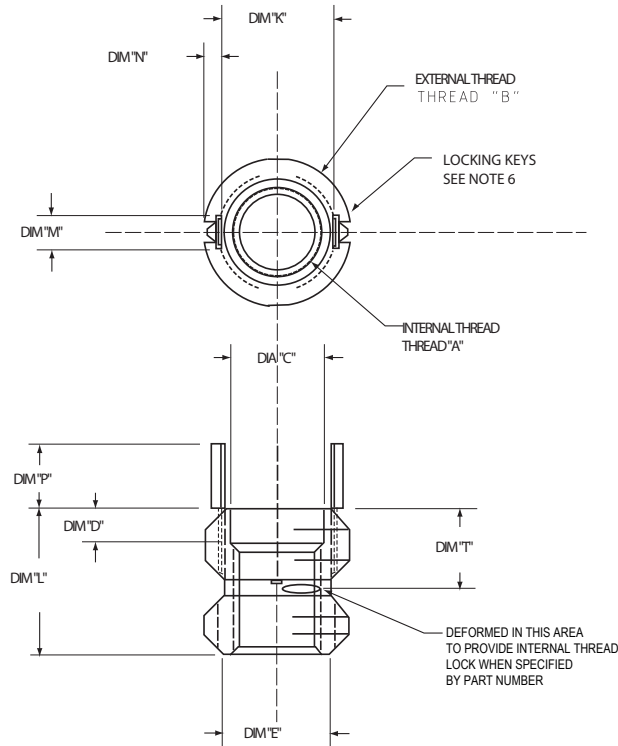
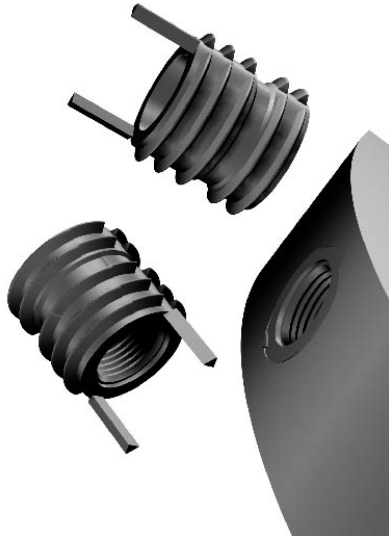




P/N RA2020



INTERNAL THREADS UNJF-3B	A MINOR	B EXTERNAL THREADS UNC-2A	B MINOR	C	E REF	T	L	M REF	K	D	N REF	P
.1900-32	.1675 .1596	.3125-18	.256 .249	.201 .191	.250	.140 .080	.327 .297	.068	.224 .216	.080 .060	.040	.175 .145

NOTES:

- 1) MATERIAL: INSERT - 303 OR 303SE CORROSION RESISTANT STEEL PER ASTM A582 OR AMS 5640.
- 2) LOCKING KEYS: 420 CORROSION RESISTANT STEEL PER QQ-S-763 (CHEMISTRY ONLY) HEAT TREATED TO A MINIMUM ROCKWELL HARDNESS OF (RC50).
- 3) SURFACE TREATMENT: INSERTS SHALL BE PASSIVATED PER QQ-P-35C OR AMS-QQ-P-35.
- 4) LUBRICATION: FINISHED INSERTS WITH INTERNAL SELF-LOCKING FEATURE SHALL BE DRY FILM LUBRICATED PER AS 5272, TYPE 1.
- 5) PERFORMANCE: I.A.W. MIL-I-45914
- 6) Keys: 2 Locking Keys
- 7) CHAMFERS AND THREAD RELIEFS ARE 40°-50° TYPICAL.

TITLE
INSERT, KEY LOCKED, SELF BROACHING

CAGE CODE 63EM5	DWG NO. RA2020 REV: NC SHEET1 of 1	Drawn by: R.S.	Date: 12/05/2018
		Approved by:	Date: 12/05/2018