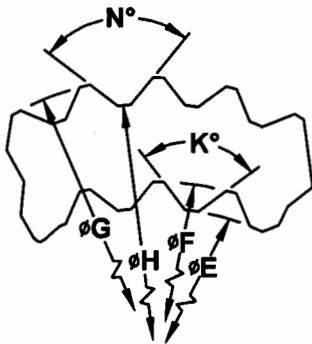
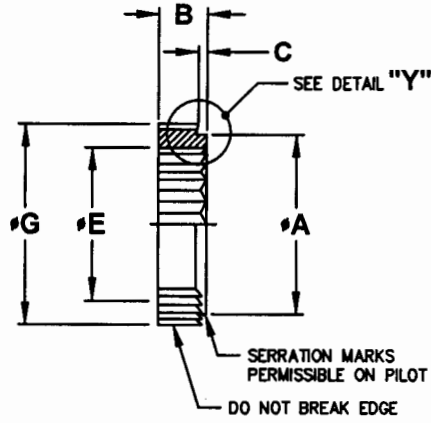
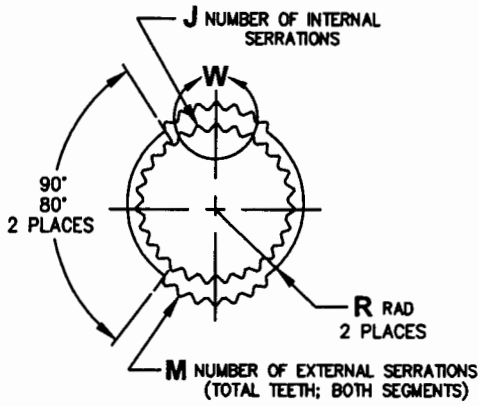
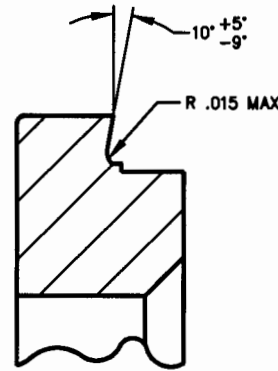


Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Vol-Shan



DETAIL "W"
NO SPECIFIC ANGULARITY EXISTS BETWEEN INTERNAL AND EXTERNAL SERRATIONS. THE SERRATED SECTORS WILL BE LOCATED DIAMETRICALLY OPPOSITE.



DETAIL "Y"
ALLOWABLE MACHINING MISMATCH

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

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TABLE I

PART NUMBER	Ø A ±.005	-5		-6		-7		-8		-9		-10		-11		-12		Ø E +.004 -.003	Ø F +.005 -.004	Ø G +.003 -.006	Ø H	J	K° +1° -2°	M	N°	(R)
		B	C	B	C	B	C	B	C	B	C	B	C	B	C	B	C									
RLRR16(X)	.223	.084	.027	.097	.040	.112	.040	.128	.040	.145	.040							.161	.189	.274	.246	14	102°	10	100°	.120
RLRR18(X)	.255	.084	.027	.099	.040	.115	.040	.130	.045	.145	.040							.189	.223	.308	.279	16	90°	10	100°	.135
RLRR21(X)	.298	.075	.027	.099	.040	.123	.040	.130	.040									.213	.252	.354	.324	13	102°	12	90°	.159
RLRR24(X)	.343	.081	.040	.097	.040	.112	.040	.128	.040	.145	.040							.266	.315	.399	.363	17	86°	12	90°	.180
RLRR28(X)	.400	.081	.040	.099	.040	.115	.040	.138	.040	.145	.040							.323	.364	.468	.430	20	102°	14	90°	.214
RLRR31(X)	.452				.115	.040	.138	.040	.145	.040								.375	.408	.514	.480	24	102°	16	90°	.237
RLRR33(X)	.480	.084	.027	.099	.040	.115	.040	.130	.040	.145	.040	.161	.049	.176	.072			.390	.425	.545	.511	24	102°	18	90°	.252
RLRR38(X)	.560			.099	.040	.115	.040	.130	.040	.145	.040	.161	.049	.176	.056			.468	.505	.624	.589	26	102°	20	90°	.293
RLRR47(X)	.702							.130	.040	.145	.040	.161	.049					.574	.613	.767	.731	26	111°	22	100°	.362
RLRR56(X)	.837			.099	.040	.115	.040	.130	.040	.145	.040	.161	.049	.176	.056			.694	.740	.910	.871	30	111°	24	111°	.431
RLRR64(X)	.958			.099	.040									.176	.056			.795	.845	1.040	.994	30	111°	20	111°	.492
RLRR72(X)	1.078							.138	.040					.176	.056			.908	.950	1.170	1.113	38	102°	22	102°	.551
RLRR82(X)	1.232			.099	.040	.115	.040	.138	.040	.145	.040	.161	.049	.176	.056	.193	.070	1.035	1.093	1.326	1.274	36	111°	20	111°	.636
RLRR90(X)	1.371															.193	.070	1.189	1.247	1.456	1.402	48	90°	20	102°	.692
RLRR100(X)	1.509							.130	.040	.145	.040	.161	.049	.176	.056	.193	.070	1.282	1.339	1.611	1.551	42	111°	16	111°	.770

APPROVED DATE 7/26/07	<p>ARCONIC Fastening Systems and Rings <i>Rosan Products</i> 3018 W. Lomita Blvd. Torrance, California 90505-5103</p>	TITLE: LOCKRING	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
REV. LETTER AND DATE G 2/14/2018		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES	SALES DRAWING NO.
DAF NUMBER 116455		ANGLES = ±3° DECIMALS .XX = ±.02 XXX = ±.010	RLRR() () SERIES SHEET 1 OF 2

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

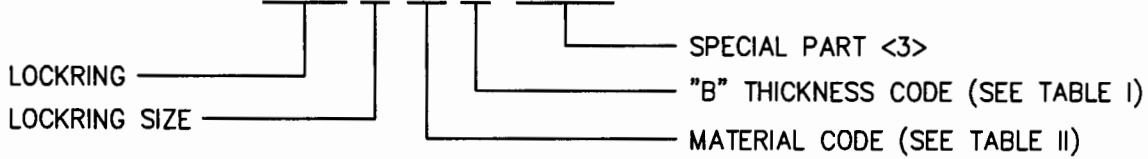
TABLE II

CODE	MATERIAL	SPECIFICATION	HEAT TREAT	FINISH
SA	4130 STEEL	AMS 6370	36-45 HRc PER AMS 2759	CAD PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3
	4140 STEEL	AMS 6382		
	8740 STEEL	AMS 6322		
SM	303SE CRES	ASTM A582 OR AMS 5640	NONE	PASSIVATE PER AMS 2700
SU	A286 CRES	AMS 5731, AMS 5732, AMS 5734, OR AMS 5737	269 HB MIN	PASSIVATE PER AMS 2700
S3C	718 CRES	AMS 5662	230 KSI UTS MIN	PASSIVATE PER AMS 2700

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


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RLRR 64 SA 11 EO432



NOTES:

- FILLETS RAD .015 MAX.
 - UNLESS OTHERWISE SPECIFIED, BREAK SHARP EDGES .003-.015, EXCEPT SERRATIONS.
- <3> FOR SPECIAL PART, ADD SUFFIX EOXXX TO LOCKRING PART NUMBER.
- EO432: ZINC PLATE PER ASTM B633, TYPE II, CLASS Fe/Zn 12, APPLICABLE FOR "SA".
- EO433: CAD PLATE PER ASTM B766, TYPE II, CLASS 8, APPLICABLE FOR "SA".
- EO137: ZINC PLATE PER QQ-Z-325, TYPE II, CLASS 3, APPLICABLE FOR "SA".
- EO325: CAD PLATE PER AMS-QQ-P-416 TYPE II CLASS 3
PLUS SOLID FILM LUBE PER AS 5272, TYPE 1

APPROVED DATE 7/26/07	CURRENT DESIGN ACTIVITY:  ARCONIC Fastening Systems and Rings	TITLE: LOCKRING	CURRENT DESIGN ACTIVITY: CAGE CODE: 83324
REV. LETTER AND DATE G 2/14/2018	Rosan Products 3018 W. Lomita Blvd. Torrance, California 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO.
DAF NUMBER 116455		ANGLES = ±.5° DECIMALS .XX = ±.02 XXX = ±.010	RLRR() () SERIES
			SHEET 2 OF 2