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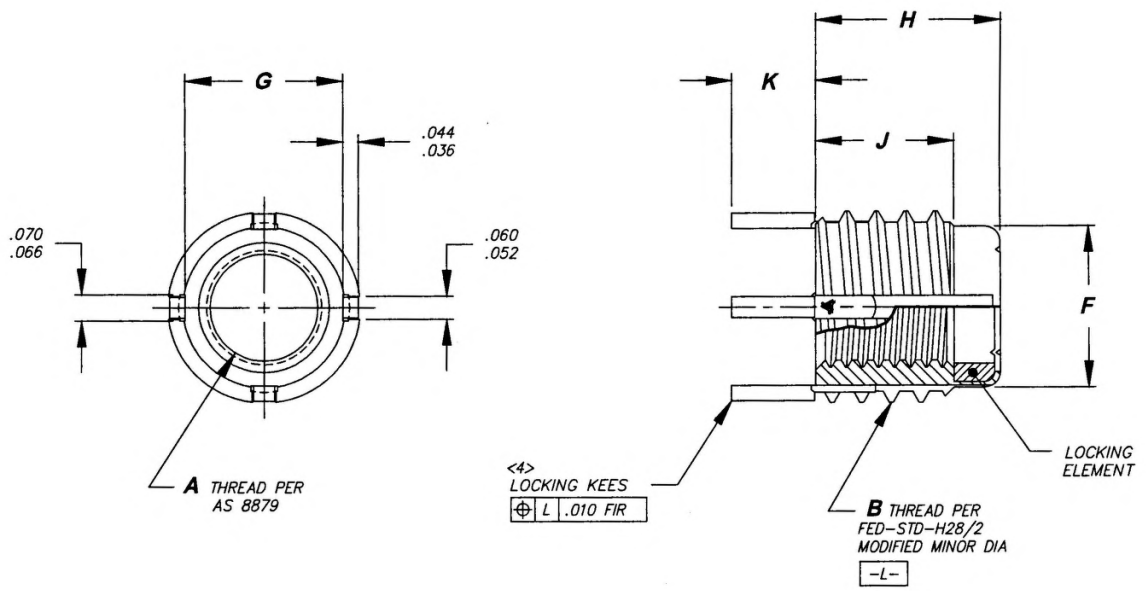


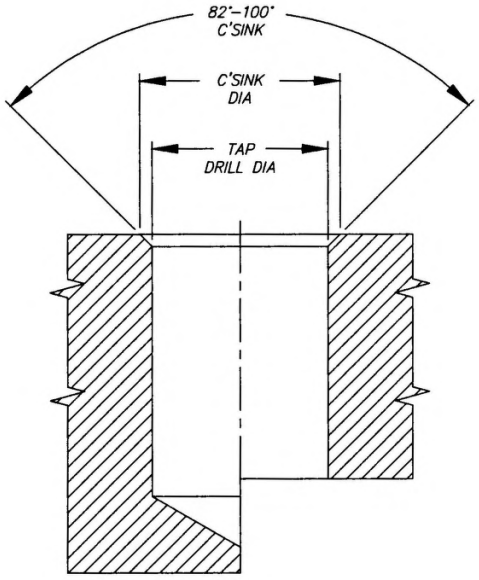
TABLE I

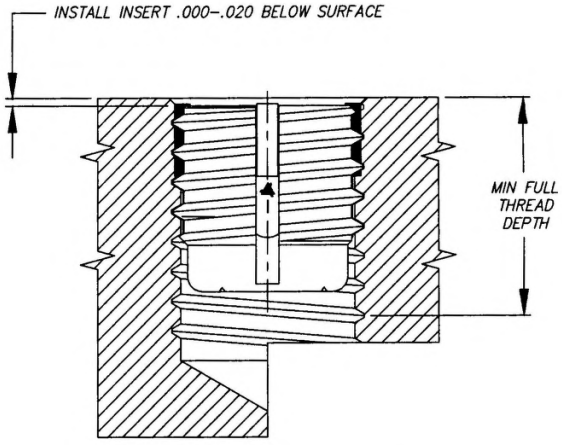
-( )	A THREAD	B THREAD SIZE	B THREAD MODIFIED MINOR DIA	INSERT MIN SHEAR ENGAGEMENT AREA in² <6>	H ±.015	J ±.015	F DIA MAX	G	K ±.015
-3	.1900-32UNJF-3B	.3750-16UNC-2A	.320 .312	.0938	.350	.265	.312	.288 .280	.220
-4	.2500-28UNJF-3B	.4375-14UNC-2A	.383 .375	.1358	.400	.300	.375	.348 .341	.220
-5	.3125-24UNJF-3B	.5000-13UNC-2A	.440 .432	.1765	.480	.360	.432	.411 .403	.220
-6	.3750-24UNJF-3B	.5625-12UNC-2A	.503 .495	.2398	.540	.400	.495	.473 .465	.220
-7	.4375-20UNJF-3B	.6250-11UNC-2A	.565 .551	.3101	.570	.450	.551	.536 .528	.350
-8	.5000-20UNJF-3B	.6875-11UNS-2A	.625 .615	.7149	.725	.590	.615	.597 .591	.350
-13	.1900-32UNJF-3B	.4375-14UNC-2A	.383 .375	.0952	.350	.265	.355	.348 .341	.220
-14	.2500-28UNJF-3B	.5000-13UNC-2A	.440 .432	.1159	.400	.275	.412	.411 .403	.220
-15	.3125-24UNJF-3B	.5625-12UNC-2A	.503 .495	.1820	.480	.330	.475	.473 .465	.220
-16	.3750-24UNJF-3B	.6250-11UNC-2A	.565 .551	.2515	.580	.390	.531	.536 .528	.220
-17	.4375-20UNJF-3B	.6875-11UNS-2A	.625 .615	TBD	.670	.450	.595	.597 .591	.350

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REV. LETTER AND DATE K 8/14/2019			SALES DRAWING NO. TR24194-( )
DAF NUMBER 118384	Tridair Products 3000 W. Lomita Blvd. Torrance, California 90505	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & ASME Y14.5M TOLERANCES: ANGLES = ±3° DECIMALS .XX = ±.02 .XXX = ±.010	SHEET 1 OF 3

S45191

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





BLIND HOLE INSTALLATION

THRU HOLE INSTALLATION

TABLE II

-( )	INSTALLATION DATA						REMOVAL DATA	
	TAP DRILL DIA	C'SINK DIA	TAP		BROACHING TOOL PART NUMBER	INSTALLATION TOOL PART NUMBER	DRILL	
			SIZE	MIN FULL THREAD DEPTH			SIZE	DEPTH
-3	.336 .331	.395 .385	.3750-16UNC-2B	.44	TR18690-332-2	THD1032L	.281	.220
-4	.401 .396	.457 .447	.4375-14UNC-2B	.49	TR18690-397-2	THD428L	.343	.220
-5	.457 .452	.520 .510	.5000-13UNC-2B	.57	TR18690-453-4	THD524L	.406	.220
-6	.521 .515	.582 .572	.5625-12UNC-2B	.63	TR18690-516-4	THD624L	.468	.220
-7	.583 .577	.645 .635	.6250-11UNC-2B	.66	TR18690-578-4	THD720L	.531	.220
-8	.646 .640	.710 .700	.6875-11UNS-2B	.82	TR18690-641-4	THD820L	.594	.220
-13	.401 .396	.457 .447	.4375-14UNC-2B	.44	TR18690-397-2	THXHD1032L	.343	.220
-14	.457 .452	.520 .510	.5000-13UNC-2B	.49	TR18690-453-4	THXHD428L	.406	.220
-15	.521 .515	.582 .572	.5625-12UNC-2B	.57	TR18690-516-4	THXHD524L	.469	.220
-16	.583 .577	.645 .635	.6250-11UNC-2B	.67	TR18690-578-4	THXHD624L	.531	.220
-17	.644 .640	.710 .700	.6875-11UNS-2B	.76	TBD	THXHD687L	.680	.220

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NOTES:

1. MATERIAL:
1.1 INSERT: A286 CRES PER AMS5732 OR AMS5737.
1.2 LOCKING KEES: A286 CRES PER AMS5525 (CHEMISTRY ONLY).
1.3 LOCKING ELEMENT: VESPEL® POLYMIDE RESIN TYPE SP1.

2. HEAT TREAT:
2.1 LOCKING KEES: 140 KSI MIN PER AMS2759.

3. FINISH:
3.1 INSERT: PASSIVATE PER AMS 2700, AND DRY FILM LUBE WITH ESNALUBE 382.
3.2 LOCKING KEES: PASSIVATE PER AMS 2700 (LUBRICANT OPTIONAL).

<4> 2 LOCKING KEES ON -3 AND -4 SIZES, 4 LOCKING KEES ON ALL OTHER SIZES.

5. PERFORMANCE IAW GENERAL ELECTRIC SPEC. NO. M50TF19, CLASS B AND DWG. NO. J970 AND J971.

<6> SHEAR ENGAGEMENT AREAS ARE FOR MATERIALS WITH ULTIMATE SHEAR STRENGTH GREATER THAN 85 KSI.

7. MUST CONFORM TO: AS 478-37 (MARKING)

8. VENDOR SUBSTANTIATION REQUIRED

9. MUST CONFORM TO MIL-I-45914 (KEY LOCKED SCREW THREAD INSERT) REQUIREMENTS FOR MS51832 INSERTS WHEN ASSEMBLED INTO AMS 5731 TEST BLOCKS CONFORMING TO P12TF24 CL-A. (ASSY OF INSERTS)

10. MATERIAL AND SELF LOCKING FEATURE MUST CONFORM TO M50TF19 CL-B (AMS 5735, AMS 5737 REF, DRY FILM LUBRICATED SELF LOCKING NUTS) EXCEPT THE DESIGN ASSURANCE REQUIRMENTS (QUALIFICATION TEST) SHALL BE AS FOLLOWS:
(a) TEST BOLTS SHALL BE J642 THRU J648 OR R582 THRU R588 AND SPACER MATERIAL SHALL BE AMS5663 (INCONEL 718 ALLOY)
(b) HIGH TEMPERATURE REUSABILITY TEST SHALL BE REPEATED FOR A TOTAL OF 50 TIMES AND MINIMUM PREVALING TORQUE SHALL BE RECORDED EVERY FIVE CYCLES. TEST BOLTS MAY BE REPLACED WHEN WORN PROVIDED A MINIMUM OF TEN TEST CYCLES HAVE BEEN PERFORMED ON THE BOLT. THE NUMBER OF CYCLES PERFORMED ON THE BOLT SHALL BE NOTED IN THE TEST REPORT.

11. INSTALLATION PROCEDURES:
11.1 PREPARE PANEL IN ACCORDANCE TO THE DIMENSIONS SHOWN IN TABLE II.
11.2 SCREW IN INSTERT WITH FINGERS OR INSTALLATION TOOL. INSERT IS DESIGNED TO STOP AT CORRECT DEPTH.
11.3 MARK LOCATION OF LOCKING KEES AND REMOVE INSERT.
11.4 BROACH SLOTS USING THE MARKS AS A GUIDE.
11.5 CHASE THREADS WITH A TAP TO REMOVE CHIPS.
11.6 REINSTALL INSERT AND DRIVE LOCKING KEES DOWN USING THE INSTALLATION TOOL.

12. REMOVAL PROCEDURES:
12.1 USE THE DRILL SIZES AND DEPTHS SPECIFIED IN TABLE II TO REMOVE MATERIAL BETWEEN THE KEES.
12.2 DEFLECT LOCKING KEES INWARD AND BREAK OFF.
12.3 REMOVE INSERT WITH AN "EASY OUT" TYPE TOOL.

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S45191