

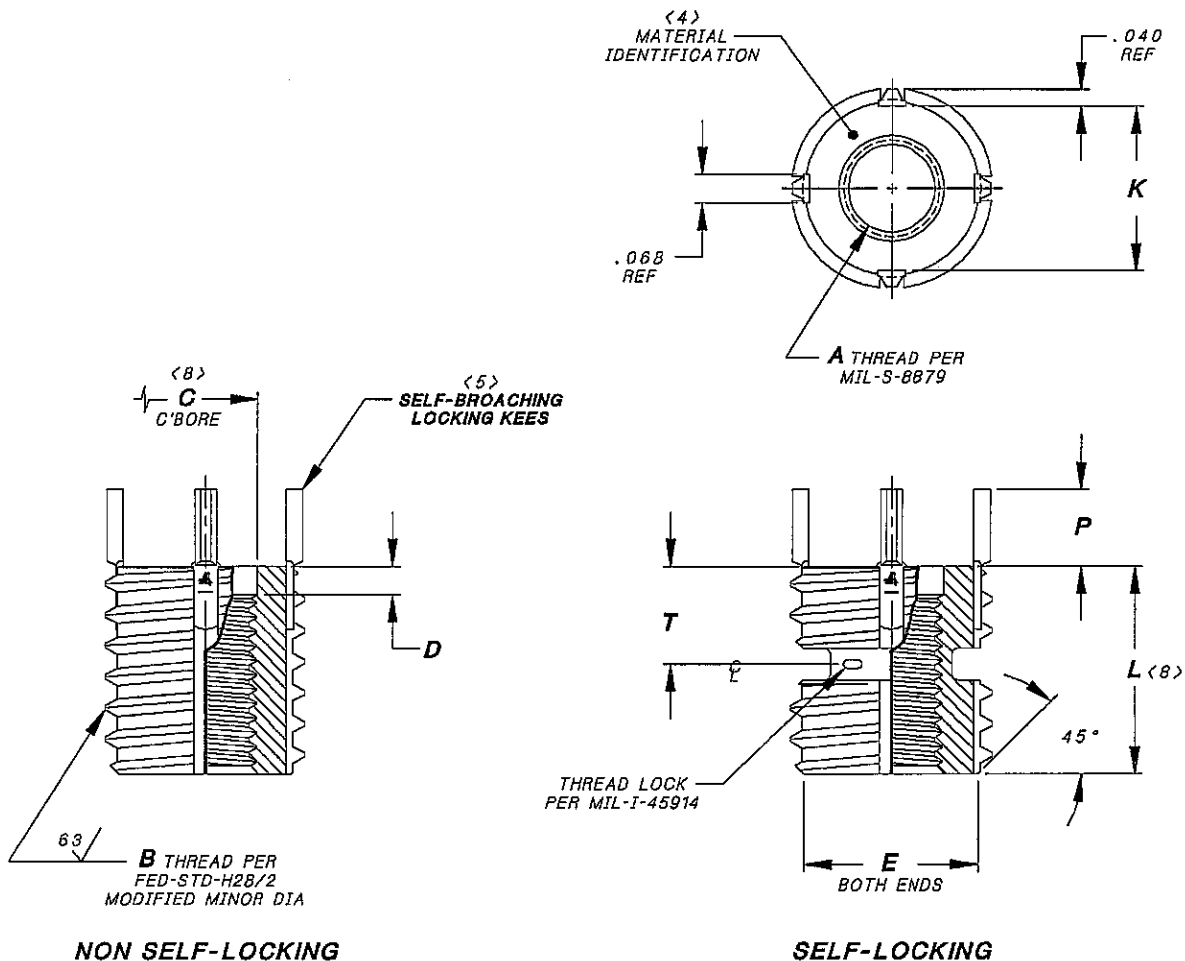


TABLE I

-()	A THREAD	B THREAD		C DIA ±.005	D ±.010	E DIA REF	K ±.004	L ±.015	P ±.015	T ±.030
		SIZE	MINOR DIA							
-101	.1900-24UNJC-3B	.4375-14UNC-2A	.383	.196	.070	.375	.345	.312	.190	.220
-201	.1900-32UNJF-3B		.375							
-102	.2500-20UNJC-3B	.5000-13UNC-2A	.440	.257	.070	.430	.407	.375	.190	.220
-202	.2500-28UNJF-3B		.432							
-103	.3125-18UNJC-3B	.5625-12UNC-2A	.503	.316	.070	.495	.469	.437	.190	.220
-203	.3125-24UNJF-3B		.495							
-104	.3750-16UNJC-3B	.6250-11UNC-2A	.565	.380	.070	.550	.532	.500	.190	.250
-204	.3750-24UNJF-3B		.551							
-105	.4375-14UNJC-3B	.6875-11NS-2A	.625	.445	.100	.615	.594	.625	.190	.280
-205	.4375-20UNJF-3B		.615							
-106	.5000-13UNJC-3B	.8125-16UN-2A	.752	.507	.100	.745	.720	.688	.190	.280
-206	.5000-20UNJF-3B		.744							
-107	.5625-12UNJC-3B	.8750-14UNF-2A	.815	.580	.100	.805	.782	.812	.190	.320
-207	.5625-18UNJF-3B		.807							

APPROVED DATE

MB 10/23/96

REV. LETTER AND DATE

D 23 OCT 96

ECN NUMBER

ECN 36578

Fairchild

AEROSPACE FASTENER DIVISION
ENGINEERING CENTER

3000 WEST LOMITA BOULEVARD

TORRANCE, CA 90505

95-089

91-151

CAGE CODE **29372**

TRIDAIR PRODUCT

**KEENSERT INSERT,
EXTRA HEAVY DUTY
SELF-BROACHING**
TR29001-()

SHEET 1 OF 3

SCANNED

NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
 - 1.1 INSERT= 4140 ALLOY STEEL PER MIL-S-5626.
A286 CRES PER AMS5737.
303 CRES PER AMS5640.
 - 1.2 LOCKING KEES= 420 CRES PER QQ-S-763. (CHEMISTRY ONLY)
2. HEAT TREAT:
 - 2.1 INSERT= 4140 ALLOY STEEL: 160-180 KSI PER MIL-H-5875. (HRC 36-40)
 - 2.2 LOCKING KEES= HRC 54 MIN.
3. FINISH:
 - 3.1 INSERT= 4140 ALLOY STEEL: CAD PLATE PER QQ-P-416 TYPE II, CLASS 3.
A286 CRES & 303 CRES= PASSIVATE PER QQ-P-35.
 - 3.2 LOCKING KEES= PASSIVATE PER QQ-P-35. (LOCKING KEES MAY OR MAY NOT BE PLATED OR LUBRICATED)
 - 3.3 OPTIONAL FINISH: SZ: CAD PLATE PER QQ-P-416, TYPE II, CLASS 2. (ALLOY STEEL MATERIAL).
SP: SILVER PLATE PER AMS2410 (303 AND A-286 MATERIAL ONLY).
 - 3.4 LUBRICATION= INSERTS WITH SELF-LOCKING INTERNAL THREADS HAVE DRY FILM LUBE PER MIL-L-46010 TYPE I.
4. INSERT MATERIAL IDENTIFICATION:

4140 ALLOY STEEL= TWO PARALLEL DASH MARKS ON TOP OF INSERT.
A286 CRES= ONE DASH MARK ON TOP OF INSERT.
303 CRES= NO IDENTIFICATION REQUIRED.
5. INSERT DASH NUMBERS -101 AND -201 SIZES ARE FURNISHED WITH 2 LOCKING KEES, INSERT DASH NUMBERS -102, -202 AND LARGER SIZES ARE FURNISHED WITH 4 LOCKING KEES.
6. SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH ANSI/ASME B46.1
ALL SURFACE FINISH= 125 MICROINCHES UNLESS OTHERWISE SPECIFIED.
7. PART NUMBER EXAMPLE:
TR29001CA201L-12SZ

OPTIONAL FINISH:
SZ = CAD PLATE
SP = SILVER PLATE

SPECIAL LENGTH SEE NOTE
(USED ONLY IF LENGTH REQUIRED IS OTHER THAN STANDARD)

THREAD TYPE:
NO SUFFIX = NON-LOCKING THREAD.
L = SELF-LOCKING THREAD.

INSERT SIZES (SEE TABLE I).

MATERIAL:
- = 303 CRES.
A = 4140 ALLOY STEEL.
CA = A286 CRES.

BASIC PART NUMBER.
8. OVERALL LENGTHS OTHER THAN THOSE LISTED IN TABLE I ARE AVAILABLE BY SPECIFYING OVERALL LENGTH IN 1/16" INCREMENTS. EXAMPLE: -12= .750 LONG. INSERTS ORDERED WITH LENGTHS SHORTER THAN STANDARD ARE SUPPLIED WITH NO C'BORE AND MAY REQUIRE SPECIAL TOOLING FOR INSTALLATION.
9. ALL DIMENSIONS ARE AFTER CAD PLATING OR SURFACE TREATMENT AND PRIOR TO THE ADDITION OF THE LUBRICATION.
10. INSTALLATION PROCEDURES:
 - 10.1 PREPARE PANEL IN ACCORDANCE WITH THE DIMENSIONS SHOWN IN TABLE II.
 - 10.2 SELECT APPROPRIATE INSTALLATION TOOL FROM TABLE II AND ATTACH TO 70950-6 POWER TOOL.
 - 10.3 SCREW IN INSERT WITH FINGERS OR INSTALLATION TOOL. INSERT IS DESIGNED TO STOP AT CORRECT DEPTH.
 - 10.4 DRIVE LOCKING KEES DOWN USING THE INSTALLATION TOOL.
11. REMOVAL PROCEDURES:
 - 11.1 USE THE DRILL SIZES AND DEPTHS SPECIFIED IN TABLE II TO REMOVE MATERIAL BETWEEN THE KEES.
 - 11.2 DEFLECT KEES INWARD AND BREAK OFF.
 - 11.3 REMOVE INSERT WITH AN "EASY OUT" TYPE TOOL.
12. CONSULT FAIRCHILD'S ENGINEERING DEPARTMENT FOR AVAILABILITY OF OPTIONAL MATERIALS, FINISHES AND SIZES.

APPROVED DATE MS 10/23/96	Fairchild AEROSPACE FASTENER DIVISION ENGINEERING CENTER 3000 WEST LOMITA BOULEVARD TORRANCE, CA 90505	CASE CODE 29372 TRIDAIR PRODUCT 95-083 91-151
REV. LETTER AND DATE D 23 OCT 96	KEENSERT INSERT, EXTRA HEAVY DUTY SELF-BROACHING	TR29001-()
ECN NUMBER ECN 36578		SHEET 2 OF 3

SCANNED

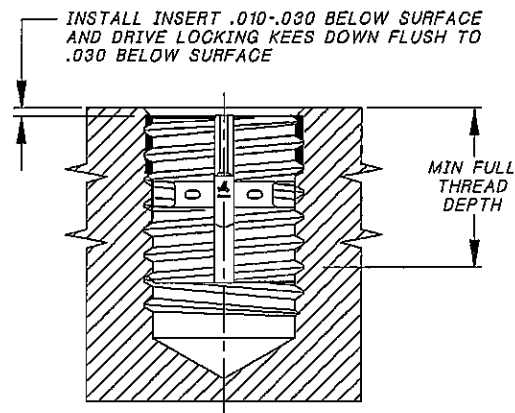
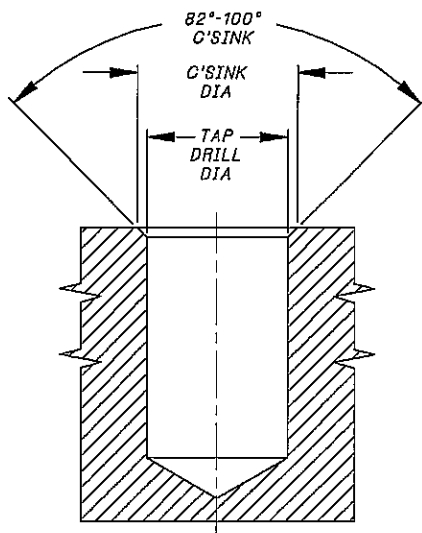


TABLE II

-()	INSTALLATION DATA					REMOVAL DATA	
	TAP DRILL DIA	C'SINK DIA	TAP SIZE	MIN FULL THREAD DEPTH	NOSEPIECE INSTALLATION TOOL PART NO.	DRILL SIZE	DEPTH
-101	.401	.457	.4375-14UNC-2B	.370	70947ASBK-101XH	.343	.130
-201	.396	.447			70947ASBK-201XH		
-102	.457	.520	.5000-13UNC-2B	.440	70947ASBK-102XH	.406	.190
-202	.452	.510			70947ASBK-202XH		
-103	.521	.582	.5625-12UNC-2B	.500	70955ASBK-103XH	.468	.190
-203	.515	.572			70955ASBK-203XH		
-104	.583	.645	.6250-11UNC-2B	.560	70955ASBK-104XH	.531	.190
-204	.577	.635			70955ASBK-204XH		
-105	.646	.710	.6875-11NS-2B	.680	70955ASBK-105XH	.593	.190
-205	.640	.700			70955ASBK-205XH		
-106	.771	.832	.8125-16UN-2B	.750	70955ASBK-106XH	.718	.190
-206	.765	.822			70955ASBK-206XH		
-107	.833	.895	.8750-14UNF-2B	.940	70955ASBK-107XH	.781	.190
-207	.827	.885			70955ASBK-207XH		

APPROVED DATE

mB 10/23/96

REV. LETTER AND DATE

D 23 OCT 96

ECN NUMBER

ECN 36578


AEROSPACE FASTENER DIVISION
ENGINEERING CENTER
3000 WEST LOMITA BOULEVARD
TORRANCE, CA 90505

95-083
91-151

CAGE CODE 29372

TRIDAIR PRODUCT

KEENSERT INSERT,
EXTRA HEAVY DUTY
SELF-BROACHING

TR29001-()

SHEET 3 OF 3

SCANNED