

Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi-Shan

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

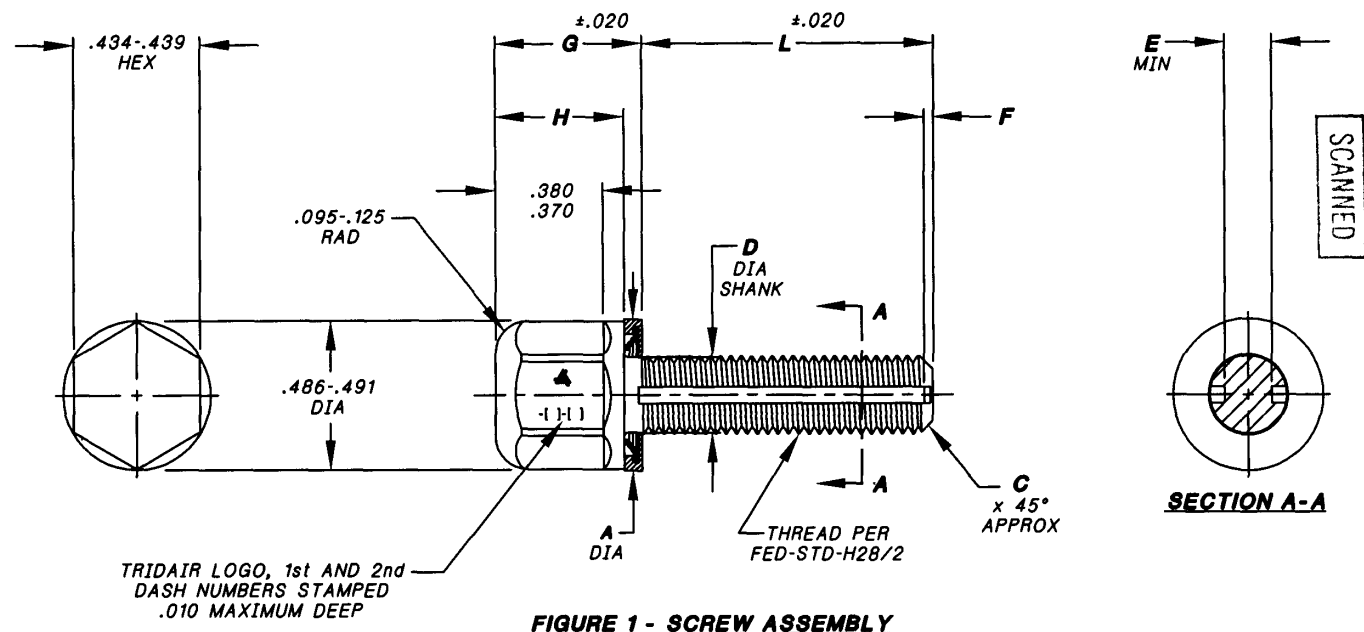


FIGURE 1 - SCREW ASSEMBLY

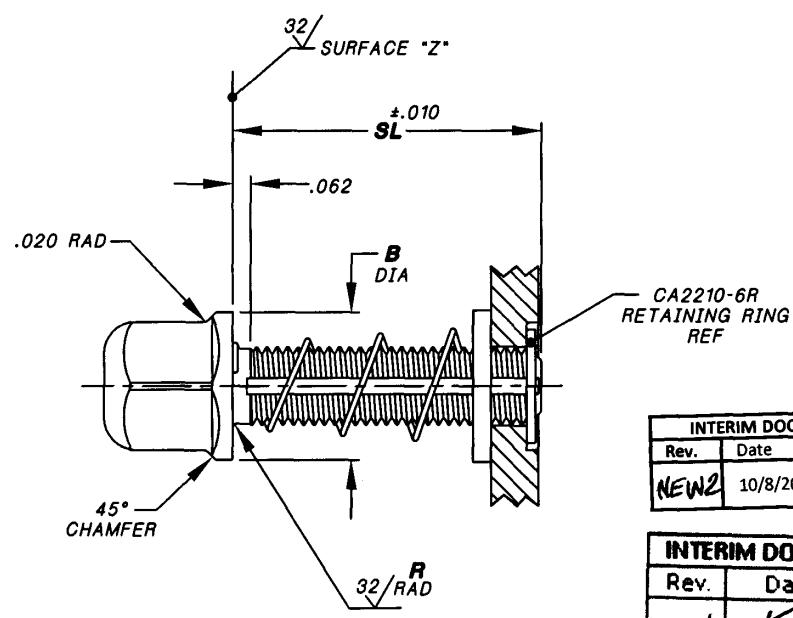


FIGURE 2 - INSTALLED AND RETRACTED <6>

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF#
NEW2	10/8/2018	117431

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF #
new1	10/21/10	94341

TABLE 1

FIRST DASH NUMBER	THREAD SIZE UNF-3A	A DIA	B DIA	C	D DIA	E MIN	F	G	H	R RAD	ULTIMATE TENSILE STRENGTH MIN (CALCULATED)	ULTIMATE SHEAR STRENGTH MIN (CALCULATED)
-6	.375-24	.750	.630 .620	.040	.3745 .3740	.268	.050	.567	.505	.025 .015	11,300 LBS.	7,300 LBS.

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APPROVED DATE 15 SEP 05	CURRENT DESIGN ACTIVITY: ARCONIC	TITLE: CAPTIVE SCREW ASSEMBLIES, SELF-RETRACTING 'CRIMPING' TYPE, EVA HEX HEAD, CRES, 180 KSI SOLID FILM LUBED THREADS	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372
REV. LETTER AND DATE NEW 15 SEP 05	Arconic Fastening Systems	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	SALES DRAWING NO.
DAF NUMBER DAF 69596	TRIDAIR PRODUCTS 3000 W. LOMITA BLVD. TORRANCE, CA 90505	ANGLES - ± 3° DECIMALS .XX - ± .02 .XXX - ± .010	CA22078-()-()

PROJECT NUMBER: 05-045

SCANNED

TABLE 2

SECOND DASH NUMBER	L	SL	SECOND DASH NUMBER	L	SL
-7	.437	.500	-18	1.125	1.187
-8	.500	.562	-19	1.187	1.250
-9	.562	.625	-20	1.250	1.312
-10	.625	.687	-21	1.312	1.375
-11	.687	.750	-22	1.375	1.437
-12	.750	.812	-23	1.437	1.500
-13	.812	.875	-24	1.500	1.562
-14	.875	.937	-25	1.562	1.625
-15	.937	1.000	-26	1.625	1.687
-16	1.000	1.062	-27	1.687	1.750
-17	1.062	1.125	-28	1.750	1.812

NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
 - 1.1 SCREW: - A286 CRES PER AMS5731, AMS5732, AMS5734 OR AMS5737.
 - 1.2 HOUSING: - 300 SERIES CRES PER AMS5640, ASTM-A555, ASTM-A582.
 - 1.3 SPRING: - 302 CRES PER ASTM-A313.
2. HEAT TREAT:
 - 2.1 SCREW ONLY - 160,000 PSI MINIMUM TENSILE.
3. NO SHARP EDGES OR DEPRESSIONS (NICKS, GOUGES) OR RAISED SPURS OR STRIATIONS OBSERVABLE UNDER #10 POWER MAGNIFICATION AT PITCH CREST TO 50% OF CREST PERMITTED. BLEND OBSERVED DEPRESSIONS EDGES TO 32 MICROFINISH. REMOVE OBSERVED RAISED SPURS OR STRIATIONS UNTIL FLUSH WITH SURFACE OF THREAD TO 32 MICROINCH FINISH. SCREW MUST COMPLY WITH INSPECTION PROVISIONS OF ASME B1.3M SYSTEM 23. 100% INSPECTION REQUIRED.
4. FINISH:
 - 4.1 ALL COMPONENTS PASSIVATED PER AMS2700.
 - 4.2 SCREW: SOLID FILM LUBE THREAD AND SHANK PER BOEING SPECIFICATION RB0140-02B, TYPE II. OVERSPRAY PERMITTED ON "SURFACE Z".
5. PACKAGING AND IDENTIFICATION:
 - 5.1 PROTECT AND PACKAGE PARTS PER BOEING SPECIFICATION RA0116-030 METHOD J, TYPE I.
 - 5.2 PACKAGE IDENTIFY PER BOEING SPECIFICATION RF0004-044, TYPE XI.
6. PANEL PREPARATION: REFER TO DRAWING NUMBER CAL-STD-0260.
7. REFER TO DRAWING NUMBER CA2210T-() FOR INSTALLATION PROCEDURE AND REQUIRED TOOL.
- (8) ASSEMBLIES WITH L LENGTHS OVER 1.000 MAY NOT FULLY SELF-RETRACT.
9. PART CALLOUT EXAMPLE:
 - 9.1 CA22078-6-16
 - L = 1.000
 - .375-24 SIZE
 - BASIC PART NUMBER


11. TOLERANCES, UNLESS OTHERWISE SPECIFIED: DECIMALS .XX .02, .XXX .010, ANGLES 2 SURFACE FINISH 125 MICROINCHES Ra.

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INTERIM DOCUMENT REVISION		
Rev.	Date	DAF #
new1	10/4/10	94301

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APPROVED DATE 15 SEP 05	CURRENT DESIGN ACTIVITY:  ARCONIC Arconic Fastening Systems	TITLE: CAPTIVE SCREW ASSEMBLIES, SELF-RETRACTING "CRIMPING" TYPE, EVA HEX HEAD, CRES, 160 KSI SOLID FILM LUBED THREADS	CURRENT DESIGN ACTIVITY: CAGE CODE: 29372 SALES DRAWING NO.
REV. LETTER AND DATE NEW 15 SEP 05	TRIDAIR PRODUCTS 3000 W. LOMITA BLVD. TORRANCE, CA 90505	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES:	CA22078-()-()
DAF NUMBER DAF 69590		ANGLES = ± 3° DECIMALS .XX = ± .02 .XXX = ± .010	SHEET 2 OF 2

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