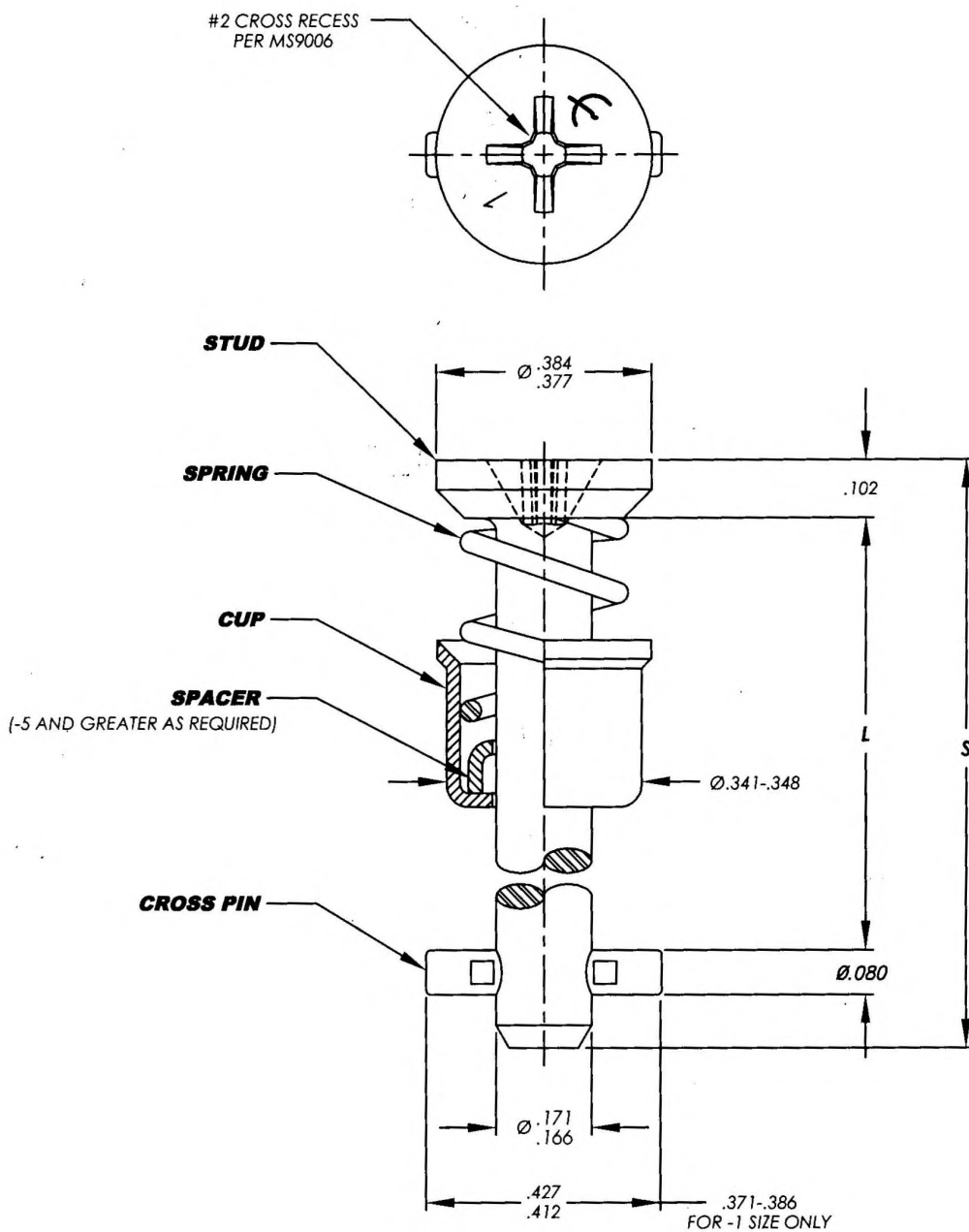


MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED

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Rev.	Date	DAF#
AC1	10/8/2018	117431

NOTES: UNLESS OTHERWISE SPECIFIED:

- CROSS PIN WILL WITHSTAND A PUSHOUT FORCE OF 175 LBS FOR STEEL PARTS AND 50 LBS FOR CRES PARTS RETAIN SYMMETRICALLY ABOUT CENTERLINE OF STUD WITHIN ±.02.
- FOR STUD SELECTION AND INSTALLATION DATA, SEE CAMLOC CATALOG 4002 SERIES.

<3> SUFFIX "X" ONLY AVAILABLE FOR SUFFIX " NONE" AND " S" FOR DASH NUMBERS 3, 4, 5 & 6. HEAD MARK SHALL INCLUDE AN " X" SUFFIX " X" PARTS ARE .015 LONGER THAN STANDARD PARTS AND ARE INTENDED FOR USE WHEN PANEL THICKNESS CROSSES TABULATED VALUES IN CATALOG.

APPROVED DATE 8 OCT 52	 ARCONIC Arconic Fastening Systems CAMLOC PRODUCTS 3012 WEST LOMITA BLVD. TORRANCE, CA 90505-5103	TITLE: STUD ASSEMBLY FLAT HEAD CROSS RECESS	CURRENT DESIGN ACTIVITY: CAGE CODE: 7 1 2 8 6
REV. LETTER AND DATE AC 9 APR 13		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO. 40S5
DAF NUMBER 104100		ANGLES = ± 1° FRACTIONS = ± 1/32 DECIMALS .XX = ± .02 .XXX = ± .010	SHEET 1 OF 2

MATERIAL SPECIFICATIONS:

FOR STEEL ASSEMBLY:

- CROSS PIN: MUSIC WIRE PER ASTM A228.
- SPACER: CARBON STEEL PER ASTM A109, A682 OR, A684.
- SPRING: MUSIC WIRE PER ASTM A228.
- CUP: CARBON STEEL PER ASTM A684.
- STUD: 4037 STEEL PER AMS6300, ASTM A331, ASTM A322, ASTM A752 OR 1008-1010 STEEL PER ASTM A108.

FOR STAINLESS STEEL ASSEMBLY:

- CROSS PIN: 302 CRES PER ASTM A313 OR AMS-QQ-S-763
- SPACER: 300 SERIES CRES PER ASTM A666 OR ASTM A240.
- SPRING: 302 CRES PER ASTM A313 OR AMS-QQ-S-763.
- CUP: 300 SERIES CRES PER ASTM A167, ASTM A240, ASTM A582, OR ASTM A666
- STUD: 300 SERIES CRES PER ASTM A276, ASTM A580 OR AMS-QQ-S-763.

PART NO. CALLOUT:

40S5-() ()

SUFFIX	MATERIAL	FINISH
NONE <3>	STEEL	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, WITH YELLOW CHROMATE
B		STUD AND CUP: NICKEL PLATE PER AMS-QQ-N-290, CLASS 1 GRADE F SPACER, CROSS PIN AND SPRING: ZINC PLATED
C		ZINC PLATE PER ASTM B633, CLASS 5, TYPE III, WITH CLEAR CHROMATE
D		ZINC PLATE PER ASTM B633, CLASS 5, TYPE II, WITH YELLOW CHROMATE
S <3>	STAINLESS STEEL	PASSIVATE PER ASTM A967 (NITRIC) OR AMS 2700.

DASH NUMBER	L	S	APPROX. WEIGHT		DASH NUMBER	L	S	APPROX. WEIGHT	
			STEEL LB/100	CRES LB/100				STEEL LB/100	CRES LB/100
1	.383-.393	.66	.94	.95	9	.623-.633	.90	1.09	1.10
2	.413-.423	.69	.96	.97	10	.653-.663	.93	1.11	1.12
3	.443-.453	.72	.98	.99	11	.683-.693	.96	1.13	1.14
3X <3>	.458-.468	.74	.99	1.00	12	.713-.723	.99	1.15	1.16
4	.473-.483	.75	1.00	1.01	13	.743-.753	1.02	1.17	1.18
4X <3>	.488-.498	.77	1.01	1.02	14	.773-.783	1.05	1.19	1.20
5	.503-.513	.78	1.02	1.03	15	.803-.813	1.08	1.21	1.22
5X <3>	.518-.528	.80	1.03	1.04	16	.833-.843	1.11	1.23	1.24
6	.533-.543	.81	1.04	1.05	17	.863-.873	1.14	1.25	1.26
6X <3>	.548-.558	.83	1.05	1.06	18	.893-.903	1.17	1.27	1.28
7	.563-.573	.84	1.06	1.07	19	.923-.933	1.20	1.29	1.30
8	.593-.603	.87	1.07	1.08	20	.953-.963	1.23	1.31	1.32

FOR DASH NUMBER NOT SHOWN IN TABLE USE:

"L" MIN = .353 + (.030 x DASH NUMBER)

"L" MAX = "L" MIN + .010

"S" = .630 + (.030 x DASH NUMBER)

WT-LB/100 FOR STEEL:

.92 + (.0193 x DASH NO.)


WT-LB/100 FOR STAINLESS STEEL:

.93 + (.0193 x DASH NO.)

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			SHEET 2 OF 2