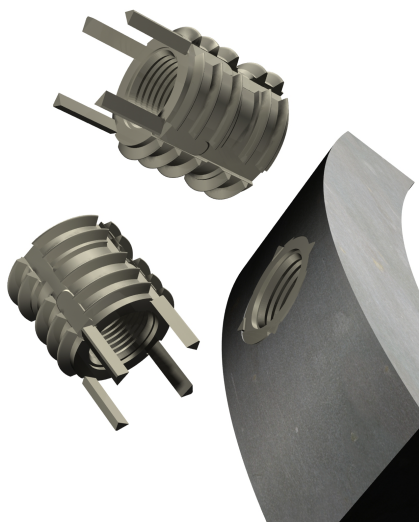




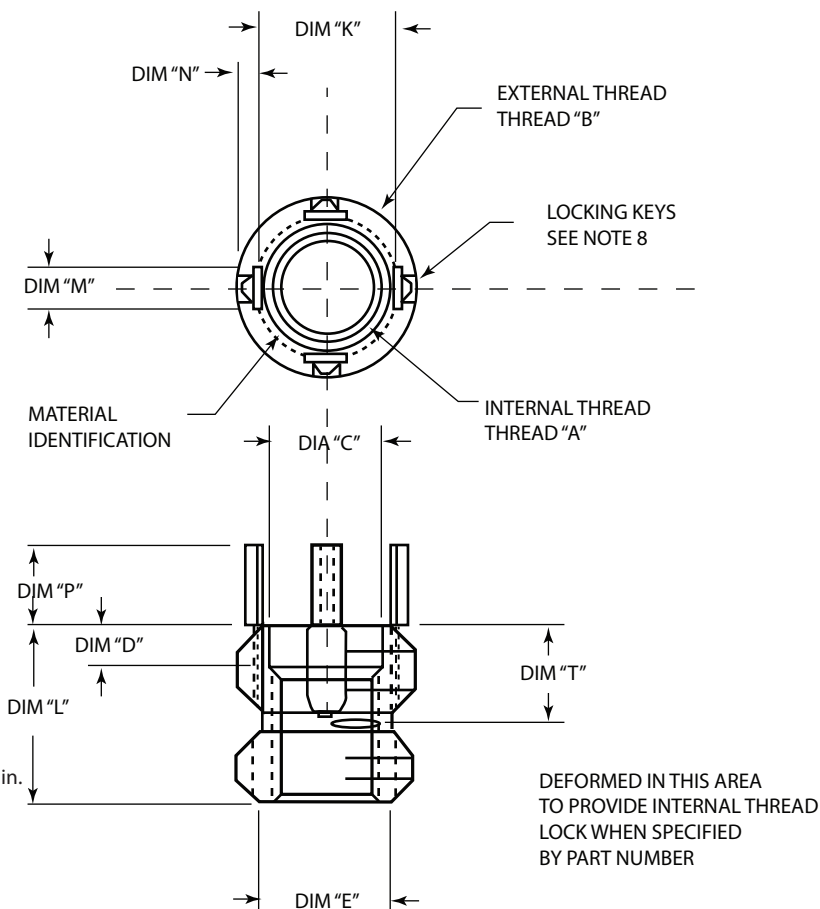
P/N RA2015



Example of Part Number

RA 2015 - 2201-NSL M **D** **SP**

- For Lube Per Note 6 On Free Running Inserts
- Add SP For Silver Plate Per QQ-S-365
- Add M For Military Key
- Add Dash For Non Standard Lengths In 1/16 in.
- Dash From Table I or II
- Basic Drawing Number



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) LUBRICATION: 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, EXTRA HEAVY DUTY**

CAGE CODE	DWG NO. RA2015	Drawn by: R.S.	Date: 03/28/2018
63EM5	REV: A SHEET 1 OF 2	Approved by:	Date: 03/29/2018



P/N RA2015

TABLE I. COARSE INTERNAL THREADS

DASH NO.	INTERNAL THREAD SAE AS8879 UNJC-3B	EXTERNAL THREAD FED-STD-H28/2 EXCEPT MODIFIED MINOR DIA.		ØC ±.005	D ±.010	ØE REF	K REF	L ±.015	KEY DIMENSIONS			T ±.030
		SIZE	MINOR DIA.						M REF	N REF	P REF	
101	.190-24	.4375-14UNC2A	.383 .375	.196	.070	.375	.344	.312	.068	.040	.130	.220
102	.250-20	.500-13UNC-2A	.440 .432	.257	.070	.430	.407	.375	.068	.040	.190	.220
103	.3125-18	.5625-12UNC-2A	.503 .495	.316	.070	.495	.469	.437	.068	.040	.190	.220
104	.375-16	.625-11UNC-2A	.565 .551	.380	.070	.550	.532	.500	.068	.040	.190	.250
105	.4375-14	.6875-11NS-2A	.625 .615	.445	.100	.615	.595	.625	.068	.040	.190	.280
106	.500-13	.8125-16UN-2A	.752 .744	.507	.100	.745	.720	.688	.068	.040	.190	.280
107	.5625-12	.875-14UNF-2A	.815 .807	.580	.100	.805	.782	.812	.068	.040	.190	.320
108	.625-11	1.000-12UNF-2A	.924 .916	.640	.100	.915	.850	.875	.103	.070	.250	.330
109	.750-10	1.250-12UNF-2A	1.175 1.165	.763	.100	1.165	1.100	1.125	.103	.070	.250	
110	.875-9	1.375-12UNF-2A	1.300 1.290	.888	.100	1.290	1.225	1.250	.103	.070	.250	
111	1.000-8	1.500-12UNF-2A	1.424 1.416	1.015	.100	1.415	1.350	1.375	.103	.070	.250	

TABLE II. FINE INTERNAL THREADS

DASH NO.	INTERNAL THREAD SAE AS8879 UNJC-3B	EXTERNAL THREAD FED-STD-H28/2 EXCEPT MODIFIED MINOR DIA.		ØC ±.005	D ±.010	ØE REF	K REF	L ±.015	KEY DIMENSIONS			T ±.030
		SIZE	MINOR DIA.						M REF	N REF	P REF	
201	.190-32	.4375-14UNC2A	.383 .375	.196	.070	.375	.344	.312	.068	.040	.130	.220
202	.250-28	.500-13UNC-2A	.440 .432	.257	.070	.430	.407	.375	.068	.040	.190	.220
203	.3125-24	.5625-12UNC-2A	.503 .495	.316	.070	.495	.469	.437	.068	.040	.190	.220
204	.375-24	.625-11UNC-2A	.565 .551	.380	.070	.550	.532	.500	.068	.040	.190	.250
205	.4375-20	.6875-11NS-2A	.625 .615	.445	.100	.615	.595	.625	.068	.040	.190	.280
206	.500-20	.8125-16UN-2A	.752 .744	.507	.100	.745	.720	.688	.068	.040	.190	.280
207	.5625-18	.875-14UNF-2A	.815 .807	.580	.100	.805	.782	.812	.068	.040	.190	.320
208	.625-18	1.000-12UNF-2A	.924 .916	.640	.100	.915	.850	.875	.103	.070	.250	.330
209	.750-16	1.250-12UNF-2A	1.175 1.165	.763	.100	1.165	1.100	1.125	.103	.070	.250	
210	.875-14	1.375-12UNF-2A	1.300 1.290	.888	.100	1.290	1.225	1.250	.103	.070	.250	
211	1.000-12	1.500-12UNF-2A	1.424 1.416	1.015	.100	1.415	1.350	1.375	.103	.070	.250	

**INSERT, KEY LOCKED, SELF
BROACHING, EXTRA HEAVY DUTY**

CAGE CODE 63EM5	DWG NO. RA2015 REV: A SHEET 2 OF 2	Drawn by: R.S.	Date: 03/28/2018
		Approved by: 	Date: 03/29/2018