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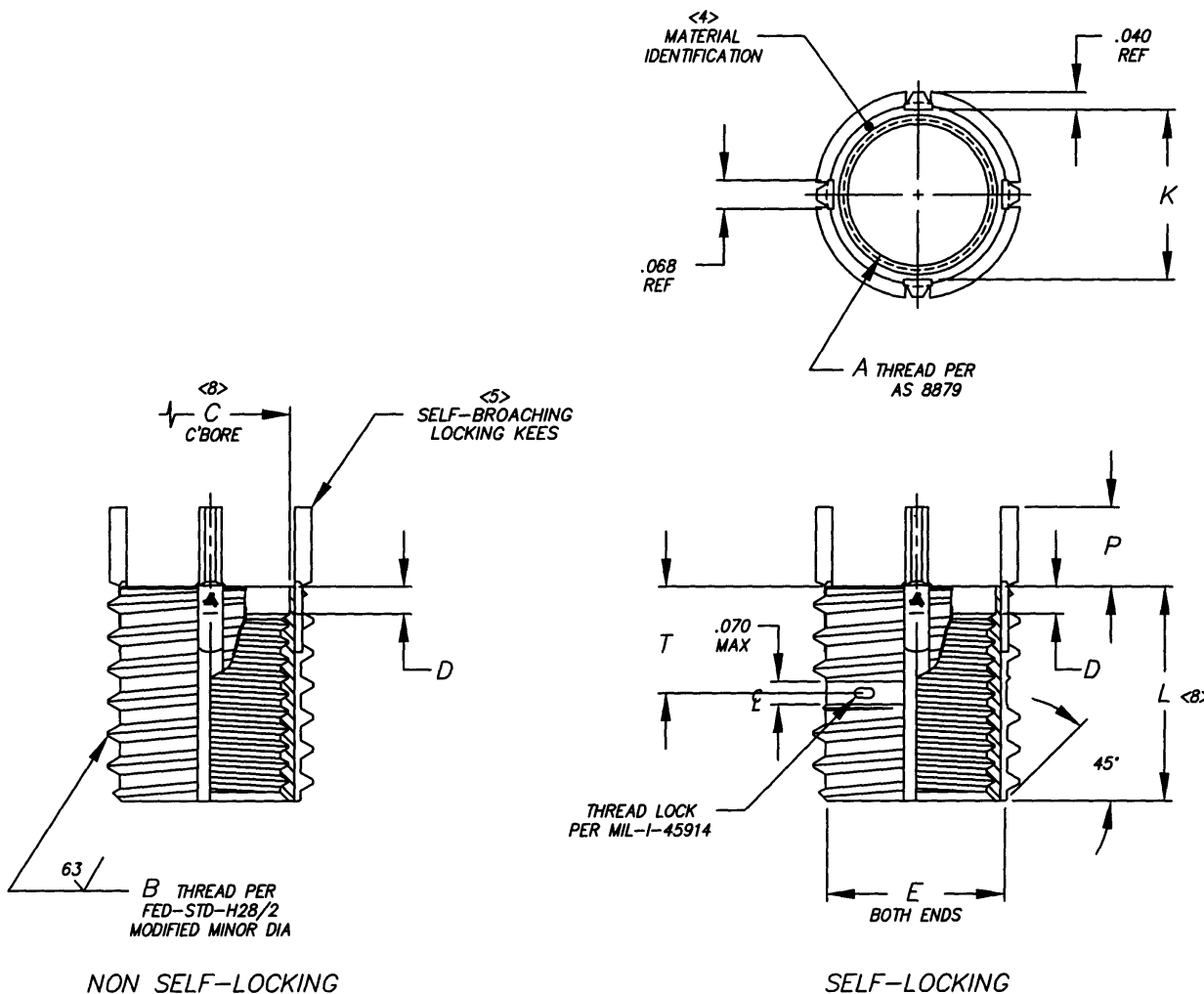


TABLE 1

-()	A THREAD	B THREAD		C DIA ±.005	D ±.010	E DIA REF	K ±.004	L ±.015	P ±.015	T ±.030
		SIZE	MINOR DIA							
-201	.1900-32UNF-3B	.3125-18UNC-2A	.256 .249	.196	.070	.250	.220	.312	.160	.220
-202	.2500-28UNF-3B	.3750-16UNC-2A	.320 .312	.257	.070	.310	.284	.375	.190	.220
-203	.3125-24UNF-3B	.4375-14UNC-2A	.383 .375	.316	.070	.375	.345	.437	.190	.220
-204	.3750-24UNF-3B	.5000-13UNC-2A	.440 .432	.380	.070	.430	.407	.500	.190	.240
-205	.4375-20UNF-3B	.5625-12UNC-2A	.503 .495	.445	.070	.495	.469	.562	.190	.270
-206	.5000-20UNF-3B	.6250-11UNC-2A	.565 .551	.507	.070	.550	.532	.625	.190	.280
-207	.5625-18UNF-3B	.7500-16UNF-2A	.690 .682	.580	.100	.680	.657	.750	.190	.307

INTERIM DOCUMENT REVISION		
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APPROVED DATE

9/24/99

REV. LETTER AND DATE

H1 11/10/01 CA

DAF NUMBER

65501

CURRENT DESIGN ACTIVITY:



ARCONIC

Arconic Fastening Systems

FAIRCHILD FASTENERS
Tridair Products
3000 WEST LONITA BOULEVARD
TOMBRAVE, CA 95065-3103

95-083
94-063

TITLE:

KEENSERT INSERT,
LIGHTWEIGHT
SELF-BROACHING

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES &
ASME Y14.5M TOLERANCES:

ANGLES
DECIMALS

.X = ± .2
.XX = ± .02
.XXX = ± .015

CURRENT DESIGN ACTIVITY:

CAGE CODE: 29372

SALES DRAWING NO.

TR29006-()

SHEET 1 OF 3

S42429

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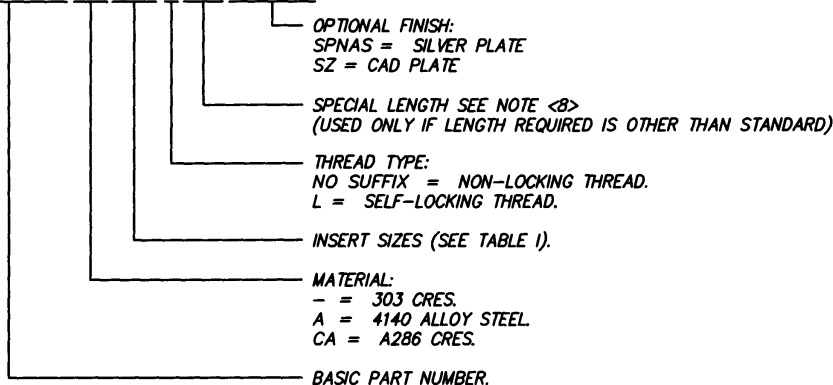
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NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
 - 1.1 INSERT= 4140 ALLOY STEEL PER AMS 5626.
A286 CRES PER AMS5737.
303 PER AMS 5640 OR ASTM-A-582.
 - 1.2 LOCKING KEES= 420 CRES PER AMS-QQ-S-763. (CHEMISTRY ONLY)
2. HEAT TREAT:
 - 2.1 INSERT= 4140 ALLOY STEEL: 160-180 KSI PER AMS 2759. (HRC 36-40)
 - 2.2 LOCKING KEES= HRC 54 MIN.
3. FINISH:
 - 3.1 INSERT= 4140 ALLOY STEEL: CAD PLATE PER AMS-QQ-P-416 TYPE II, CLASS 3.
A286 CRES & 303 CRES= PASSIVATE PER AMS-QQ-P-35.
 - 3.2 LOCKING KEES= PASSIVATE PER AMS-QQ-P-35. (LOCKING KEES MAY OR MAY NOT BE PLATED OR LUBRICATED)
 - 3.3 OPTIONAL FINISH: SPNAS: SILVER PLATE PER AMS2410. (A286 CRES & 303 CRES MATERIALS ONLY)
SZ: CAD PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2. (ALLOY STEEL MATERIAL ONLY).
 - 3.4 LUBRICATION= INSERTS WITH SELF-LOCKING INTERNAL THREADS HAVE DRY FILM LUBE PER AS 5272, 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 -201 AND -202 SIZES ARE FURNISHED WITH 2 LOCKING KEES, INSERT DASH NUMBERS -203 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:


TR29006CA201 L-12SPNAS



- <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, SILVER PLATE 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.

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APPROVED DATE 9/24/99	CURRENT DESIGN ACTIVITY:  ARCONIC	TITLE: KEENSERT INSERT, LIGHTWEIGHT SELF-BROACHING	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372
REV. LETTER AND DATE H 11/10/04-FA	Arconic Fastening Systems		SALES DRAWING NO.
DAF NUMBER 85597	FAIRCHILD FASTENERS Tridair Products 3000 WEST LOMITA BOULEVARD TORRANCE, CA 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	TR29006-() SHEET 2 OF 3

ANGLES .X = ± 2°
DECIMALS .XX = ± .02
.XXX = ± .015

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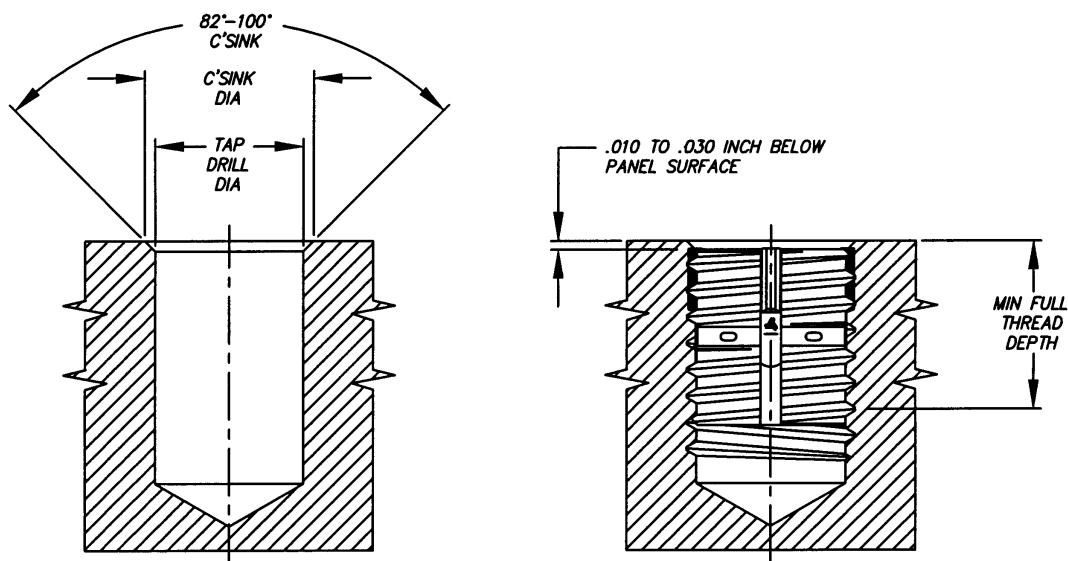



TABLE II

-()	INSTALLATION DATA					REMOVAL DATA	
	TAP DRILL DIA	C'SINK DIA	TAP SIZE	MIN FULL THREAD DEPTH	NOSEPIECE INSTALLATION TOOL PART NO.	DRILL	
						SIZE	DEPTH
-201	.276 .271	.333 .323	.3125-18UNC-2B	.370	70947ASBK-201	.218	.160
-202	.336 .331	.395 .385	.3750-16UNC-2B	.430	70947ASBK-202	.281	.190
-203	.401 .396	.457 .447	.4375-14UNC-2B	.500	70947ASBK-203	.343	.190
-204	.457 .452	.520 .510	.5000-13UNC-2B	.560	70947ASBK-204	.406	.190
-205	.521 .515	.582 .572	.5625-12UNC-2B	.620	70955ASBK-205	.468	.190
-206	.583 .577	.645 .635	.6250-11UNC-2B	.680	70955ASBK-206	.531	.190
-207	.708 .702	.770 .760	.7500-16UNF-2B	.810	70955ASBK-207	.656	.190

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APPROVED DATE 9/24/99	 ARCONIC Arconic Fastening Systems	TITLE: KEENSERT INSERT, LIGHTWEIGHT SELF-BROACHING	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372
REV. LETTER AND DATE H1 11/10/01 ECA			SALES DRAWING NO.
DAF NUMBER 65504	FAIRCHILD FASTENERS Tridair Products 3000 WEST LOMITA BOULEVARD TORRANCE, CA 90505-5103	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	ANGLES .X = ± 2° DECIMALS .XX = ± .02 .XXX = ± .015

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