

-()	A THREAD	B THREAD		C ±.030 <7>	D DIA <7>	E ±.015	F DIA ±.010	H ±.020	J DIA ±.010	K REF	L MIN LENGTH <11>	P REF
		SIZE	MODIFIED MINOR DIA									
-101	.1900-24UNJC-3A	.3125-18UNC-2A	.256-.249	.410	.189-.185	.312	.250	.141	.070	.220	-6 (.375)	.160
-102	.2500-20UNJC-3A	.3750-16UNC-2A	.320-.312	.470	.249-.245	.375	.310	.156	.076	.284	-6 (.375)	.190
-103	.3125-18UNJC-3A	.4375-14UNC-2A	.383-.375	.530	.312-.308	.437	.375	.172	.076	.345	-9 (.562)	.190
-104	.3750-16UNJC-3A	.5000-13UNC-2A	.440-.432	.640	.374-.370	.500	.430	.172	.106	.407	-10 (.625)	.190
-105	.4375-14UNJC-3A	.5625-12UNC-2A	.503-.495	.660	.437-.433	.562	.495	.172	.106	.469	-10 (.625)	.190
-106	.5000-13UNJC-3A	.6250-11UNC-2A	.565-.551	.780	.499-.495	.625	.550	.172	.106	.532	-12 (.750)	.190
-201	.1900-32UNJF-3A	.3125-18UNC-2A	.256-.249	.410	.189-.185	.312	.250	.141	.070	.220	-6 (.375)	.160
-202	.2500-28UNJF-3A	.3750-16UNC-2A	.320-.312	.470	.249-.245	.375	.310	.156	.076	.284	-6 (.375)	.190
-203	.3125-24UNJF-3A	.4375-14UNC-2A	.383-.375	.530	.312-.308	.437	.375	.172	.076	.345	-9 (.562)	.190
-204	.3750-24UNJF-3A	.5000-13UNC-2A	.440-.432	.640	.374-.370	.500	.430	.172	.106	.407	-10 (.625)	.190
-205	.4375-20UNJF-3A	.5625-12UNC-2A	.503-.495	.660	.437-.433	.562	.495	.172	.106	.469	-10 (.625)	.190
-206	.5000-20UNJF-3A	.6250-11UNC-2A	.565-.551	.780	.499-.495	.625	.550	.172	.106	.532	-12 (.750)	.190

NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
 - 1.1 STUD: 4140 ALLOY STEEL PER MIL-S-5626.
A286 CRES PER AMS 5737.
303 CRES PER AMS 5640.
INCONEL 718 PER AMS 5662.
 - 1.2 LOCKING KEES: 420 CRES PER QQ-S-763 (CHEMISTRY ONLY).
2. HEAT TREAT:
 - 2.1 STUD: 4140 ALLOY STEEL, 160 KSI MIN PER MIL-H-6875.
A286 CRES, 140 KSI MIN OR 180 KSI MIN PER MIL-H-6875. <11>
303 CRES, NONE
INCONEL 718, 180 KSI MIN PER AMS 5662, AMS 5663.
3. HARDNESS:
 - 3.1 STUD: 4140 ALLOY STEEL, HRC 36-40.
 - 3.2 LOCKING KEES: 420 CRES HRC 54 MIN.

APPROVED DATE <i>M. B. 4/24/97</i>	Fairchild FAIRCHILD FASTENERS ENGINEERING CENTER 3000 WEST LOMITA BOULEVARD TORRANCE, CA 90505	CAGE CODE 29372 TRIDAIR PRODUCT
REV. LETTER AND DATE J 18 JUN 97	KEENSERT, STUD LIGHTWEIGHT SELF-BROACHING	TR28000-()-()-() SHEET 1 OF 2
DAF NUMBER 40371		

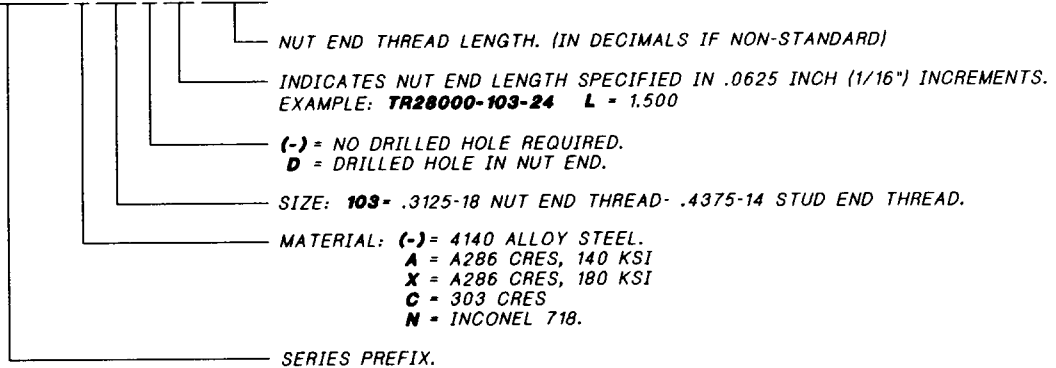
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NOTES, CONTINUED:


4. FINISH:
ALLOY STEEL: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 3. (LOCKING KEES MAY OR MAY NOT BE PLATED).
303, A286, AND INCONEL: PASSIVATE PER ASTM-A-967.
- <5> MATERIAL IDENTIFICATION:
4140 ALLOY STEEL: TWO PARALLEL DASH MARKS ON TOP OF STUD.
A286 CRES 140 KSI: ONE DASH MARK ON TOP OF STUD.
A286 CRES 180 KSI: IDENTIFIED WITH "H" ON TOP OF STUD.
303 CRES: NO IDENTIFYING MARKS REQUIRED.
INCONEL 718: IDENTIFIED WITH "N" ON TOP OF STUD.
- <6> 2 LOCKING KEES ON -101, -102, -201 AND -202, 4 LOCKING KEES ON ALL OTHER SIZES.
- <7> DASH NUMBER -6 THRU -8 FOR 1032 AND 1024 SIZES, -6 THRU -9 FOR 428 AND 420 SIZES, -9 AND -10 FOR 524 AND 518 SIZES, -10 AND -11 FOR 624 AND 616 SIZES, -10 THRU -12 FOR 720 AND 714 SIZES, AND -12 THRU -14 FOR 820 AND 813 SIZES ARE TO BE THREADED TO THE STUD END AS FOLLOWS:
THE MAXIMUM DISTANCE FROM THE STUD END TO THE FIRST FULL THREAD SHALL BE EQUAL TO THE SUM OF THE MAXIMUM FILLET RADIUS AND A MAXIMUM OF TWO INCOMPLETE THREADS. INCOMPLETE THREADS NOT TO ENTER FILLET AREA. "D" DIA. IS NOT APPLICABLE ON "SHORT LENGTHS" LISTED ABOVE IN ORDER TO MAXIMIZE THREAD LENGTH.
8. STUDS SHALL BE FREE FROM ALL HANGING BURRS OR SLIVERS WHICH MAY BECOME DISLODGED UNDER USAGE.
9. HOLE PREPARATION FOR INSTALLATION OF STUD SHALL BE IN ACCORDANCE WITH MS51835. SELECT POWER TOOLING FROM FAIRCHILD'S PRODUCT BULLETIN NO. PB88-315.
10. POWER TOOLING MAY NOT BE USED ON DASH NUMBERS -6 THRU -8 DUE TO LACK OF ADEQUATE THREAD ENGAGEMENT. CONSULT FAIRCHILD'S ENGINEERING DEPARTMENT FOR ALTERNATE METHODS OF INSTALLATION.

<11> PART NUMBER EXAMPLE:

TR28000-103-24-1.36



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

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J 18 JUN 97 DAF NUMBER 40371	KEENSERT, STUD LIGHTWEIGHT SELF-BROACHING	TR28000-(-)(-)(-) SHEET 2 OF 2

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