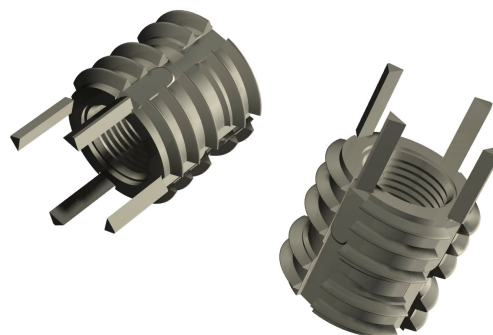
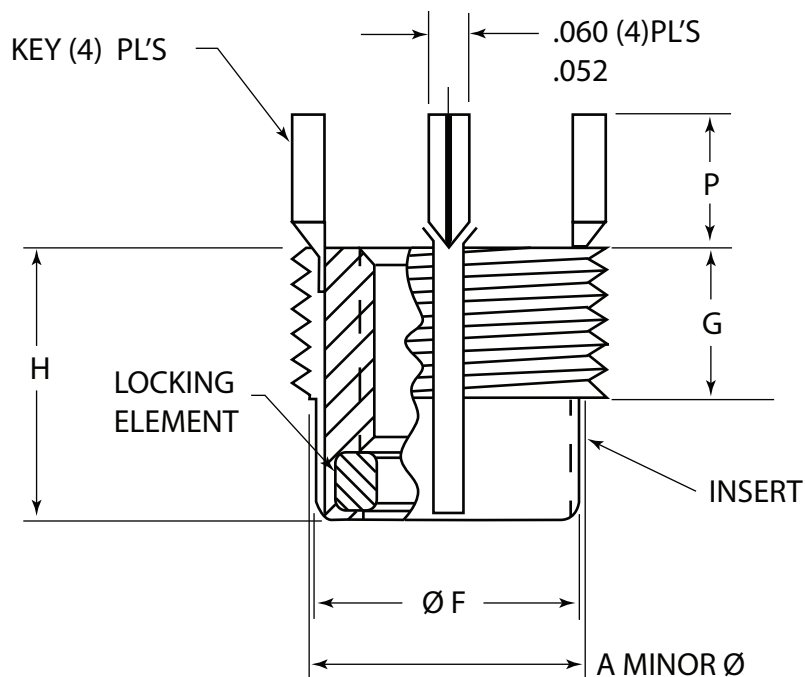




INSERT SELF LOCKING SELF BROACHING



PROCUREMENT NUMBER	A MINOR Ø	F MAX	G	H MAX	P	THREAD PER MIL-S-8879		FED-STD-H28/2A
						INTERNAL	EXTERNAL	EXTERNAL
RA2011-9001	.3268 .3214	.312	.180 .150	.250	.150 .120	.1900-32UNJF-3B	.3750-24UNJF-3A	
RA2011-9002	.3797 .3736	.365	.230 .200	.310	.210 .175	.2500-28UNJF-3B	.4375-20UNJF-3A	
RA2011-9003	MOD .440 .432	.432	.580 .550	.703	.205 .175	.3125-24UNJF-3B		.5000-13UNC-2A
RA2011-9004	MOD .503 .495	.495	.795 .765	.935	.205 .175	.3750-24UNJF-3B		.562-12 UNC-2A

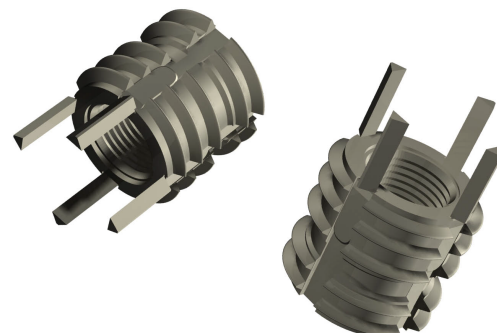
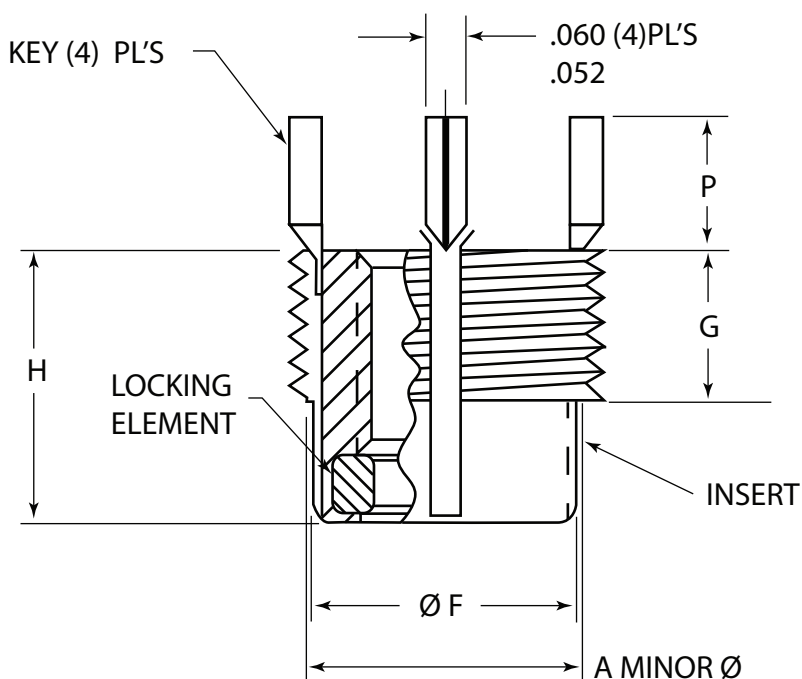
MATERIALS: INSERT - A286 CRES PER AMS5734 OR AMS5737
KEYS- INCO 718 PER AMS5662 OR INCO 750X PER AMS5698.
LOCKING ELEMENT - DUPONT VESPEL POLYMER

FINISH: INSERT-DRY FILM LUBRICANT
KEYS- BARE OR DRY FILM LUBE (AT MFR'S OPTION).

HARDNESS: INSERT- 140 KSI UTS MINIMUM.
KEYS- 48 HRC MINIMUM.

TEMPERATURE: APPLICATIONS TO 600° F MAX.

CAGE CODE	DWG NO. RA2011	Drawn by: R.S.	Date Modified:2/25/2016
		Approved by: 	Date: 2/25/2016
63EM5	REV: NC SHEET 1 OF 3		



PROCUREMENT NUMBER	A MOD MINOR Ø	F MAX	G	H MAX	P	INTERNAL	EXTERNAL
						THREAD PER MIL-S-8879	FED-STD-H28/2
RA2011-9107	.565	.551	.465	.585	.203	.4375-20UNJF-3B	.625-11UNC-2A
	.551		.435	.555	.173		

MATERIALS: INSERT - A286 CRES PER AMS5732 OR AMS5737
KEYS - 420 CRES PER QQ-S-763 (CHEMISTRY ONLY)
LOCKING ELEMENT - DUPONT VESPEL POLYIMIDE RESIN TYPE SP1.

FINISH: INSERT - PASSIVATED PER AMS-QQ-P-35 AND DRY FILM LUBRICATED.
KEYS - PASSIVATED PER AMS-QQ-P-35 (LUBRICATED OPT).

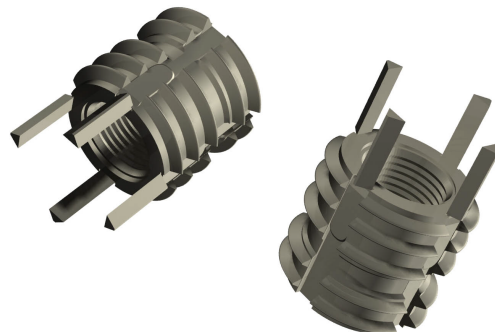
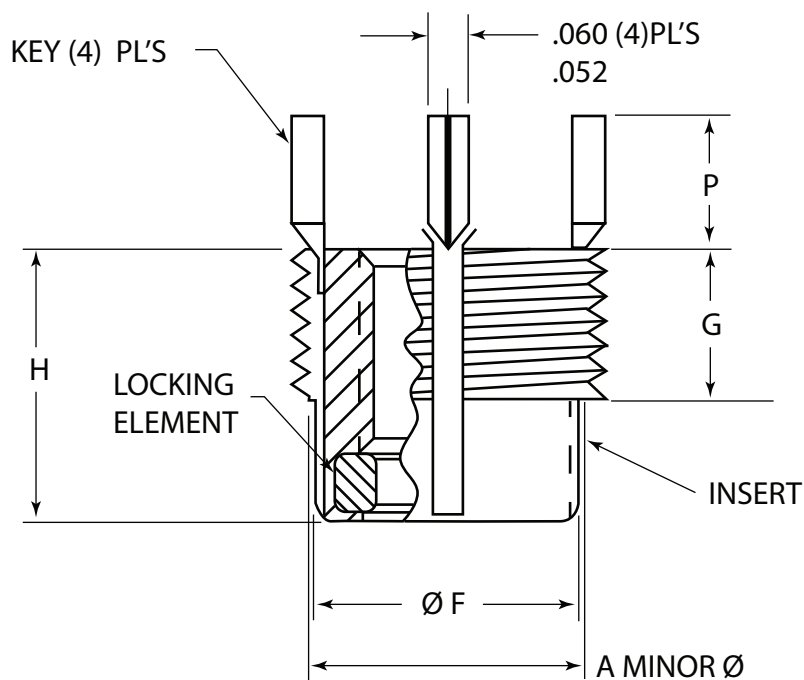
HARDNESS: KEYS - 54 HRC MINIMUM

TEMPERATURE: APPLICATIONS TO 600° F MAX.

CAGE CODE 63EM5	DWG NO. RA2011 REV: NC SHEET 2 OF 3	Drawn by: R.S.	Date Modified: 2/25/2016
		Approved by:	Date: 2/25/2016



INSERT SELF LOCKING SELF BROACHING



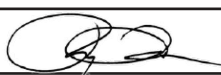
PROCUREMENT NUMBER	A MOD MINOR Ø	F MAX	G	H MAX	P	INTERNAL	EXTERNAL
						THREAD PER MIL-S-8879	FED-STD-H28/2
RA2011-9207	.625 .615	.615	.465 .435	.585 .555	.203 .173	.4375-20UNJF-3B	.6875-11NS-2A

MATERIALS: INSERT - A286 CRES PER AMS5732 OR AMS5737
KEYS - 420 CRES PER-QQ-S-763 (CHEMISTRY ONLY)
LOCKING ELEMENT - DUPONT VESPEL POLYIMIDE RESIN TYPE SPI.

FINISH: INSERT - PASSIVATED PER AMS-QQ-P-35 AND DRY FILM LUBRICATED.
KEYS: PASSIVATED PER AMS-QQ-P-35 (LUBRICANT OPT).

HARDNESS: KEYS - 54 HRC MINIMUM

TEMPERTURE: APPLICATIONS TO 600° F MAX.

CAGE CODE	DWG NO. RA2011	Drawn by: R.S.	Date Modified:2/25/2016
		Approved by: 	Date: 2/25/2016
63EM5	REV: NC SHEET 3 OF 3		