

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

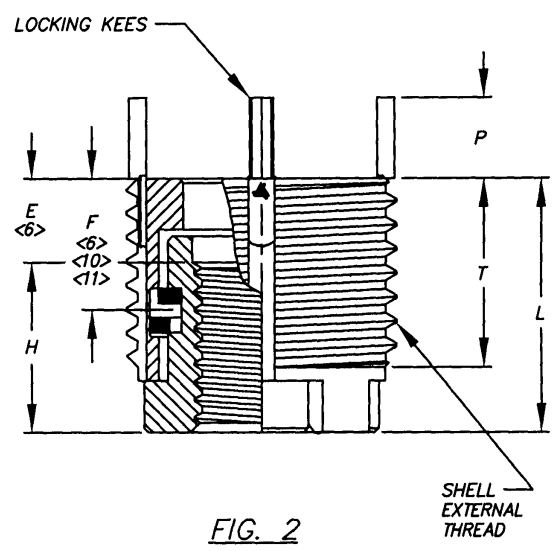
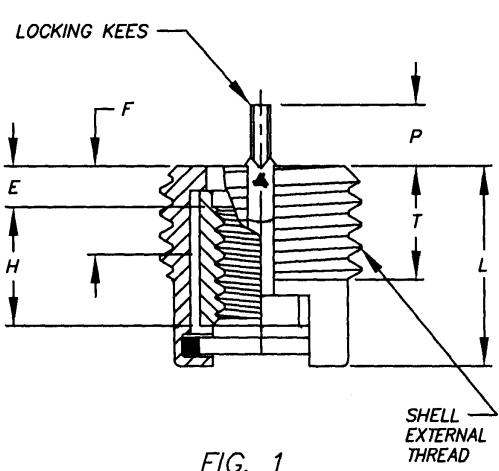
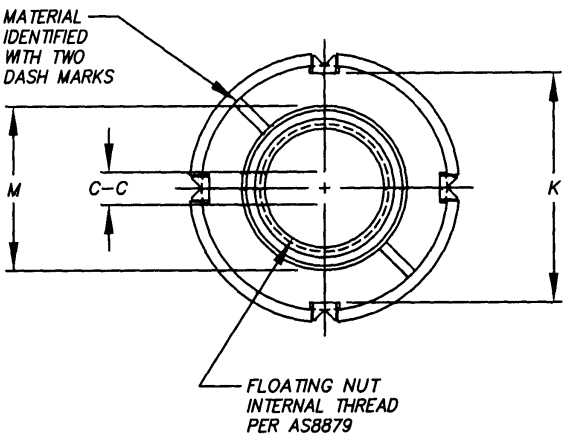
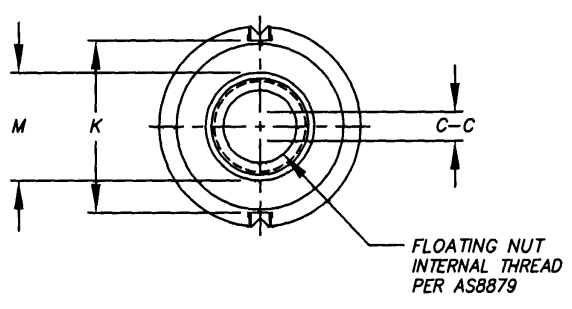


FIG. 1
FOR SIZE CODES
0256 THRU 0832
(KNK SERIES)

FIG. 2
FOR SIZE CODES
1032 THRU 616
(KNKD SERIES EXCEPT 524 & 518
SHALL BE KNK SERIES BUT FIG. 2)

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
AC1	10/8/2018	117431

TABLE 1

SIZE CODE	FIG NO	INTERNAL THREAD AS8879	EXTERNAL THREAD	MODIFIED MINOR DIA ±.004	L ±.015	E TO 1ST THREAD <6>	H INTERNAL THREAD LENGTH	C-C FLOAT MIN	T EXTERNAL THREAD LENGTH	KEES		K	F TO LOCK CENTER <6>	M ±.005 -.001
										QTY	P			
0256	1	.086-56UNJC-3B	.2500-28UNF-2A (MOD)	.213	.19	.05	.10	.015	.11	2	.060	.196	.11	N/A
0440	1	.112-40UNJC-3B	.3125-24UNF-2A	STD	.32	.07	.21	.020	.19	2	.110	.220	.16	.135
0632	1	.138-32UNJC-3B	.3750-24UNF-2A	STD	.36	.08	.22	.030	.21	2	.125	.286	.19	.199
0832	1	.164-32UNJC-3B	.3750-24UNF-2A	STD	.36	.08	.22	.030	.21	2	.125	.286	.19	.199
1032	2	.190-32UNJF-3B	.4375-20UNF-2A (MOD)	.396	.40	.15	.25	.040	.29	2	.156	.356	.24	.234
1024	2	.190-24UNJC-3B	.4375-20UNF-2A (MOD)	.396	.40	.15	.25	.040	.29	2	.156	.356	.24	.234
428	2	.250-28UNJF-3B	.5000-20UNF-2A (MOD)	.458	.40	.15	.25	.040	.29	2	.156	.416	<10> .27	.292
420	2	.250-20UNJC-3B	.5000-20UNF-2A (MOD)	.458	.40	.15	.25	.040	.29	2	.156	.416	<10> .27	.292
524	1	.3125-24UNJF-3B	.6250-18UNF-2A (MOD)	.570	.53	.13	.39	.040	.38	4	.187	.532	.26	.358
518	1	.3125-18UNJC-3B	.6250-18UNF-2A (MOD)	.570	.53	.13	.39	.040	.38	4	.187	.532	.26	.358
624	2	.375-24UNJF-3B	.7500-16UNF-2A (MOD)	.686	.65	.20	.45	.040	.51	4	.187	.659	.39	.422
616	2	.375-16UNJC-3B	.7500-16UNF-2A (MOD)	.686	.65	.20	.45	.040	.51	4	.187	.659	.39	.422

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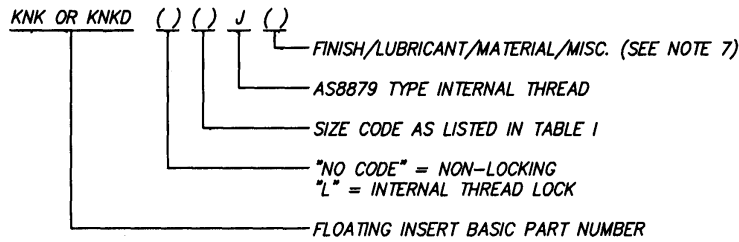
APPROVED DATE 5/3/95	 ARCONIC Arconic Fastening Systems Tridair Products 3000 W. Lomita Blvd. Torrance, California 90505	TITLE: KEENSERT, FLOATING INSERT	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372
REV. LETTER AND DATE AC 03/15/18 CA		PROJECT NO.	
DAF NUMBER 116610		SALES DRAWING NO.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.3M TOLERANCES:	ANGLES = ±3° DECIMALS .XX = ±.01 .XXX = ±.010
			KNK(D)(L)(J() SHEET 1 OF 2

TABLE II

SIZE CODE	INSTALLATION DATA					REMOVAL DATA	
	TAP DRILL DIA	C'SINK DIA +.010 -.000	THREAD TAP		INSTALLATION TOOL PART NUMBER	DRILL	
			SIZE UNF-2B	MIN DEPTH FULL THD		SIZE	DEPTH
0256	.227-.231	.250	.2500-28	.12	TK 02	#8 (.199)	3/32
0440	.270-.276	.323	.3125-24	.31	TK 04	7/32	1/8
0632	.331-.336	.385	.3750-24	.38	TK 06	9/32	1/8
0832	.331-.336	.385	.3750-24	.38	TK 08	9/32	1/8
1032	.405-.410	.447	.4375-20	.39	TK 010	11/32	5/32
1024	.405-.410	.447	.4375-20	.39	TK 010	11/32	5/32
428	.467-.472	.510	.5000-20	.39	TK 4	13/32	5/32
420	.467-.472	.510	.5000-20	.39	TK 4	13/32	5/32
524	.577-.583	.635	.6250-18	.50	TK 5	17/32	3/16
518	.577-.583	.635	.6250-18	.50	TK 5	17/32	3/16
624	.702-.708	.760	.7500-16	.62	TK 6	21/32	3/16
616	.702-.708	.760	.7500-16	.62	TK 6	21/32	3/16


PART NUMBER CODE:



NOTES:

1. MATERIAL:
 - 1.1 NUT AND SHELL: FIG. 1 PARTS: 303 CRES PER ASTM A582 OR AMS 5640.
FIG. 2 PARTS: 4140 PER AMS 5626 OR AMS 6382.
 - 1.2 LOCKING KEES: 302 CRES PER ASTM A580 (CHEMISTRY ONLY).
 - 1.3 RETAINING RINGS: 302 CRES PER ASTM A580 OR ASTM A313 (CHEMISTRY ONLY).
2. HEAT TREAT:
 - 2.1 FIG. 1 PARTS: SHELL & NUT: NONE.
 - 2.2 FIG. 2 PARTS: NUT: 160 KSI MIN PER AMS 2759.
SHELL: 160 KSI MIN PER AMS 2759.
3. FINISH:
 - 3.1 FIG. 1 PARTS: SHELL & NUT: PASSIVATE PER AMS 2700.
 - 3.2 FIG. 2 PARTS: SHELL & NUT: CAD PLATE PER AMS-QQ-P-416; TYPE I, CLASS 3 (FOR STANDARD FINISH AND SX CODE),
TYPE II, CLASS 3 (FINISH CODE SY) AND TYPE II, CLASS 2 (FINISH CODE SZ).
 - 3.3 ALL LOCKING KEES & RETAINING RINGS: PASSIVATE PER AMS 2700.
4. LUBRICATION: DRY FILM LUBRICANT PER AS5272, TYPE I (APPLIED TO NUT COMPONENT OF SELF-LOCKING INSERTS).
5. INTERNAL THREAD LOCK, TENSILE, PUSH-OUT AND TORQUE-OUT SHALL BE PER NASM25027.
- <6> DISTANCE TO FIRST INTERNAL THREAD AND DISTANCE TO INTERNAL THREAD LOCK MEASURED WITH NUT IN RETAINED POSITION.
- <7> FOR VARIOUS MATERIALS, CONTACT AFS ENGINEERING DEPARTMENT.
NO CODE AFTER "J" IN PART NUMBER INDICATES STANDARD MATERIAL AND FINISH PER NOTE 1 AND 3 ABOVE.
8. FOR ADDITIONAL CODES, REFER TO S-70248.
9. INSTALLATION PROCEDURE:
 - 9.1 PREPARE PANEL PER THE DIMENSIONS IN TABLE II. COUNTERSINK ANGLE IS 82°-100°.
 - 9.2 SCREW IN INSERT WITH FINGERS OR INSTALLATION TOOL. INSERT IS DESIGNED TO STOP AT CORRECT DEPTH.
 - 9.3 DRIVE LOCKING KEES DOWN USING THE INSTALLATION TOOL.
10. REMOVAL PROCEDURE:
 - 10.1 USE DRILL SIZE AND DEPTH SPECIFIED IN TABLE TO REMOVE MATERIAL BETWEEN LOCKING KEES.
 - 10.2 DEFLECT LOCKING KEES INWARD AND BREAK OFF.
 - 10.3 REMOVE INSERT WITH AN "EASY-OUT" TYPE TOOL.
- <11> EXCEPTION: LOCKING FEATURE FOR KNKD428 AND KNKD420 ONLY ARE LOCATED ON NUT O.D. INSTEAD OF NUT GROOVE AS SHOWN.

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ACI	10/8/2018	117431

APPROVED DATE 5/3/95	CURRENT DESIGN ACTIVITY:  ARCONIC Arconic Fastening Systems	TITLE: KEENSERT, FLOATING INSERT	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372
REV. LETTER AND DATE AC 03/15/18 CA	Tridair Products 3000 W. Lomita Blvd. Torrance, California 90505	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	PROJECT NO.
DAF NUMBER 116619		ANGLES = ±3° DECIMALS .XX = ±.01 .XXX = ±.010	SALES DRAWING NO.
			KNK(D)(L)() J() SHEET 2 OF 2

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