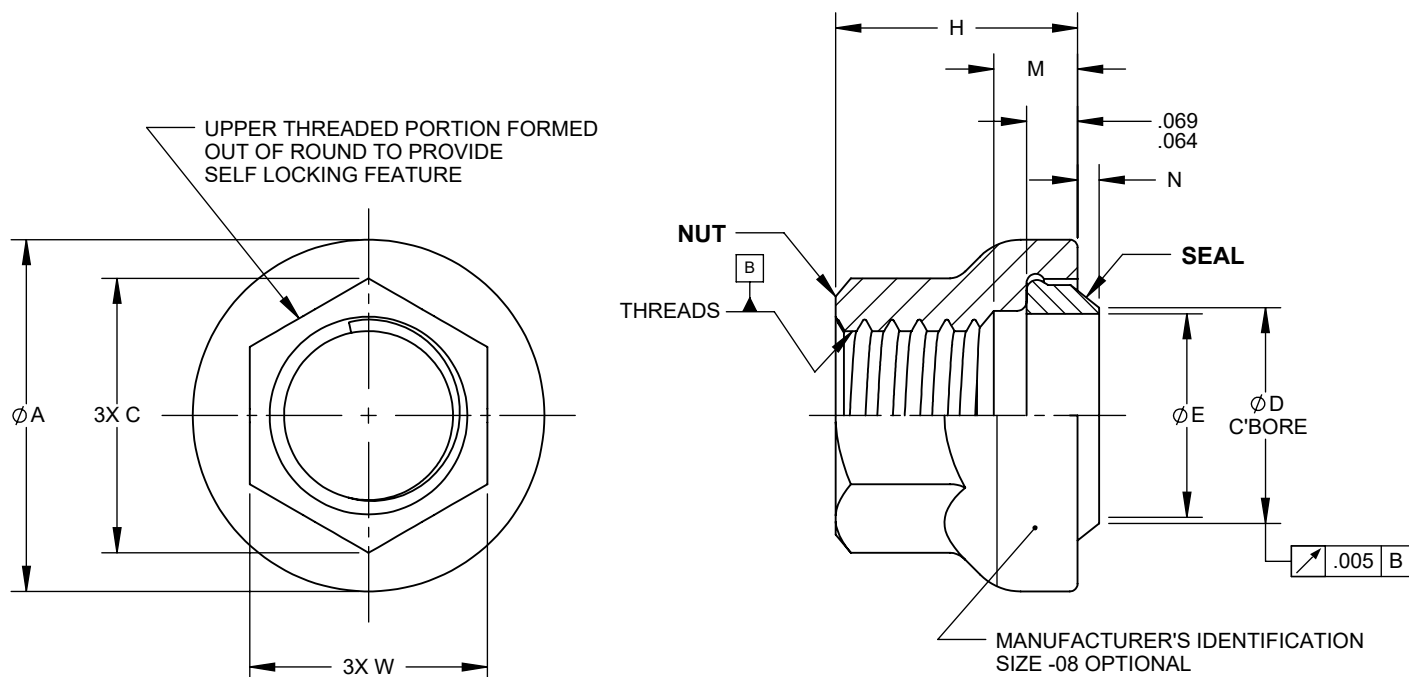


MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN CONSENT OF HOWMET FASTENING SYSTEMS IS ABSOLUTELY PROHIBITED.



HFS PART NO.		THREADS PER AS8879	Ø A MAX	C MIN	Ø D	Ø E	H MAX	M	N	W	AXIAL TENSILE STRENGTH lbf MIN	INSTALLATION TORQUE in-lbf	APPROX WEIGHT lbs/100
KFN556-	08	.1640-32UNJC-3B	.313	.244	.189 .186	.177 .164	.252	.092	.039 .019	.220 .212	2,800	20 - 30	.25
	3	.1900-32UNJF-3B	.348	.277	.208 .203	.203 .190	.260	.088	.041 .021	.251 .243	3,470	50 - 60	.29
	4	.2500-28UNJF-3B	.461	.347	.275 .270	.268 .254	.335	.111 .107	.045 .025	.313 .305	6,200	100 - 110	.46
	5	.3125-24UNJF-3B	.636	.419	.349 .344	.323 .318	.430	.127	.045 .035	.376 .367	10,200	130 - 160	.55
	6	.3750-24UNJF-3B	.720	.491	.416 .411	.391 .386	.470	.117	.055 .035	.439 .430	15,200	200 - 240	.90

MATERIAL:

NUT:

8740 ALLOY STEEL PER AMS6322 (UNS G87400) OR
4340 ALLOY STEEL PER AMS6415 (UNS G43406).

SEAL:

TEFLON, PER ASTM D1710.

HEAT TREAT:

NUT -- Rc 39-43 PER AMS-H-6875.

SEAL -- NONE.

FINISH:

NUT -- CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, PLUS
CETYL ALCOHOL LUBRICANT PER AS87132, GRADE OPTIONAL.
SEAL -- NONE.

PERFORMANCE:

KFS1009, EXCEPT AS FOLLOWS:

- A) LOCKING TORQUE LIMITED TO ONE SEATED CYCLE.
- B) AXIAL TENSILE STRENGTH AS TABULATED.
- C) MAXIMUM TEMPERATURE AS NOTED.

TEMPERATURE:

250°F.

NOTES:

- NUT DESIGN INCORPORATES POSITIVE RETENTION OF THE SEALING RING.
- PACKAGING:
PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING. ADD S AFTER DASH NUMBER FOR SPINDLED PACKAGED NUTS, FOR USE ON K-FAST™ AUTOMATIC TOOLS. EXAMPLE: KFN556-3S

THIRD ANGLE PROJECTION

EAR EXPORT CONTROLLED TECHNICAL DATA: DISTRIBUTION LIMITED TO U.S. PERSONS OR THOSE NON-U.S. PERSONS COVERED BY AN APPROPRIATE EXPORT LICENSE OR ALLOWED FOR BY THE APPROPRIATE REGULATIONS, ECCN: EAR99.

APPROVED DATE

16APR1982

REV. LETTER AND DATE:

D 06APR2020

CUSTOMER:

CURRENT DESIGN ACTIVITY:



Howmet Fastening Systems
800 S State College Boulevard
Fullerton, California, 92831

<http://www.hfs.howmet.com>

TITLE:

NUT - 6 POINT,
SELF SEALING, SELF LOCKING,
ASSEMBLY

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE
IN INCHES & TO ASME Y14.5-2018 TOLERANCES:
DECIMALS = $\pm .015$; ANGLES = $\pm 2^\circ$

CAGE CODE: 15653

SALES DRAWING No.

KFN556-(*)

SHEET 1 OF 2

FILED AS:

s_KFN556-()

SEALING PERFORMANCE:

NUTS SHALL SEAL AGAINST PRESSURE APPLIED TO THE INSTALLED FASTENERS, USING JP-5 AS A TEST FLUID, WHEN INSTALLED AND TESTED UNDER THE FOLLOWING CONDITIONS:

- A) HLT114 OR HLT116 PINS SHALL BE USED FOR TESTING, THE HOLES SHALL BE AT LEAST .002 INCHES LARGER IN DIAMETER THAN THE PIN, AND THE PINS SHALL BE INSTALLED IN SUCH A MANNER AS TO PROVIDE AN UNOBSTRUCTED LEAK PATH TO THE SEALING ELEMENT OF THE NUT. THE SURFACE UPON WHICH THE NUT BEARS SHALL BE INCLINED AT LEAST 2 DEGREES FROM PERPENDICULAR TO THE AXIS OF THE NUT. TESTS SHALL BE CONDUCTED WITH PIN PROTRUSIONS AND NUT INSTALLATION TORQUES CONFORMING TO THE FOLLOWING TABLE.

NOMINAL DIAMETER	PIN PROTRUSION (INCH)		INSTALLATION TORQUE in-lbf
	+.000 -.016	+.016 -.000	
.1640	.302	.384	20 - 30
.1900	.315	.397	50 - 60
.2500	.385	.467	100 - 110

- B) INSTALLED NUTS SHALL BE SUBJECTED TO A STATIC PRESSURE OF 15-17 PSIG FOR A PERIOD OF 5 MINUTES MINIMUM FOLLOWED BY CYCLING THE PRESSURE FROM 0 TO 15 PSIG FOR 100 CYCLES. THE 15 PSIG STATIC PRESSURE SHALL THEN BE REAPPLIED AND MAINTAINED FOR A PERIOD OF 4 HOURS MINIMUM. NO LEAKS, AS DETERMINED BY VISUAL EXAMINATION, ARE PERMITTED.

THIRD ANGLE
PROJECTION

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DECIMALS = ±.015; ANGLES = ±2°

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SALES DRAWING No.

KFN556-()

SHEET 2 OF 2