

Spec. CHV TC

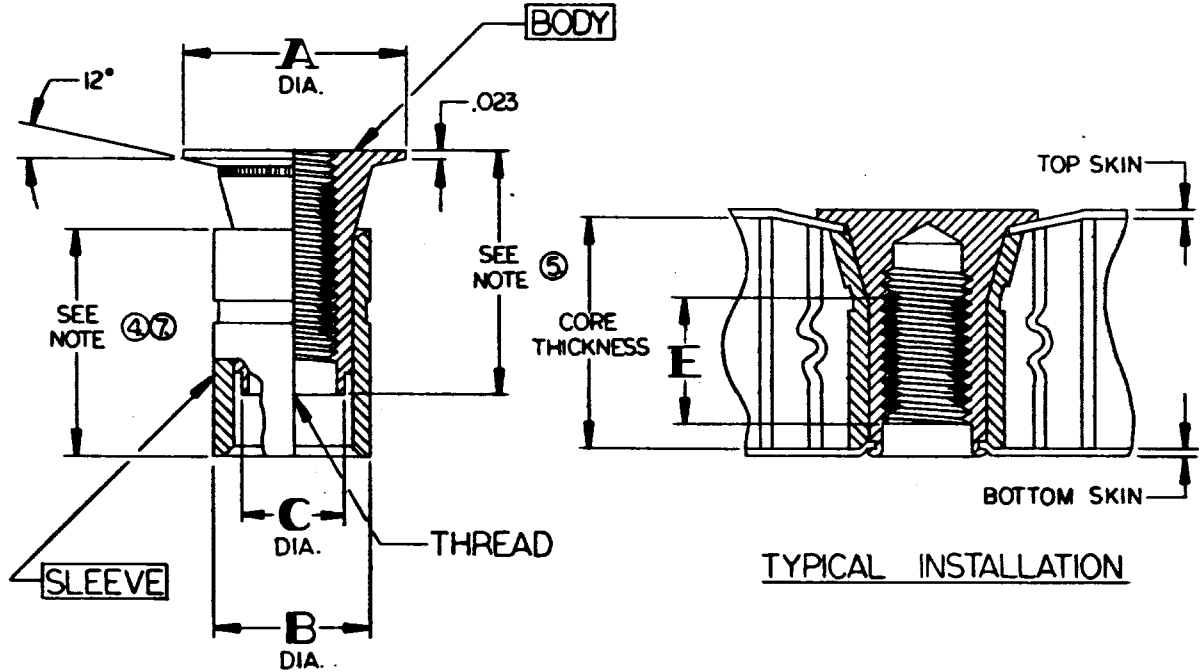
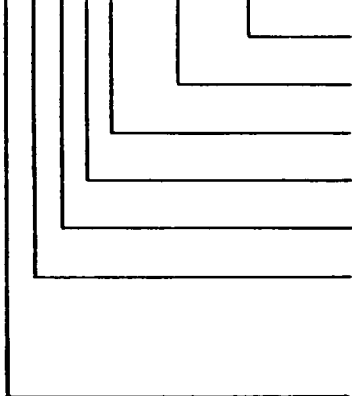


TABLE I

SIZE CODE	THREAD SIZE PER MIL-S-8879	A	B	C
1	.1380-32 UNJC-3B	.562	.375	.225
2	.1640-32 UNJC-3B	.625	.437	.290
3	.1900-32 UNJF-3B	.625	.437	.290
4	.2500-28 UNJF-3B	.687	.500	.356
5	.3125-24 UNJF-3B	.750	.562	.418

BASIC PART NO. CODE:

606D3-49 F52



BODY DASH NUMBER (SEE NOTE ⑤, TABLE II)

SLEEVE DASH NUMBER (SEE NOTE ④ ⑦)

THREAD SIZE (SEE TABLE 1)

HEAD STYLE: D = STANDARD FLUSH

TYPE: THREADED WITH SELF-LOCKING HELICAL COIL INSERT PER MS 21209

MATERIAL: 0 = ALUMINUM ALLOY - ALODINE

6 = CRES STEEL - PASSIVATE

9 = CARBON STEEL - CADMIUM PLATE

SERIES PREFIX

(WAS DWG. NO. 2005)

DRAWING PROVIDES FORM, FIT AND FUNCTION DATA. DO NOT ATTEMPT TO MANUFACTURE PRODUCT USING THIS DRAWING.

Delron Inserts		TITLE: FASTENER - SELF-LOCKING FLARED TYPE		Tridair <small>a Rexnord Company</small> 3000 W. Lomita Blvd. Torrance, CA 90505 213/530-2220	
DRAWN BY: DNE SATOW MFG. ENGRG:	DATE: 10-29-81 DATE:	UNLESS OTHERWISE SPECIFIED: TOLERANCES: DECIMALS: XX ± .02 .XXX ± .010 ANGLES: ± 2°		606D FLARED SERIES	
APPROVED BY: <i>[Signature]</i> PROJECT NUMBER:	DATE: 2-18-82	SURFACE FINISH: 125 MICRONS		FSC: 29372 SHEET 1 OF 4	

REVISION A ELD 7272 10-5-81 D ELD 14507 2-18-85

CHV TC

NOTES:

1. MATERIAL:
 - 1.1 ALUMINUM ALLOY: BODY = 2024-T4 PER QQ-A-225/6.
SLEEVE = 6061-T6 PER WW-T-700/6.
 - 1.2 CRES STEEL - PER ASTM-A-582/AMS5640.
 - 1.3 CARBON STEEL - PER FED-STD-66/ASTM-A-108.
2. FINISH:
 - 2.1 ALUMINUM ALLOY - ALODINE PER MIL-C-5541.
 - 2.2 CRES STEEL - PASSIVATE PER QQ-P-35.
 - 2.3 CARBON STEEL - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
3. NOT RECOMMENDED FOR TOP SKIN THICKNESS GREATER THAN .030.
- ④ TO DETERMINE SLEEVE DASH NUMBER: CORE THICKNESS ROUNDED TO THE NEAREST HUNDREDTH OF AN INCH.
EXAMPLE: IF CORE IS .494 SLEEVE DASH NUMBER WILL BE -49.
- ⑤ TO DETERMINE BODY DASH NUMBER, SELECT BODY DASH NUMBER FROM TABLE II ACCORDING TO OVERALL PANEL THICKNESS.
EXAMPLE: IF OVERALL PANEL THICKNESS IS .524, BODY DASH NUMBER WILL BE F52.
6. CONSULT TRIDAIR ENGINEERING DEPARTMENT FOR AVAILABILITY OF OPTIONAL MATERIAL, FINISHES AND SIZES.
- ⑦ FOR INSPECTION: ACTUAL SLEEVE LENGTH WILL BE .010-.015 SHORTER THAN THE CONVERTED DASH NUMBER. EXAMPLE: -49 = .490. ACTUAL LENGTH = .475-.480.

TABLE II

BODY NO.	PANEL THICKNESS	BODY NO.	PANEL THICKNESS	BODY NO.	PANEL THICKNESS
F25	.250-.259	F51	.510-.519	F77	.770-.779
F26	.260-.269	F52	.520-.529	F78	.780-.789
F27	.270-.279	F53	.530-.539	F79	.790-.799
F28	.280-.289	F54	.540-.549	F80	.800-.809
F29	.290-.299	F55	.550-.559	F81	.810-.819
F30	.300-.309	F56	.560-.569	F82	.820-.829
F31	.310-.319	F57	.570-.579	F83	.830-.839
F32	.320-.329	F58	.580-.589	F84	.840-.849
F33	.330-.339	F59	.590-.599	F85	.850-.859
F34	.340-.349	F60	.600-.609	F86	.860-.869
F35	.350-.359	F61	.610-.619	F87	.870-.879
F36	.360-.369	F62	.620-.629	F88	.880-.889
F37	.370-.379	F63	.630-.639	F89	.890-.899
F38	.380-.389	F64	.640-.649	F90	.900-.909
F39	.390-.399	F65	.650-.659	F91	.910-.919
F40	.400-.409	F66	.660-.669	F92	.920-.929
F41	.410-.419	F67	.670-.679	F93	.930-.939
F42	.420-.429	F68	.680-.689	F94	.940-.949
F43	.430-.439	F69	.690-.699	F95	.950-.959
F44	.440-.449	F70	.700-.709	F96	.960-.969
F45	.450-.459	F71	.710-.719	F97	.970-.979
F46	.460-.469	F72	.720-.729	F98	.980-.989
F47	.470-.479	F73	.730-.739	F99	.990-.999
F48	.480-.489	F74	.740-.749	F100	1.000-1.009
F49	.490-.499	F75	.750-.759	F101	1.010-1.019
F50	.500-.509	F76	.760-.769	F102	1.020-1.029

DRAWING PROVIDES FORM, FIT AND FUNCTION DATA. DO NOT ATTEMPT TO MANUFACTURE PRODUCT USING THIS DRAWING.

		TITLE:			
DRAWN BY: DAVE SATZ DATE: 11-3-81		FASTENER - SPECIFICATIONS		a Rexnord Company 3000 W. Lomita Blvd. Torrance, CA 90505 213/530-2200	
MFG. ENGRG.: DATE:		UNLESS OTHERWISE SPECIFIED: TOLERANCES: DECIMALS: XX ± .02 XXX ± .010 ANGLES: ± 2°		606D FLARED SERIES	
APPROVED BY: <i>[Signature]</i> DATE: 2-18-82		MILLIMETERS ± 0.50 ± 0.25		SURFACE FINISH 125 MICROINCHES	
PROJECT NUMBER:		FSC: 29372		SHEET 2 OF 4	

REVISION A E2D 7272 11-5-81 B

TABLE III

BODY NO	E MIN. FULL THREAD				
	6-32 1	8-32 2	10-32 3	1/4-28 4	5/16-24 5
F31	THRU	NA	NA	NA	NA
F32	↑	NA	NA	NA	NA
F33		NA	NA	NA	NA
F34		THRU	NA	NA	NA
F35		↑	NA	NA	NA
F36			THRU	NA	NA
F37	↓		↑	NA	NA
F38	THD.			NA	NA
F39	.138			NA	NA
F40	↑			NA	NA
F41				NA	NA
F42		↓		NA	NA
F43		THD.	↓	THRU	NA
F44		.164	THD.	↑	NA
F45	↓	↑	.190	↑	NA
F46	.138		↑		NA
F47	.207				NA
F48	↑				NA
F49		↓			THRU
F50		.164			↑
F51		.246			
F52	↓	↑			
F53	.207				
F54	.276		↓	↓	
F55	↑		.190	THD.	
F56			.285	.250	
F57		↓	↑	↑	
F58		.246			
F59		.328			
F60		↑			
F61					
F62					
F63					
F64			↓		↓
F65	↓	↓	.285	↓	THD.
F66	.266	.328	.380	.250	.312

BODY NO	E MIN. FULL THREAD				
	6-32 1	8-32 2	10-32 3	1/4-28 4	5/16-24 5
F67	.276	.328	.380	.250	.312
F68	↑	↑	↑	.375	↑
F69				↑	
F70					
F71					
F72					
F73					
F74					
F75					
F76					
F77					
F78					
F79				↓	
F80				.375	↓
F81				.500	.312
F82				↑	.469
F83					↑
F84					
F85					
F86					
F87					
F88					
F89					
F90					
F91					
F92					
F93					
F94					
F95					
F96					
F97					.469
F98					.625
F99					↑
F100					↑
F101	↓	↓	↓	↓	↓
F102	.276	.328	.380	.500	.625

⊘ DENOTES NOT AVAILABLE

NOTES:

1. WHEN THRU-THREAD IS REQUIRED BUT NOT STANDARD ADD "T" TO BODY LENGTH. EXAMPLE = FT52.
2. DIMENSIONS IN TABLE III ARE ACTUAL MINIMUM FULL THREAD LENGTHS FOR GIVEN THREAD SIZE AND BODY LENGTHS.

DRAWING PROVIDES FORM, FIT AND FUNCTION DATA. DO NOT ATTEMPT TO MANUFACTURE PRODUCT USING THIS DRAWING.

		TITLE: FASTENER - MIN. FULL THREAD				a Ramrod Company 3000 W. Louisa Blvd. Torrance, CA 90505 713/530-2220	
DRAWN BY: DVE SATOW	DATE: 11-11-81					606D FLARED SERIES	
MFG. ENGRG.:	DATE:					FSC: 29372	
APPROVED BY: 	DATE: 2-18-82	UNLESS OTHERWISE SPECIFIED: TOLERANCES: DECIMALS: XX ± .02 XXX ± .010 ANGLES: ± 2°		MILLIMETERS ± 0.50 ± 0.25		SURFACE FINISH 125 MICRONS	
PROJECT NUMBER:						SHEET 3 OF 4	

REVISION A ECO 7272 11-11-81

INSTALLATION PROCEDURE

1. PANEL PREPARATION:

PREPARING PANELS FOR THE FLARED TYPE STRUCTURAL FASTENERS CAN EITHER BE ACCOMPLISHED WITH A STEP DRILL OR STANDARD DRILL AND COUNTERBORE OPERATION AS SHOWN IN FIGURE 1.

IF THE BOTTOM COVER SHEET EXCEEDS .032" THICK, AN ADDITIONAL EXTERNAL SPOTFACING OPERATION IS REQUIRED. SEE INSTALLATION DRILL SIZE TABLE FOR CORRECT DRILL, COUNTERBORE AND SPOTFACE DIAMETERS.

2. POSITION PANEL OVER ALIGNMENT TOOL WITH THE GUIDE ANVIL PROJECTING THROUGH THE PILOT HOLE. SEE FIGURE 2.

3. POSITION FASTENER IN PREPARED HOLE AND APPLY PRESSURE WITH THE PRESSING ANVIL UNTIL THE FASTENER HEAD BECOMES FLUSH WITH THE TOP SKIN. FIGURE 3.

4. REPLACE ALIGNMENT TOOL WITH FLARING ANVIL AND AGAIN APPLY PRESSURE WITH PRESSING ANVIL UNTIL FLARING ANVIL BECOMES FLUSH WITH THE BOTTOM SKIN. FIGURE 4.

5. AFTER INSTALLATION, THE 600 FLARED SERIES FASTENERS ARE SELF-RETAINED AND PROVIDE A FLUSH CONDITION ON THE EXTERIOR SURFACES WHEN USING THE "D" HEAD STYLE. SINCE THE HEAD DIAMETER OF THE FASTENER HAS THE GREATEST AREA OF CONTACT, IT MAY CAUSE A SLIGHT SPRING BACK CONDITION. HOWEVER, WHEN THE COMPONENT IS BOLTED DOWN TO THE PANEL, THE FASTENER WILL AGAIN BECOME FLUSH.

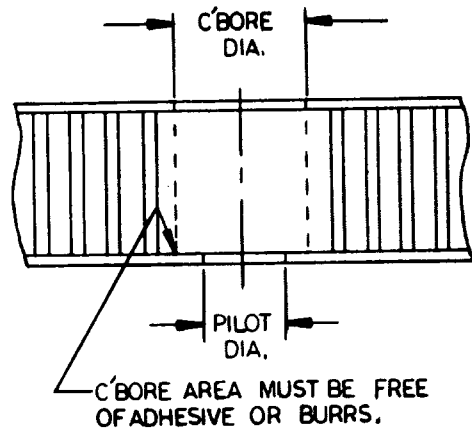


FIG. 1

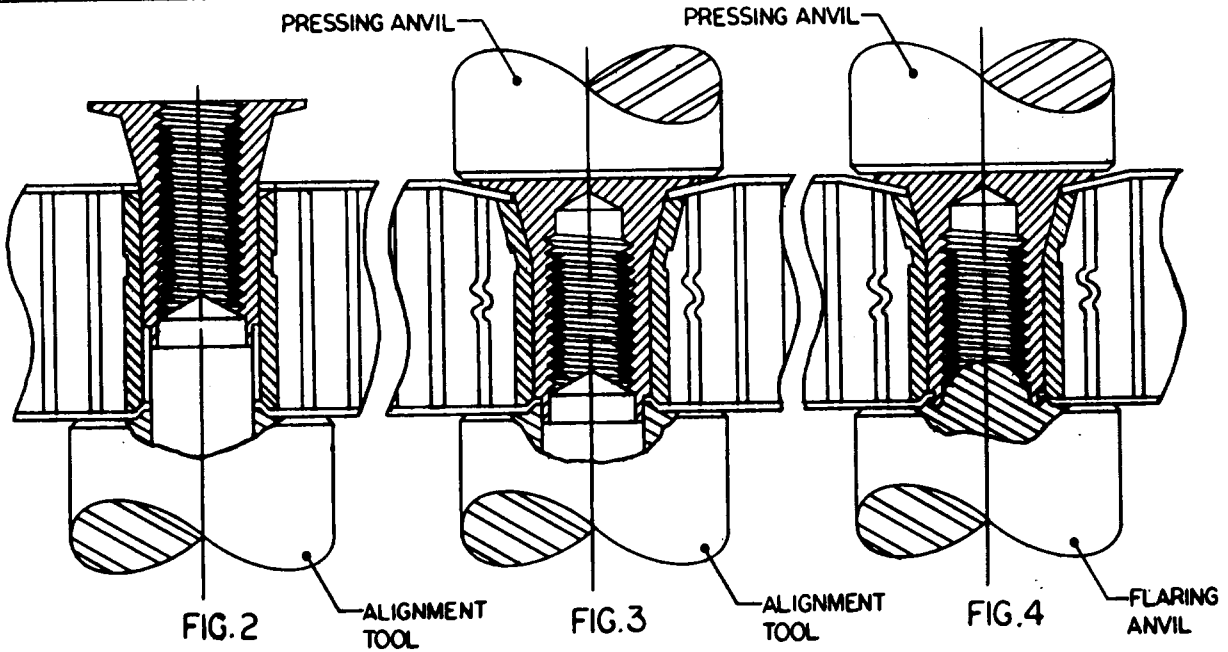


TABLE IV

SIZE CODE	INSTALLATION DRILL SIZE			INSTALLATION TOOL KIT
	PILOT DIA.	C'BORE DIA.	SPOTFACE DIA.	
1	.228-.233	.375-.385	.500	1632K2
2	.295-.300	.437-.447	.562	1632K4
3	.295-.300	.437-.447	.625	1632K4
4	.358-.363	.500-.510	.687	1632K5
5	.421-.426	.562-.572	.750	1632K6

DRAWING PROVIDES FORM, FIT AND FUNCTION DATA. DO NOT ATTEMPT TO MANUFACTURE PRODUCT USING THIS DRAWING.

Deltron <small>inserts</small>	
DRAWN BY: DAVE SATOW	DATE: 10-29-81
MPG. ENGRG:	DATE:
APPROVED BY: <i>[Signature]</i>	DATE: 8-20-82
PROJECT NUMBER:	

TITLE: **FASTENER INSTALLATION**

UNLESS OTHERWISE SPECIFIED:

TOLERANCES:	MILLIMETERS	SURFACE FINISH
DECIMALS: .XX ± .02	± 0.80	125 MICRONCHES
.XXX ± .010	± 0.25	
ANGLES: ± 2°		

Tridair a Remond Company
3000 W. Lomita Blvd.
Torrance, CA 90505
213/530-2220

606D FLARED SERIES

FSC: 29372 SHEET 4 OF 4

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