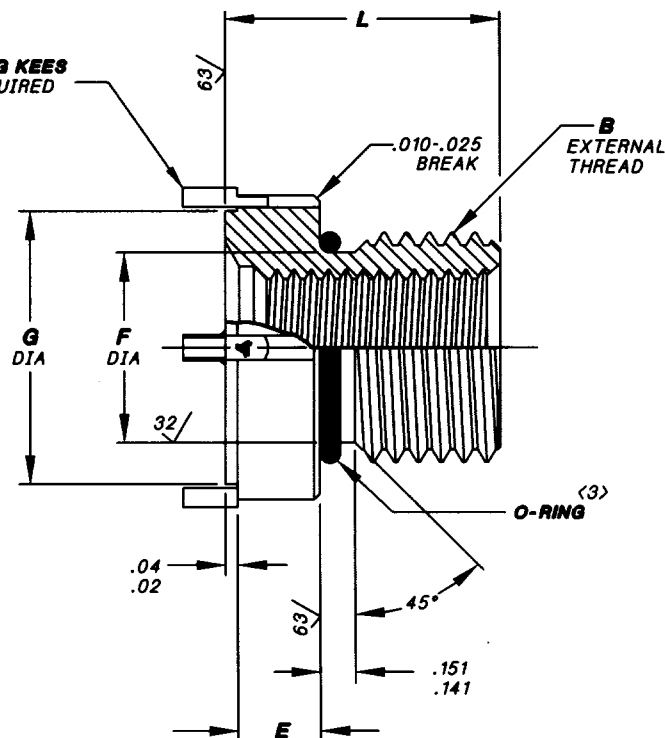


LOCKING KEES
4 REQUIRED



1. MATERIAL:

1.1 INSERT MATERIAL CODES:

- "NO CODE" = 303 CRES PER AMS5640, AMS5738 OR ASTM A 582.
- T = A286 CRES PER AMS5731, AMS5732 OR AMS5737.
- SE = 316 CRES PER AMS-QQ-S-763.

1.2 KEY MATERIAL = 302 CRES PER ASTM A 580 (CHEMISTRY ONLY.)

2. FINISH:

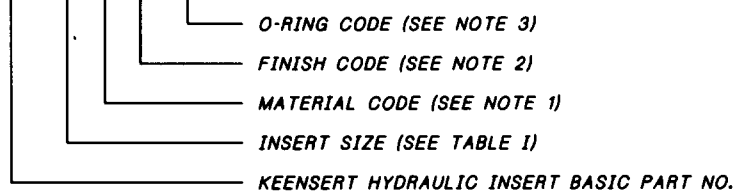
- "NO CODE" = PASSIVATE PER AMS-QQ-P-35 (FOR CRES ONLY).
- SP = SILVER PLATE PER QQ-S-365.

<3> O-RING CODES:

- 3.1 "NO CODE" = INSERT SUPPLIED WITHOUT O-RING.
- BNN = BUNA-N O-RING PER ASTM-D-2000.
- TEF = TEFLON O-RING PER AMS3656.
- VIT = VITON O-RING PER AMS7276 OR AMS7280.

4. PART NUMBER EXAMPLE:

KNYDJ - 2 SE SP - BNN



<5> INTERNAL CONFIGURATION PER MS 33649. SEE EQUIVALENT TUBE DASH NUMBER IN TABLE I.


- 6. UNLESS OTHERWISE SPECIFIED; TOLERANCES ARE: .XX ±.02, .XXX ±.010 AND ANGLES ±3°.
- 7. CONSULT FAIRCHILD'S ENGINEERING DEPARTMENT FOR AVAILABILITY OF OPTIONAL MATERIAL, FINISH ETC.

APPROVED DATE	FAIRCHILD FASTENERS ENGINEERING CENTER 3000 WEST LOMITA BOULEVARD TORRANCE, CA 90505	CAGE CODE 29372
07 APR 99		TRIDAIR PRODUCT
REV. LETTER AND DATE	-KEENSERT INSERT-HYDRAULIC INSERTS (FOR PRESSURE TO 3000 psi)	KNYDJ() SHEET 1 OF 3
E 15 MAR 02		
DAF NUMBER		
44236 <i>T. [signature]</i> 1/02		

055175

TABLE 1

INSERT SIZES	EQUIV. TUBE DASH NUMBER <5>	TUBE O.D REF.	A INTERNAL THREAD PER AS8879	B EXTERNAL THREAD PER MIL-S-7742	D DIA ±.002	E ±.005	F DIA ±.002	G DIA ±.002	L ±.020
-2	2	.125	.3125-24 UNJF-3B	.5000-20 UNF-3A	.676	.205	.399	.604	.658
-3	3	.188	.3750-24 UNJF-3B	.5625-18 UNF-3A	.739	.205	.462	.667	.658
-4	4	.250	.4375-20 UNJF-3B	.6250-18 UNF-3A	.802	.205	.524	.730	.667
-5	5	.312	.5000-20 UNJF-3B	.7500-16 UNF-3A	.864	.205	.649	.792	.676
-6	6	.375	.5625-18 UNJF-3B	.7500-16 UNF-3A	.926	.205	.649	.854	.685
-7	7	.438	.6250-18 UNJF-3B	.8125-16 UN-3A	.989	.205	.712	.917	.748
-8	8	.500	.7500-16 UNJF-3B	.9375-16 UN-3A	1.176	.325	.837	1.042	.805
-9	9	.562	.8125-16 UNJ-3B	1.0000-16 UN-3A	1.238	.325	.899	1.104	.840
-10	10	.625	.8750-14 UNJF-3B	1.0625-16 UN-3A	1.301	.325	.962	1.167	.880
-11	11	.688	1.0000-12 UNJF-3B	1.1875-16 UN-3A	1.488	.325	1.087	1.354	.900
-12	12	.750	1.0625-12 UNJ-3B	1.2500-16 UN-3A	1.551	.325	1.149	1.417	.919
-14	14	.875	1.1875-12 UNJ-3B	1.3750-16 UN-3A	1.676	.325	1.274	1.542	.942
-16	16	1.000	1.3125-12 UNJ-3B	1.5000-16 UN-3A	1.801	.325	1.399	1.667	.966

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REV. LETTER AND DATE	-KEENSERT INSERT-HYDRAULIC INSERTS (FOR PRESSURE TO 3000 psi)	KNYDJ() SHEET 2 OF 3
E 15 MAR 02		
DAF NUMBER		
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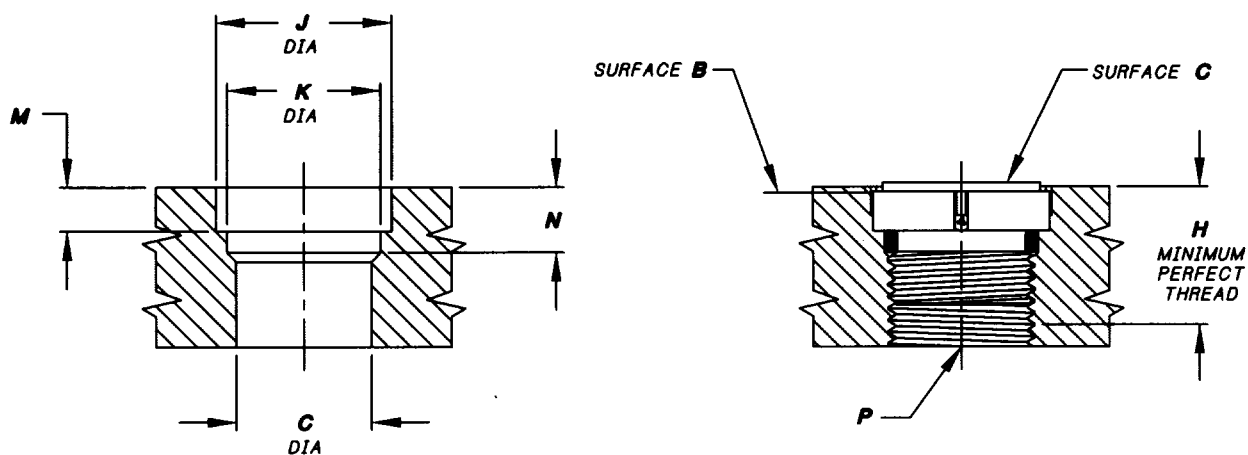


TABLE II

PART NUMBER	C DIA +.005 -.001	H MINIMUM PERFECT THREAD	J DIA +.001	K DIA +.005 -.001	M +.010 -.000	N +.015 -.000	P TAP SIZE THREAD PER FED-STD-H28/2	USE WITH O-RING MS28775-() DASH NUMBER	INST. TOOL NUMBER TKNYDJ-() DASH NUMBER	SEATING TORQUE lbf-in
KNYDJ-2	.453	.72	.680	.562	.210	.351	.5000-20 UNF-3B	-110	-2	40-65
KNYDJ-3	.515	.72	.743	.625	.210	.351	.5625-18 UNF-3B	-111	-3	90-100
KNYDJ-4	.578	.73	.806	.687	.210	.351	.6250-18 UNF-3B	-112	-4	135-150
KNYDJ-5	.687	.74	.868	.812	.210	.351	.7500-16 UNF-3B	-114	-5	180-200
KNYDJ-6	.687	.75	.930	.812	.210	.351	.7500-16 UNF-3B	-114	-6	270-300
KNYDJ-7	.750	.81	.993	.875	.210	.351	.8125-16 UN-3B	-115	-7	350-400
KNYDJ-8	.875	.87	1.180	1.000	.330	.470	.9375-16 UN-3B	-117	-8	450-500
KNYDJ-9	.937	.90	1.242	1.062	.330	.470	1.0000-16 UN-3B	-118	-9	550-600
KNYDJ-10	1.000	.94	1.305	1.125	.330	.470	1.0625-16 UN-3B	-119	-10	650-700
KNYDJ-11	1.125	.96	1.492	1.250	.330	.470	1.1875-16 UN-3B	-121	-11	750-850
KNYDJ-12	1.188	.98	1.555	1.312	.330	.470	1.2500-16 UN-3B	-122	-12	900-1000
KNYDJ-14	1.312	1.00	1.680	1.437	.330	.470	1.3750-16 UN-3B	-124	-14	1050-1200
KNYDJ-16	1.438	1.03	1.805	1.562	.330	.470	1.5000-16 UN-3B	-126	-16	1200-1400

7. HOLE PREPARATION:

- 7.1 DRILL "C" DIA MINUS 1/64.
- 7.2 REAM "C" DIA AND C'BORE "J" DIA TO "M" DEPTH.
- 7.3 DRILL "K" DIA TO "N" DEPTH.
- 7.4 TAP "P" THREADS TO "H" MIN. PERFECT THREADS.

8. INSTALLATION PROCEDURE:

- 8.1 LUBRICATE INSERT AND O-RING BEFORE ASSEMBLY.
- 8.2 SCREW INSERT INTO TAPPED HOLE UNTIL PROPERLY SEATED USING SPECIFIED INSTALLATION TOOL.
- 8.3 SURFACE B SHOULD BE BELOW THE PARENT MATERIAL AND SURFACE C SHOULD BE ABOVE.
- 8.4 DRIVE DOWN THE FOUR KEES, USING INSTALLATION TOOL AND ORDINARY HAMMER OR PRESS.

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DAF NUMBER		
44236		

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