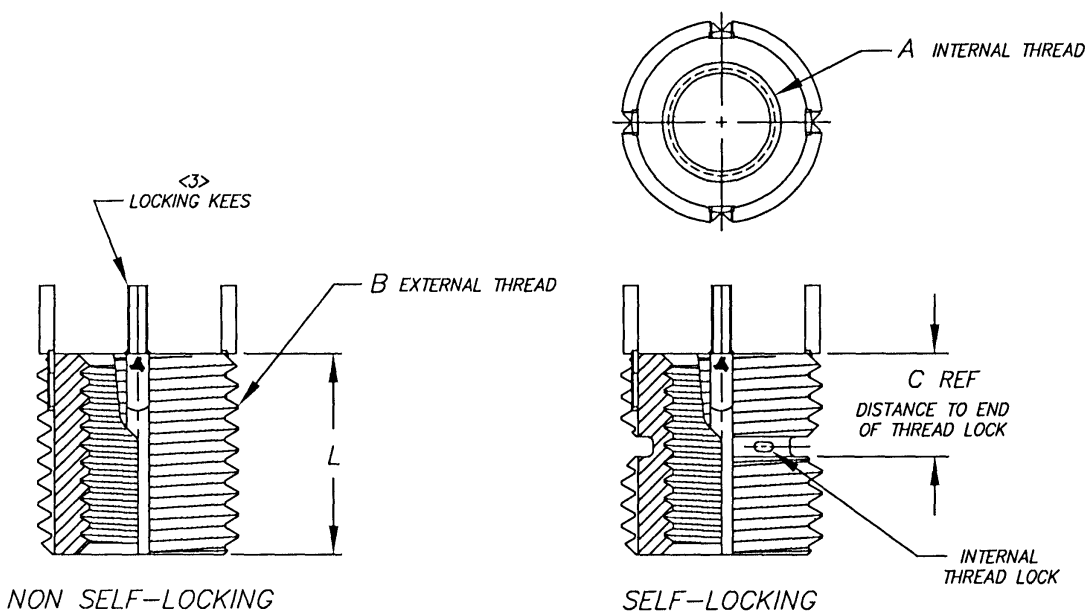


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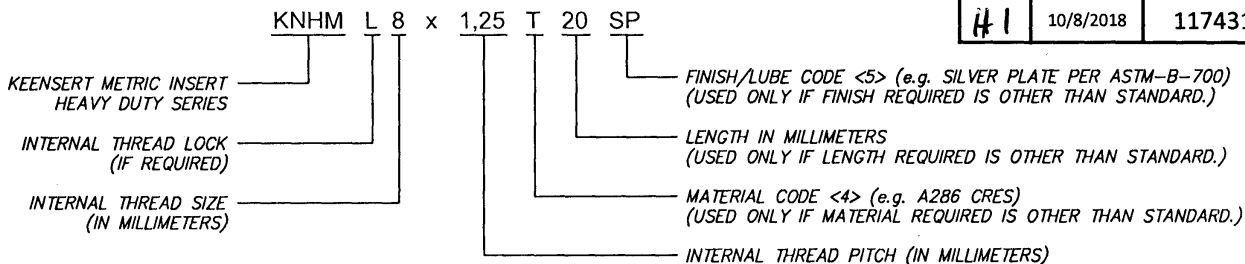
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NOTES:

1. ALL DIMENSIONS ARE IN MILLIMETERS.
- <2> THREADS ARE PER BRITISH STANDARD 3643. (I.S.O.)
- <3> INSERTS WITH INTERNAL THREAD SIZE 6 AND UNDER ARE FURNISHED WITH 2 LOCKING KEES. SIZE 7 AND ABOVE SIZES ARE FURNISHED WITH 4 LOCKING KEES.
- <4> MATERIAL CODES:
  - 4.1 STANDARD MATERIAL IS 303 CRES PER AMS 5640 OR ASTM A582, OR 303SE PER AMS 5640, AMS 5738 OR ASTM A582.
  - 4.2 OPTIONAL MATERIALS WITH THEIR DESIGNATED FINISH:
    - M = CHROME MOLY STEEL, TYPE 4140 PER AMS 5626 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 5626 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 = ARMC0, NITRONIC 60 CRES PER ASTM A479 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, AMS 5732 OR AMS 5737. 160 KSI MINIMUM TENSILE STRENGTH. IDENTIFIED BY LETTER "H" ON TOP OF INSERT. PASSIVATE PER AMS 2700.
    - TA = 6AI-4V TITANIUM ALLOY PER AMS 4928, AMS 4930 OR AMS 4967; OR 3AI-2.5V TITANIUM ALLOY PER AMS 4943 (MIL-T-9047) 100 KSI MINIMUM TENSILE.
    - TB = 6AI-4V TITANIUM ALLOY PER AMS 4930 OR AMS 4967. 160 KSI MINIMUM TENSILE STRENGTH. THIS MATERIAL CODE IS ONLY AVAILABLE FOR NON-LOCKING PARTS.
    - F = CARBON STEEL PER ASTM A108, PARKERIZE.
  - 4.3 KEE MATERIAL FOR ALL STANDARD AND SPECIAL MATERIAL INSERTS IS 302 CRES PER ASTM A580 (CHEMISTRY ONLY). CONTACT AFS ENGINEERING FOR OPTIONAL MATERIALS.
  - <5> FINISH CODES:
    - NO CODE= PASSIVATE PER AMS 2700.
    - SP = SILVER PLATE PER ASTM B700, TYPE 1, 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.

6. PART NUMBER EXAMPLE: KNHML8x1,25T20SP



| INTERIM DOCUMENT REVISION |           |        |
|---------------------------|-----------|--------|
| Rev.                      | Date      | DAF#   |
| #1                        | 10/8/2018 | 117431 |

|   |   |   |  |
|---|---|---|--|
| APPROVED DATE<br>10/23/03                         | CURRENT DESIGN ACTIVITY:<br><b>ARCONIC</b><br>Arconic Fastening Systems       | TITLE:<br>KEENSERT INSERT,<br>HEAVY DUTY, METRIC<br><br>03-066                      | CURRENT DESIGN ACTIVITY:<br>CAGE CODE: 29372 |
| REV. LETTER AND DATE<br><del>11</del> 16/11/12 CA | <b>Tridair Products</b><br>3000 W. Lomita Blvd.<br>Torrance, California 90505 | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES &<br>ASME Y14.5M TOLERANCES: | SALES DRAWING NO.                            |
| DAF NUMBER<br><del>102343</del>                   |   | ANGLES = ±J'<br>DECIMALS .XX = ±.02<br>.XXX = ±.010                                 | KNHM (L)                                     |
|   |   |   | SHEET 1 OF 5                                 |


TABLE 1

| PART NUMBER  | DIMENSIONS                              |   |   |            |          |
|--------------|---|---|---|------------|----------|
|              | A<br>INTERNAL<br>THREAD <2><br>CLASS 5H | B<br>EXTERNAL<br>THREAD <2><br>CLASS 4h | MIN.<br>SHEAR<br>ENGAG.<br>AREA mm <sup>2</sup> | L<br>± 0,3 | C<br>REF |
| KNHM4x0,7    | M4x0,7                                  | M8x1,25                                 | 104,9   | 8,0        | 8,0      |
| KNHML4x0,7   |   |   | 83,1  |            |          |
| KNHM5x0,8    | M5x0,8                                  | M10x1,25                                | 177,7   | 10,0       | 8,7      |
| KNHML5x0,8   |   |   | 152,7   |            |          |
| KNHM6x1,0    | M6x1,0                                  | M12x1,25                                | 266,7   | 12,0       | 9,5      |
| KNHML6x1,0   |   |   | 242,5   |            |          |
| KNHM7x1,0    | M7x1,0                                  | M12x1,25                                | 266,7   | 12,0       | 9,5      |
| KNHML7x1,0   |   |   | 242,5   |            |          |
| KNHM8x1,0    | M8x1,0                                  | M14x1,5                                 | 341,6   | 14,0       | 10,0     |
| KNHML8x1,0   |   |   | 316,4   |            |          |
| KNHM8x1,25   | M8x1,25                                 | M14x1,5                                 | 341,6   | 14,0       | 10,0     |
| KNHML8x1,25  |   |   | 316,4   |            |          |
| KNHM10x1,25  | M10x1,25                                | M16x1,5                                 | 470,2   | 16,0       | 10,0     |
| KNHML10x1,25 |   |   | 441,4   |            |          |
| KNHM10x1,5   | M10x1,5                                 | M16x1,5                                 | 470,2   | 16,0       | 10,0     |
| KNHML10x1,5  |   |   | 441,4   |            |          |
| KNHM12x1,25  | M12x1,25                                | M18x1,5                                 | 608,5   | 18,0       | 10,7     |
| KNHML12x1,25 |   |   | 561,8   |            |          |
| KNHM12x1,5   | M12x1,5                                 | M18x1,5                                 | 608,5   | 18,0       | 10,7     |
| KNHML12x1,5  |   |   | 561,8   |            |          |
| KNHM12x1,75  | M12x1,75                                | M18x1,5                                 | 608,5   | 18,0       | 10,7     |
| KNHML12x1,75 |   |   | 561,8   |            |          |
| KNHM14x1,5   | M14x1,5                                 | M20x1,5                                 | 770,5   | 20,0       | 12,4     |
| KNHML14x1,5  |   |   | 724,4   |            |          |
| KNHM14x2,0   | M14x2,0                                 | M20x1,5                                 | 770,5   | 20,0       | 12,4     |
| KNHML14x2,0  |   |   | 724,4   |            |          |
| KNHM16x1,5   | M16x1,5                                 | M22x1,5                                 | 896,8   | 22,0       | 12,4     |
| KNHML16x1,5  |   |   | 855,2   |            |          |
| KNHM16x2,0   | M16x2,0                                 | M22x1,5                                 | 896,8   | 22,0       | 12,4     |
| KNHML16x2,0  |   |   | 855,2   |            |          |
| KNHM18x1,5   | M18x1,5                                 | M24x1,5                                 | 1084,4  | 24,0       | 16,8     |
| KNHML18x1,5  |   |   | 1051,5  |            |          |
| KNHM18x2,0   | M18x2,0                                 | M24x1,5                                 | 1084,4  | 24,0       | 16,8     |
| KNHML18x2,0  |   |   | 1051,5  |            |          |
| KNHM18x2,5   | M18x2,5                                 | M24x1,5                                 | 1084,4  | 24,0       | 16,8     |
| KNHML18x2,5  |   |   | 1051,5  |            |          |
| KNHM20x1,5   | M20x1,5                                 | M30x2,0                                 | 1774,3  | 30,0       | 17,5     |
| KNHML20x1,5  |   |   | 1736,4  |            |          |
| KNHM20x2,0   | M20x2,0                                 | M30x2,0                                 | 1774,3  | 30,0       | 17,5     |
| KNHML20x2,0  |   |   | 1736,4  |            |          |
| KNHM20x2,5   | M20x2,5                                 | M30x2,0                                 | 1774,3  | 30,0       | 17,5     |
| KNHML20x2,5  |   |   | 1736,4  |            |          |
| KNHM22x1,5   | M22x1,5                                 | M32x2,0                                 | 2045,9  | 32,0       | 18,3     |
| KNHML22x1,5  |   |   | 2014,7  |            |          |
| KNHM22x2,0   | M22x2,0                                 | M32x2,0                                 | 2045,9  | 32,0       | 18,3     |
| KNHML22x2,0  |   |   | 2014,7  |            |          |
| KNHM24x2,0   | M24x2,0                                 | M33x2,0                                 | 2189,4  | 33,0       | 19,0     |
| KNHML24x2,0  |   |   | 2161,9  |            |          |

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| INTERIM DOCUMENT REVISION |           |        |
|---------------------------|-----------|--------|
| Rev.                      | Date      | DAF#   |
| 41                        | 10/8/2018 | 117431 |

|                                      |  |   |  |
|--------------------------------------|--|---|--|
| APPROVED DATE<br>10/23/03            |  <b>ARCONIC</b><br>Arconic Fastening Systems<br><b>Tridair Products</b><br>3000 W. Lomita Blvd.<br>Torrance, California 90505 | TITLE:<br>KEENSERT INSERT,<br>HEAVY DUTY, METRIC<br><br>03-066                      | CURRENT DESIGN ACTIVITY:<br>CAGE CODE: 29372 |
| REV. LETTER AND DATE<br>H 10/11/12SA |  | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES &<br>ASME Y14.5M TOLERANCES: | SALES DRAWING NO.                            |
| DAF NUMBER<br>102343                 |  | ANGLES = ±3°<br>DECIMALS .XX = ±.02<br>.XXX = ±.010                                 | KNHM (L)<br><br>SHEET 2 OF 5                 |

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TABLE I (CONTINUED)

| PART NUMBER | DIMENSIONS                              |   |   |            |          |
|-------------|---|---|---|------------|----------|
|             | A<br>INTERNAL<br>THREAD <2><br>CLASS 5H | B<br>EXTERNAL<br>THREAD <2><br>CLASS 4h | MIN,<br>SHEAR<br>ENGAG,<br>AREA mm <sup>2</sup> | L<br>± 0,3 | C<br>REF |
| KNHM24x3,0  | M24x3,0                                 | M33x2,0                                 | 2189,4  | 33,0       | 19,0     |
| KNHML24x3,0 |   |   | 2161,9  |            |          |
| KNHM26x1,5  | M26x1,5                                 | M36x2,0                                 | 2733,6  | 36,0       | 20,9     |
| KNHML26x1,5 |   |   | 2553,3  |            |          |
| KNHM30x1,5  | M30x1,5                                 | M39x2,0                                 | 3243,9  | 39,0       | 22,6     |
| KNHML30x1,5 |   |   | 3025,4  |            |          |
| KNHM30x3,5  | M30x3,5                                 | M39x2,0                                 | 3243,9  | 39,0       | 22,6     |
| KNHML30x3,5 |   |   | 3025,4  |            |          |
| KNHM36x4,0  | M36x4,0                                 | M45x2,0                                 | T B D   | 45,0       | 24,3     |
| KNHML36x4,0 |   |   | T B D   |            |          |

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


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|--|--|---|--|
| APPROVED DATE<br>10/23/03                        |  <b>ARCONIC</b><br>Arconic Fastening Systems<br><b>Tridair Products</b><br>3000 W. Lomita Blvd.<br>Torrance, California 90505 | TITLE:<br>KEENSERT INSERT,<br>HEAVY DUTY, METRIC<br>03-066<br>UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES &<br>ASME Y14.5M TOLERANCES: | CURRENT DESIGN ACTIVITY:<br>CAGE CODE: 29372 |
| REV. LETTER AND DATE<br><del>H</del> 10/11/12 CA |  |   | SALES DRAWING NO.                            |
| DAF NUMBER<br>102343                             |  |   | KNHM (L)<br>SHEET 3 OF 5                     |

TABLE II

| PART NUMBER  | INSTALLATION DATA |            |               |            | REMOVAL DATA                  |       |       |
|--------------|-------------------|------------|---------------|------------|-------------------------------|-------|-------|
|              | TAP DRILL DIA     | C'SINK DIA | THREAD TAP    |            | INSTALLATION TOOL PART NUMBER | DRILL |       |
|              |                   |            | SIZE CLASS 6H | MIN. DEPTH |                               | SIZE  | DEPTH |
| KNHM4x0,7    | 7,000             | 8,50       | M8x1,25       | 9,5        | THM-4                         | 5,50  | 4,00  |
| KNHML4x0,7   | 6,875             | 8,25       |               |            |                               |       |       |
| KNHM5x0,8    | 8,900             | 10,50      | M10x1,25      | 12,5       | THM-5                         | 7,50  | 4,75  |
| KNHML5x0,8   | 8,775             | 10,25      |               |            |                               |       |       |
| KNHM6x1,0    | 10,900            | 12,50      | M12x1,25      | 14,5       | THM-6                         | 9,50  | 4,75  |
| KNHML6x1,0   | 10,775            | 12,25      |               |            |                               |       |       |
| KNHM7x1,0    | 10,900            | 12,50      | M12x1,25      | 14,5       | TRKHM-6                       | 9,50  | 4,75  |
| KNHML7x1,0   | 10,775            | 12,25      |               |            |                               |       |       |
| KNHM8x1,0    | 12,930            | 14,50      | M14x1,5       | 16,5       | THM-8                         | 11,50 | 4,75  |
| KNHML8x1,0   | 12,775            | 14,25      |               |            |                               |       |       |
| KNHM8x1,25   | 12,930            | 14,50      | M14x1,5       | 16,5       | THM-8                         | 11,50 | 4,75  |
| KNHML8x1,25  | 12,775            | 14,25      |               |            |                               |       |       |
| KNHM10x1,25  | 14,880            | 16,50      | M16x1,5       | 18,5       | THM-10                        | 13,50 | 4,75  |
| KNHML10x1,25 | 14,725            | 16,25      |               |            |                               |       |       |
| KNHM10x1,5   | 14,880            | 16,50      | M16x1,5       | 18,5       | THM-10                        | 13,50 | 4,75  |
| KNHML10x1,5  | 14,725            | 16,25      |               |            |                               |       |       |
| KNHM12x1,25  | 16,880            | 18,50      | M18x1,5       | 20,5       | THM-12                        | 15,50 | 4,75  |
| KNHML12x1,25 | 16,725            | 18,25      |               |            |                               |       |       |
| KNHM12x1,5   | 16,880            | 18,50      | M18x1,5       | 20,5       | THM-12                        | 15,50 | 4,75  |
| KNHML12x1,5  | 16,725            | 18,25      |               |            |                               |       |       |
| KNHM12x1,75  | 16,880            | 18,50      | M18x1,5       | 20,5       | THM-12                        | 15,50 | 4,75  |
| KNHML12x1,75 | 16,725            | 18,25      |               |            |                               |       |       |
| KNHM14x1,5   | 18,880            | 20,50      | M20x1,5       | 22,5       | THM-14                        | 17,50 | 4,75  |
| KNHML14x1,5  | 18,725            | 20,25      |               |            |                               |       |       |
| KNHM14x2,0   | 18,880            | 20,50      | M20x1,5       | 22,5       | THM-14                        | 17,50 | 4,75  |
| KNHML14x2,0  | 18,725            | 20,25      |               |            |                               |       |       |
| KNHM16x1,5   | 20,630            | 22,50      | M22x1,5       | 24,5       | THM-16                        | 17,75 | 6,35  |
| KNHML16x1,5  | 20,475            | 22,25      |               |            |                               |       |       |
| KNHM16x2,0   | 20,630            | 22,50      | M22x1,5       | 24,5       | THM-16                        | 17,75 | 6,35  |
| KNHML16x2,0  | 20,475            | 22,25      |               |            |                               |       |       |
| KNHM18x1,5   | 22,630            | 24,50      | M24x1,5       | 26,5       | THM-18                        | 19,75 | 6,35  |
| KNHML18x1,5  | 22,475            | 24,25      |               |            |                               |       |       |
| KNHM18x2,0   | 22,630            | 24,50      | M24x1,5       | 26,5       | THM-18                        | 19,75 | 6,35  |
| KNHML18x2,0  | 22,475            | 24,25      |               |            |                               |       |       |
| KNHM18x2,5   | 22,630            | 24,50      | M24x1,5       | 26,5       | THM-18                        | 19,75 | 6,35  |
| KNHML18x2,5  | 22,475            | 24,25      |               |            |                               |       |       |
| KNHM20x1,5   | 28,130            | 30,50      | M30x2,0       | 34,5       | THM-20                        | 25,75 | 6,35  |
| KNHML20x1,5  | 27,975            | 30,25      |               |            |                               |       |       |
| KNHM20x2,0   | 28,130            | 30,50      | M30x2,0       | 34,5       | THM-20                        | 25,75 | 6,35  |
| KNHML20x2,0  | 27,975            | 30,25      |               |            |                               |       |       |
| KNHM20x2,5   | 28,130            | 30,50      | M30x2,0       | 34,5       | THM-20                        | 25,75 | 6,35  |
| KNHML20x2,5  | 28,975            | 30,25      |               |            |                               |       |       |
| KNHM22x1,5   | 30,130            | 32,50      | M32x2,0       | 36,5       | THM-22                        | 27,75 | 6,35  |
| KNHML22x1,5  | 29,975            | 32,25      |               |            |                               |       |       |
| KNHM22x2,0   | 30,130            | 32,50      | M32x2,0       | 36,5       | THM-22                        | 27,75 | 6,35  |
| KNHML22x2,0  | 29,975            | 32,25      |               |            |                               |       |       |
| KNHM24x2,0   | 31,130            | 33,50      | M33x2,0       | 37,5       | THM-24                        | 28,75 | 6,35  |
| KNHML24x2,0  | 30,975            | 33,25      |               |            |                               |       |       |

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



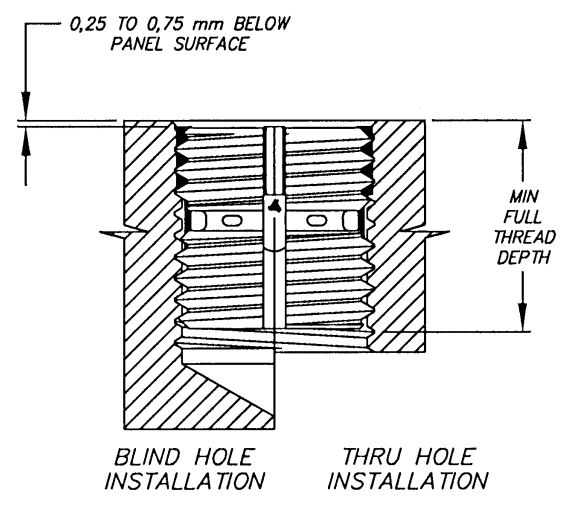
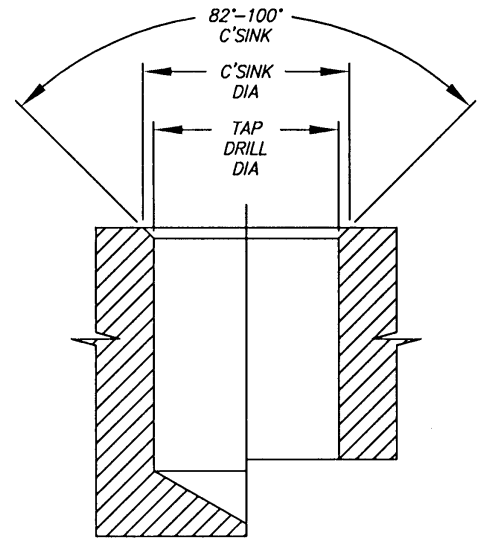
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|--|--|---|---|
| APPROVED DATE<br>10/23/03              | <br><b>ARCONIC</b><br>Arconic Fastening Systems                                   | TITLE:<br>KEENSERT INSERT,<br>HEAVY DUTY, METRIC<br>03-066                          | CURRENT DESIGN ACTIVITY:<br>CAGE CODE: 29372        |
| REV. LETTER AND DATE<br>H1 10/11/12 CA |  |   | SALES DRAWING NO.                                   |
| DAF NUMBER<br>402343                   | <br><b>Tridair Products</b><br>3000 W. Lomita Blvd.<br>Torrance, California 90505 | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES &<br>ASME Y14.5M TOLERANCES: | ANGLES = ±3'<br>DECIMALS .XX = ±.02<br>.XXX = ±.010 |
|  |  |   | KNHM (L)<br>SHEET 4 OF 5                            |

TABLE II (CONTINUED)

| PART NUMBER | INSTALLATION DATA |            |               |            | REMOVAL DATA                  |       |       |
|-------------|-------------------|------------|---------------|------------|-------------------------------|-------|-------|
|             | TAP DRILL DIA     | C'SINK DIA | THREAD TAP    |            | INSTALLATION TOOL PART NUMBER | DRILL |       |
|             |                   |            | SIZE CLASS 6H | MIN. DEPTH |                               | SIZE  | DEPTH |
| KNHM24x3,0  | 31,130            | 33,50      | M33x2,0       | 37,5       | THM-24                        | 28,75 | 6,35  |
| KNHML24x3,0 | 30,975            | 33,25      |               |            |                               |       |       |
| KNHM26x1,5  | 34,130            | 36,50      | M36x2,0       | 40,5       | THM-26                        | 31,75 | 6,35  |
| KNHML26x1,5 | 33,975            | 36,25      |               |            |                               |       |       |
| KNHM30x1,5  | 37,130            | 39,50      | M39x2,0       | 43,5       | THM-30                        | 34,75 | 6,35  |
| KNHML30x1,5 | 36,975            | 39,25      |               |            |                               |       |       |
| KNHM30x3,5  | 37,130            | 39,50      | M39x2,0       | 43,5       | THM-30                        | 34,75 | 6,35  |
| KNHML30x3,5 | 36,975            | 39,25      |               |            |                               |       |       |
| KNHM36x4,0  | 43,130            | 45,50      | M45x2,0       | 49,5       | THM-36                        | 40,75 | 6,35  |
| KNHML36x4,0 | 42,975            | 45,25      |               |            |                               |       |       |



7. INSTALLATION PROCEDURES:
- 7.1 PREPARE PANEL IN ACCORDANCE WITH THE DIMENSIONS SHOWN IN TABLE II.
  - 7.2 SCREW IN INSERT WITH FINGERS OR INSTALLATION TOOL. INSERT IS DESIGNED TO STOP AT CORRECT DEPTH.
  - 7.3 DRIVE LOCKING KEES DOWN USING THE INSTALLATION TOOL.
8. REMOVAL PROCEDURES:
- 8.1 USE THE DRILL SIZES AND DEPTHS SPECIFIED IN TABLE II TO REMOVE MATERIAL BETWEEN THE KEES.
  - 8.2 DEFLECT KEES INWARD AND BREAK OFF.
  - 8.3 REMOVE INSERT WITH AN "EASY OUT" TYPE TOOL.

| INTERIM DOCUMENT REVISION |           |        |
|---------------------------|-----------|--------|
| Rev.                      | Date      | DAF#   |
| 41                        | 10/8/2018 | 117431 |

|                                      |   |   |   |
|--------------------------------------|---|---|---|
| APPROVED DATE<br>10/23/03            | CURRENT DESIGN ACTIVITY:<br><b>ARCONIC</b><br>Arconic Fastening Systems       | TITLE:<br>KEENSERT INSERT,<br>HEAVY DUTY, METRIC<br><br>03-066                      | CURRENT DESIGN ACTIVITY:<br>CAGE CODE: 29372<br>SALES DRAWING NO.<br><br>KNHM (L) |
| REV. LETTER AND DATE<br>H 10/11/12CA | <b>Tridair Products</b><br>3000 W. Lomita Blvd.<br>Torrance, California 90505 | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES &<br>ASME Y14.5M TOLERANCES: |   |
| DAF NUMBER<br>102345                 |   | ANGLES = ±3°<br>DECIMALS .XX = ±.02<br>.XXX = ±.010                                 | SHEET 5 OF 5  |

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

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