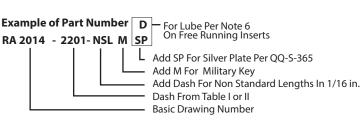
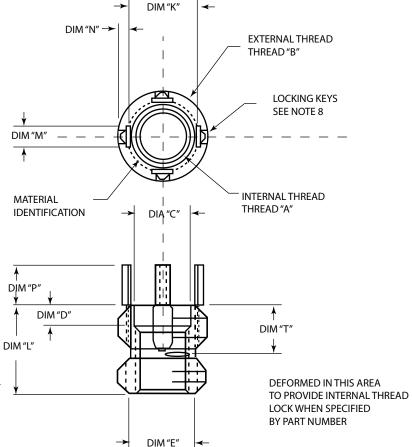
#### ROLAND AEROSPACE MANUFACTURER OF SPECIALIZED JET ENGINE COMPONENTS 16625 Gramercy Place, California 90249







#### **NOTES:**

- 1) ONE DASH MARK ON TOP OF INSERT IDENTIFIES MATERIAL.
- 2) MATERIAL INSERT A-286 HEAT AND CORROSION RESISTANT STEEL PER AMS 5731 OR AMS 5737 (140 K.S.I. MINIMUM).
- 3) HEAT TREAT: INSERT A-286 MANUFACTURED FROM AMS 5731 SHALL BE AGE HARDENED PER AMS 5737 (140 K.S.I. MINIMUM).
- 4) LOCKING KEYS: 420 CORROSION RESISTANT STEEL PER QQ-S-763 (CHEMISTRY ONLY) ADD M TO PART NUMBER FOR MILITARY KEY MADE FROM 302 SS HEAT TREATED TO A MINIMUM ROCKWELL HARDNESS OF (RC50).
- 5) SURFACE TREATMENT: INSERT SHALL BE PASSIVATED PER QQ-P-35C OR ADD SP TO PART NUMBER FOR SILVER PER QQ-S-365
- 6) LUBRICTION: FINISHED INSERTS WITH INTERNAL SELF-LOCKING FEATURE SHALL BE DRY FILM LUBRICATED PER AS 5272 TYPE 1.
- 7) PERFORMANCE: I.A.W. MIL-I-45914
- 8) INSERT WITH INTERNAL THREAD SIZES OF .1900 AND .2500 HAVE 2 LOCKING KEYS. ALL OTHER SIZES HAVE 4 LOCKING KEYS.
- 9) CHAMFERS AND THREAD RELIEFS ARE 40° 50° TYPICAL.
- 10) TO DESIGNATE PART WITH SELF-LOCKING INTERNAL THREAD, FOLLOW DASH NUMBER WITH "L".

## INSERT, KEY LOCKED, SELF BROACHING, HEAVY DUTY

CAGE CODE	DWG NO. RA2014	Drawn by: R.S.	Date: 03/18/2017
63EM5	REV: A SHEET 1 OF 2	Approved by:	Date: 03/18/2017

# ROLAND AEROSPACE MANUFACTURER OF SPECIALIZED JET ENGINE COMPONENTS 16625 Gramercy Place, California 90249

			TABL	E I - COL	JRSE INT	ERNAL 1	HREAD					
DASH NO.	INTERNAL THREAD SAE AS8879	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO	CEPT	D ±.010	E ±.010	К	L ±.015	KEY DIMENSIONS		T ±.030		
	UNJC-3B	SIZE	MINOR DIA.						M ±.002	N ±.004	P ±.015	
1201	.190-24	.375-16UNC-2A	.320 .312	.196	.070	.310	.288 .281	.312	.068	.040	.130	.220
1302	.250-20	.4375-14UNC-2A	.383 .375	.257	.070	.375	.348 .341	.375	.068	.040	.190	.220
1403	.3125-18	.500-13UNC-2A	.440 .432	.316	.070	.430	.411 .403	.437	.068	.040	.190	.220
1504	.375-16	.5625-12UNC-2A	.503 .495	.380	.070	.495	.473 .465	.500	.068	.040	.190	.250
1605	.4375-14	.625-11UNC-2A	.565 .551	.445	.100	.550	.536 .528	.625	.068	.040	.190	.280
1706	.500-13	.6875-11NS-2A	.625 .615	.507	.100	.615	.597 .591	.688	.068	.040	.190	.280
1807	.5625-12	.8125-16UN-2A	.752 .744	.580	.100	.745	.724 .716	.812	.068	.040	.190	.320
		075 4411115 04	015	.640	.100	005	.786	.875	.068	.040	.190	.330
1908	.625-11	.875-14UNF-2A	.815 .807	.040	.10	.805	.778	.0	.00	ĵ.	. 130	3
1908	.625-11	.8/5-14UNF-2A	.807	LE II - FI			.778	.073	.000	.040	.150	.550
DASH NO.	INTERNAL THREAD SAE AS8879		.807 TAB				.778	L ±.015		DIMENS		T ±.030
DASH	INTERNAL THREAD SAE	EXTERNAL THREA STD-H28/2 EX	.807 TAB	C ±.005	NE INTE	RNAL TH	.778	L				т
DASH	INTERNAL THREAD SAE AS8879	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO	TAB AD FED- CEPT OR DIA.	C ±.005	NE INTE	RNAL TH	.778	L	KEY (	DIMENS	IONS	т
DASH NO.	INTERNAL THREAD SAE AS8879 UNJF-3B	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO	TAB AD FED- CEPT OR DIA. MINOR DIA .320	C ±.005	D ±.010	RNAL TH	.778 IREAD  K	L ±.015	KEY (	N ±.004	P ±.015	T ±.030
DASH NO.	INTERNAL THREAD SAE AS8879 UNJF-3B	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO SIZE .375-16UNC-2A	TAB AD FED- CEPT OR DIA. MINOR DIA .320 .312	C ±.005	D ±.010	E ±.010	.778 IREAD  K .288 .281 .348	L ±.015	M ±.002	N ±.004	P ±.015	T ±.030
DASH NO. 2201 2302	INTERNAL THREAD SAE AS8879 UNJF-3B .190-32 .250-28	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO SIZE .375-16UNC-2A	.807  TAB  AD FED- CEPT OR DIA.  MINOR DIA  .320 .312 .383 .375 .440 .432	C ±.005	D ±.010	E ±.010	.778 IREAD  K .288 .281 .348 .341 .411	L ±.015	M ±.002 .068	N ±.004 .040	P ±.015 .130	T ±.030
DASH NO. 2201 2302 2403	INTERNAL THREAD SAE AS8879 UNJF-3B .190-32 .250-28	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO SIZE .375-16UNC-2A .4375-14UNC-2A	.807  TAB  AD FED- CEPT OR DIA.  MINOR DIA  .320 .312 .383 .375 .440 .432 .503	C ±.005	D ±.010	RNAL TH E ±.010	.778 IREAD  K .288 .281 .348 .341 .411 .403 .473	.312 .375	M ±.002 .068	N ±.004 .040	P ±.015 .130	.220 .220
DASH NO. 2201 2302 2403 2504	INTERNAL THREAD SAE AS8879 UNJF-3B .190-32 .250-28 .3125-24	EXTERNAL THREA STD-H28/2 EX MODIFIED MINO SIZE .375-16UNC-2A .4375-14UNC-2A .500-13UNC-2A	.807  TAB  AD FED- CEPT OR DIA.  MINOR DIA  .320  .312  .383  .375  .440  .432  .503  .495  .565	C ±.005	D ±.010  .070  .070  .070	RNAL TH E ±.010	.778 IREAD  K .288 .281 .348 .341 .411 .403 .473 .465	.312 .375 .437	M ±.002 .068 .068	N ±.004 .040 .040	P ±.015 .130 .190	.220 .220 .220
DASH NO. 2201 2302 2403 2504 2605	INTERNAL THREAD SAE AS8879 UNJF-3B .190-32 .250-28 .3125-24 .375-24	EXTERNAL THREA STD-H28/2 EXI MODIFIED MINO SIZE .375-16UNC-2A .4375-14UNC-2A .500-13UNC-2A .5625-12UNC-2A	.807  TAB  AD FED- CEPT OR DIA.  MINOR DIA  .320 .312 .383 .375 .440 .432 .503 .495 .565 .551 .625	C ±.005  .196  .257  .316  .380	D ±.010  .070  .070  .070  .070  .100	.310 .375 .430 .495	.778 IREAD  K  .288 .281 .348 .341 .411 .403 .473 .465 .536 .528	.312 .375 .437 .500	M ±.002 .068 .068 .068	N ±.004 .040 .040	P ±.015 .130 .190 .190	.220 .220 .220 .250

## INSERT, KEY LOCKED, SELF BROACHING, HEAVY DUTY

CAGE CODE	DWG NO. RA2014	Drawn by: R.S,	Date: 03/18/2017
63EM5	REV: A SHEET 2 OF 2	Approved by:	Date: 03/18/2017