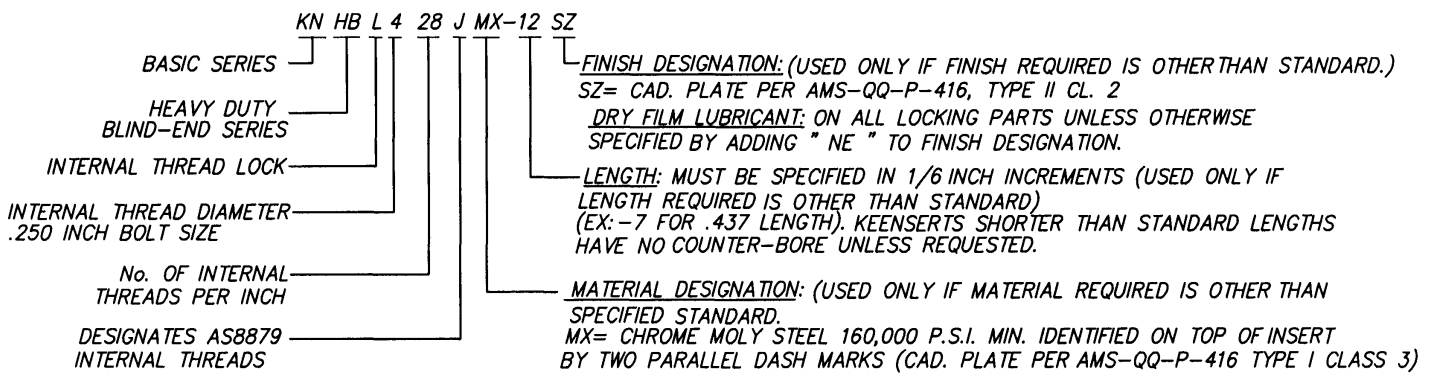
SX=CAD. PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3

SY=CAD. PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3

SZ=CAD. PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2

DRY FILM LUBRICANT ON ALL LOCKING INSERTS UNLESS SPECIFIED BY ADDING "NE" TO FINISH CODE.

<3> PART NUMBER EXAMPLE:



4. INSERTS WITH INTERNAL THREAD SIZE .2500 AND UNDER ARE FURNISHED WITH TWO (2) LOCKING KEES. SIZE .3125 AND ABOVE ARE FURNISHED WITH FOUR (4) LOCKING KEES.

<5> INTERNAL THREAD LOCK PERFORMANCE IS PER MIL-I-45914 SPECIFICATION.

6. ALL DIMENSIONS APPLY AFTER PLATING BUT PRIOR TO LUBRICATION.
7. FOR ADDITIONAL CODES REFER TO S-70248.
8. INSTALLATION PROCEDURE:
- 8.1 PREPARE PANEL PER DIMENSIONS IN TABLE.
- 8.2 SCREW IN INSERT WITH FINGERS OR INSTALLATION TOOL. INSERT IS DESIGNED TO STOP AT CORRECT DEPTH.
- 8.3 DRIVE LOCKING KEES DOWN USING THE INSTALLATION TOOL.
9. REMOVAL PROCEDURE:
- 9.1 USE DRILL SIZE AND DEPTH SPECIFIED IN TABLE TO REMOVE MATERIAL BETWEEN LOCKING KEES.
- 9.2 DEFLECT LOCKING KEES INWARD AND BREAK OFF.
- 9.3 REMOVE INSERT WITH AN "EASY-OUT" TYPE TOOL.

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
NR1	10/8/2018	117431

APPROVED DATE 10/19/2011	 ARCONIC Arconic Fastening Systems Tridair Products 3000 W. Lomita Blvd. Torrance, California 90505	TITLE: KEENSERT INSERT, BLIND END	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372
REV. LETTER AND DATE N/R 10/19/2011			SALES DRAWING NO.
DAF NUMBER 98602			KNB SERIES

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

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

SHEET 2 OF 2