

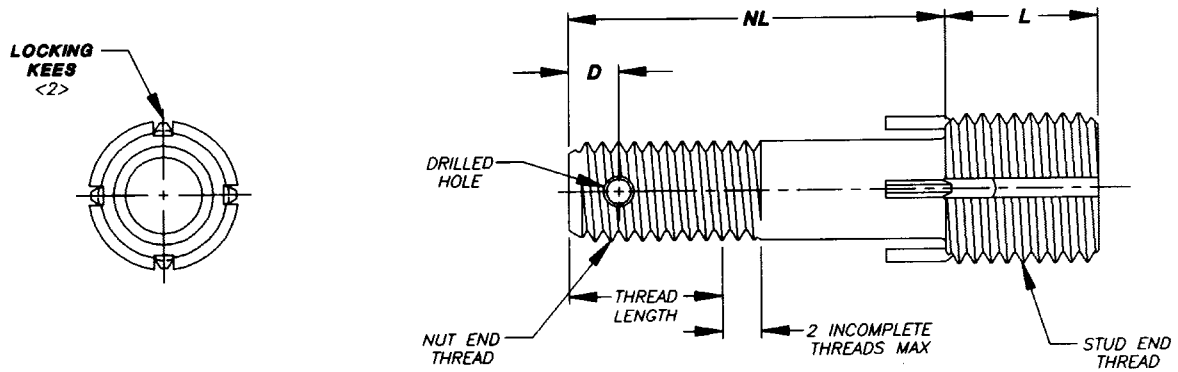


TABLE I

NUT END						STUD END		
PART NUMBER	THREAD SIZE CLASS 4h	NL MAX	THREAD LENGTH ± 0,75	DRILL HOLE		THREAD SIZE CLASS 4h	SHEAR ENGAGEMENT	L ± 0,75
				D	DIA			
KNNMS5x0,8	M5X0,8	50,	10,4	3,5	1,8	M8X1,25	104,9	8,0
KNNMS6X1,0	M6X1,0	50,	11,9	3,9	2,0	M10X1,25	177,7	10,0
KNNMS8X1,25	M8X1,25	63,	13,5	4,0	2,0	M12X1,25	266,7	12,0
KNNMS8X1,0	M8X1,0							
KNNMS10X1,5	M10X1,5	63,	16,3	4,4	2,7	M14X1,5	341,6	14,0
KNNMS10X1,25	M10X1,25							
KNNMS12X1,75	M12X1,75	76,	19,8	4,4	2,7	M16X1,5	470,2	16,0
KNNMS12X1,25	M12X1,25							

NOTES, UNLESS OTHERWISE SPECIFIED:

1. ALL DIMENSIONS ARE IN MILLIMETERS.

<2> STUDS WITH NUT END THREAD SIZES M6,0 AND UNDER ARE FURNISHED WITH 2 LOCKINGS KEES.
SIZES M8,0 AND ABOVE ARE FURNISHED WITH 4 LOCKINGS KEES.

<3> MATERIAL DESIGNATION:

STUD: S = 303 CRES, NO DESIGNATION NEEDED (PASSIVATE)

M = CHROME MOLY STEEL 125,000 KSI MIN. IDENTIFIED TWO NON-PARALLEL DASH MARK ON TOP OF STUD.

(CAD PLATE PER QQ-P-416, TYPE I, CLASS 3.

MX = CHROME MOLY STEEL 160,000 KSI MIN. IDENTIFIED TWO PARALLEL DASH MARK ON TOP OF STUD.

(CAD PLATE PER QQ-P-416, TYPE I, CLASS 3.

T = A286 CRES 140 KSI MIN. IDENTIFIED ONE DASH MARK ON TOP OF STUD (PASSIVATE).

TX = A286 CRES 180,000 KSI MIN. IDENTIFIED MARK "H" ON TOP OF STUD (PASSIVATE).

LOCKING KEES: 302 CRES PER ASTM-A-580 (CHEMISTRY ONLY).

4. FINISH DESIGNATION:

STUD SP = SILVER PLATE PER QQ-S-365.

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

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

LOCKING KEES: PASSIVATE PER QQ-P-35.

APPROVED DATE

10 JAN 96

REV. LETTER AND DATE

B 10 JAN 96

ECN NUMBER

ECN 38182



AEROSPACE FASTENER DIVISION
ENGINEERING CENTER
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CAGE CODE 29372

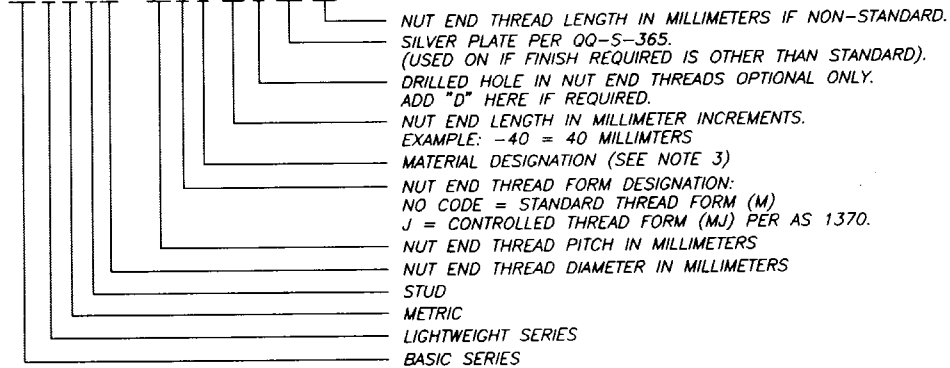
TRIDAIR PRODUCT

KEENSERT
LIGHTWEIGHT METRIC STUD

KNNMS()

SHEET 1 OF 2

5. PART NUMBER EXAMPLE:

KN NM 912 X 1,5 J T-40 D-SP-20


6. INSTALLATION PROCEDURE:

- 6.1 PREPARE PANEL IN ACCORDANCE WITH DIMENSIONS IN TABLE II.
- 6.2 SCREW IN STUD WITH FINGERS OR INSTALLATION TOOL. STUD IS DESIGNED TO STOP AT CORRECT DEPTH.
- 6.3 MARK LOCATION OF LOCKING KEES AND REMOVE STUD.
- 6.4 BROACH SLOTS USING THE MARKS AS A GUIDE.
- 6.5 CHASE THREADS WITH A TAP TO REMOVE CHIPS.
- 6.6 REINSTALL STUD AND DRIVE LOCKING KEES USING THE INSTALLATION TOOL.

7. REMOVAL PROCEDURE:

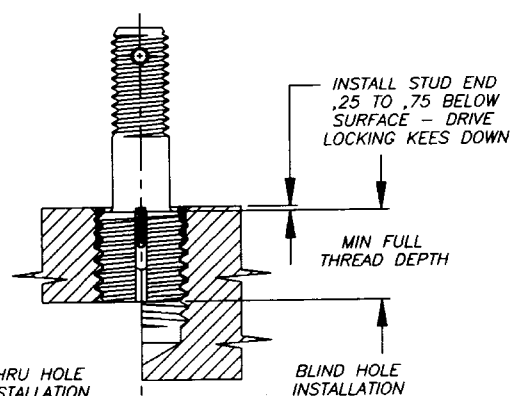
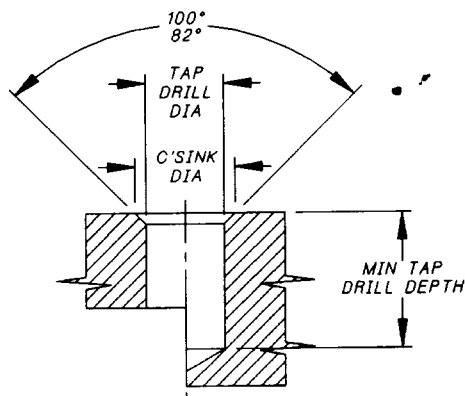
- 7.1 USE DRILL SIZE AND DEPTH SPECIFIED IN TABLE II TO REMOVE MATERIAL BETWEEN LOCKING KEES.
- 7.2 DEFLECT LOCKING KEES INWARD AND BREAK OFF.
- 7.3 REMOVE INSERT WITH AN "EASY-OUT" TYPE TOOL.

<8> INSTALLATION TAP DRILL HOLE TOLERANCE 4,0 TO 12,70 = $-.025 +.100$, ABOVE 12,70 = $-.025 +.130$.

9. CONSULT FAIRCHILD'S ENGINEERING DEPARTMENT FOR AVAILABILITY OF OPTIONAL MATERIALS, FINISHES AND SIZES.

TABLE II

INSTALLATION DATA						REMOVAL DATA	
PART NUMBER	TAP DRILL DIA <8>	C'SINK DIA +.25 -.00	THREAD TAP		INSTALLATION TOOL PART NUMBER	DRILL	
			SIZE CLASS 5H	MIN FULL THREAD DEPTH		SIZE	DEPTH
KNNMS5x0,8	6,9	8,25	M8X1,25	9,5	TNMS 5	5,50	4,0
KNNMS6X1,0	8,8	10,25	M10X1,25	11,5	TNMS 6	7,50	4,7
KNNMS8X1,25	10,8	12,25	M12X1,25	13,5	TNMS 8	9,50	4,75
KNNMS8X1,0							
KNNMS10X1,5	12,8	14,25	M14X1,5	15,5	TNMS 10	11,50	4,75
KNNMS10X1,25							
KNNMS12X1,75	14,75	16,25	M16X1,5	17,5	TNMS 12	13,50	4,75
KNNMS12X1,25							



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SHEET 2 OF 2