

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

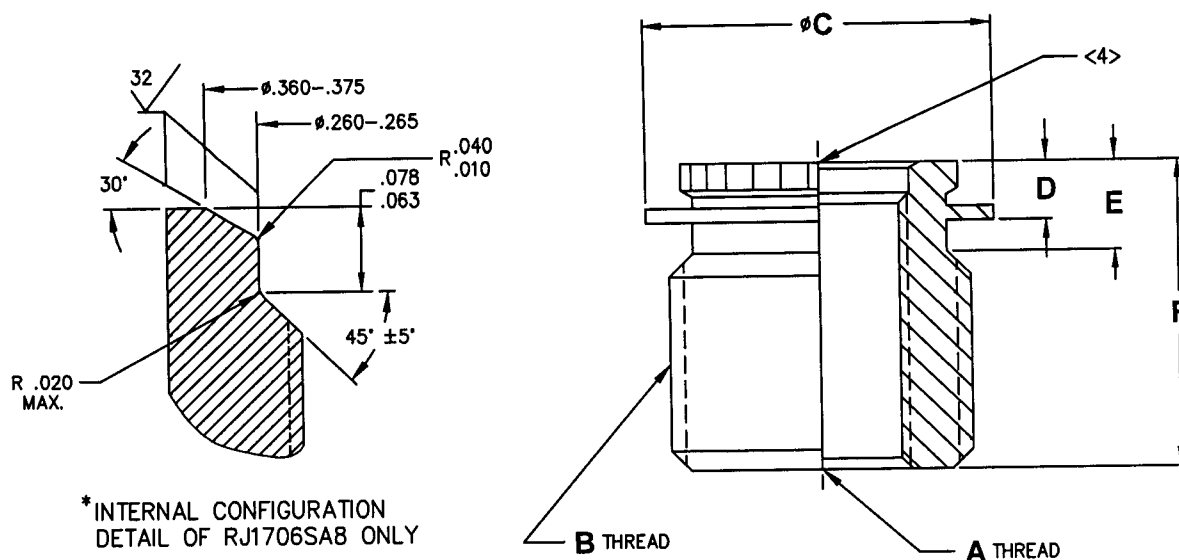


TABLE I

INSERT PART NUMBER <5>	LOCKRING PART NUMBER <6> REF.	A INTERNAL THREAD CLASS-3B	B EXTERNAL THREAD CLASS-3A	ØC	D	E	F
				±.005	±.005	±.005	±.015
*RJ1706SA8	RL33SA7	.2500-28UNJF	.4375-20UNF	.510	.176	.276	.500
RJ1707SA8	RL38SA7	.3125-24UNJF	.5000-20UNF	.585	.176	.276	.500
RJ1708SA8	RL47SA8	.3750-24UNJF	.6250-18UNF	.729	.191	.302	.560
RJ1709SA9	RL47SA8	.4375-20UNJF	.6250-18UNF	.729	.191	.302	.560
RJ1710SA9	RL56SA8	.5000-20UNJF	.7500-16UNF	.870	.191	.316	.560
RJ1713SA10	RL72SA8	.7500-16UNJF	1.0000-16UNF	1.120	.191	.334	.620


## NOTES:

1. MATERIAL: STEEL, ALLOY 4130 PER AMS-S-6758, CONDITION F.
2. HEAT TREAT: 125 KSI UTS MIN PER AMS 2759/1.
3. FINISH: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3.

<4> INTERNAL CONFIGURATION MEETS THE REQUIREMENTS OF MS33649 EXCEPT RJ1706SA8.

<5> RJ1700 SERIES SUPERSEDES R1700 SERIES DUE TO AND10050 BEING SUPERSEDED BY MS33649.

<6> THE HYDRAULIC INSERT IS USED IN CONJUNCTION WITH A THIN SERIES LOCKRING.

APPROVED DATE 2/4/11	CURRENT DESIGN ACTIVITY:  <b>ARCONIC</b> Fastening Systems and Rings	TITLE: <b>INSERT - HYDRAULIC, RING LOCKED</b>	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
REV. LETTER AND DATE A 4/10/17	<b>Rosan Products</b> 3018 W. Lomita Blvd. Torrance, California 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO.
DAF NUMBER 115378		ANGLES DECIMALS = .3° .XX = ±.01 .XXX = ±.008	<b>RJ1700SA( ) SERIES</b> SHEET 1 OF 3

MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN  
CONSENT OF ARCONIC FASTENING SYSTEMS AND RINGS IS ABSOLUTELY PROHIBITED.

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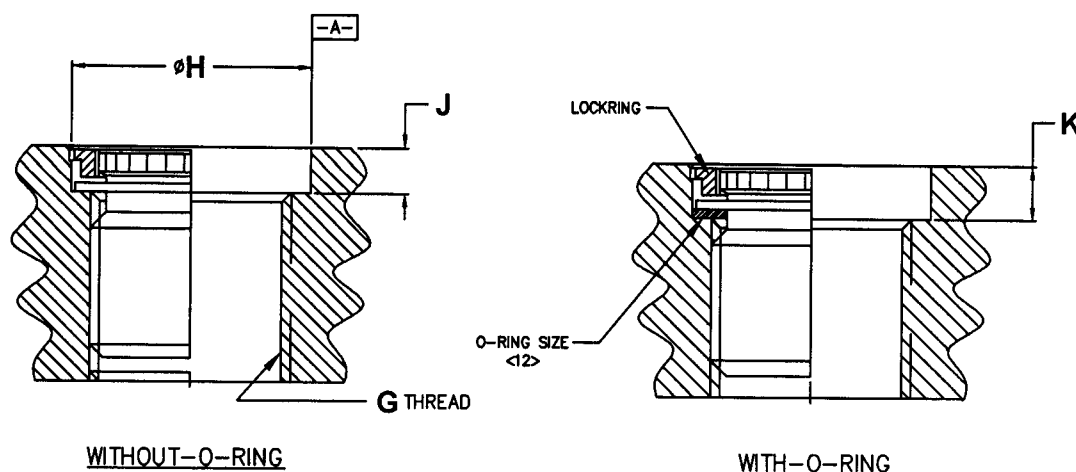



TABLE II

INSERT PART NUMBER	G INTERNAL THREAD CLASS-3B  <8>	ØH +.003 -.000  <7>	J C'BORE DEPTH  <9>	K C'BORE DEPTH  <10>	TAP DRILL SIZE	O-RING SIZE  <12>
RJ1706SA8	.4375-20UNJF	.515	.186	.226	.386	AS568-012
RJ1707SA8	.5000-20UNJF	.593	.186	.269	.453	AS568-110
RJ1708SA9	.6250-18UNJF	.734	.201	.284	.569	AS568-112
RJ1709SA9	.6250-18UNJF	.734	.201	.284	.569	AS568-112
RJ1710SA9	.7500-16UNJF	.875	.201	.284	.687	AS568-115
RJ1713SA10	1.0000-14UNJS	1.125	.201	.330	.927	AS568-212

## NOTES: (CONTINUED)

- <7> "B" DIAMETER AND MINOR DIAMETER OF THREAD TO BE CONCENTRIC WITHIN .003 F.I.M.
- <8> THREAD AS SHOWN PER AS8879 IS PREFERRED. ALTERNATE THREAD PER FED-STD-H28/2 CLASS 3B OR NATIONAL CLASS 3 IS APPLICABLE WHEN SPECIFIED BY DESIGN ACTIVITY.
- <9> WITHOUT O-RING: USE FOR DUST AND FOREIGN MATTER EXCLUSION. INSTALL PART UNTIL FLANGE IS SEATED IN C'BORE. DO NOT USE EXCESSIVE TORQUE.
- <10> WITH O-RING: USE TO EFFECT FLUID SEAL FOR PRESSURE UP TO 150 PSI. SEE NOTE 11. INSTALL PART UNTIL TOP SERRATED FLANGE IS .010 TO .020 BELOW SURFACE.
11. DRIVE LOCKRING FROM .005 TO .010 BELOW MATERIAL SURFACE.
- <12> O-RINGS MUST BE SPECIFIED SEPARATELY AND SHALL BE SELECTED BASED ON SYSTEM FLUID AND TEMPERATURE AND ARE NOT SUPPLIED BY ARCONIC. DASH NUMBERS SHOWN IN THE TABLE CONFORM TO SAE STANDARD (AS568) UNIFORM DASH NUMBERING SYSTEM. WITH PROPER INSTALLATION AND PROPER CHOICE OF O-RING, FLUID SEAL UP TO 150 PSI WILL BE EFFECTED.

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DAF NUMBER 115378		ANGLES DECIMALS = ±.3° .XX = ±.01 XXX = ±.005	<b>RJ1700SA( ) SERIES</b> SHEET 2 OF 3

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TABLE II


INSERT PART NUMBER	C'BORE TOOL PART NUMBER	BASIC TAP SIZE  <13>	WRENCH PART NUMBER	LOCKRING DRIVE TOOL PART NUMBER	REMOVAL DRILL SIZE  <14> REF.	DEPTH TO USE REMOVAL DRILL
RJ1706SA8	RC33-386	.4375-20UNF	R1107XW	R1706D	27/64	.140
RJ1707SA8	RC38-453	.5000-20UNF	R1108W	R1707D	31/64	.140
RJ1708SA8	RC47-569	.6250-18UNF	R1110W	R1708D	19/32	.156
RJ1709SA9	RC47-569	.6250-18UNF	R1110W	R209D	19/32	.156
RJ1710SA9	RC56-687	.7500-16UNF	R1111W	R210D	23/32	.156
RJ1713SA10	RC72-927	1.0000-14UNS	R1113W	R1713D	15/16	.156

NOTES: (CONTINUED)

&lt;13&gt; TAPS ARE NOT SUPPLIED BY ARCONIC.

&lt;14&gt; REMOVAL DRILLS ARE NOT SUPPLIED BY ARCONIC.

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DAF NUMBER 115378		ANGLES = ±3° DECIMALS .001 = ±.01 XXX = ±.005	<b>RJ1700SA( ) SERIES</b> SHEET 3 OF 3