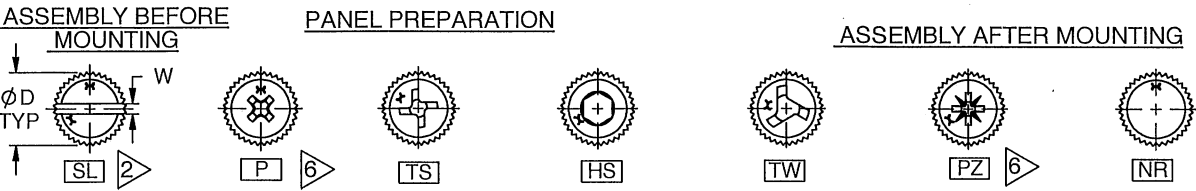
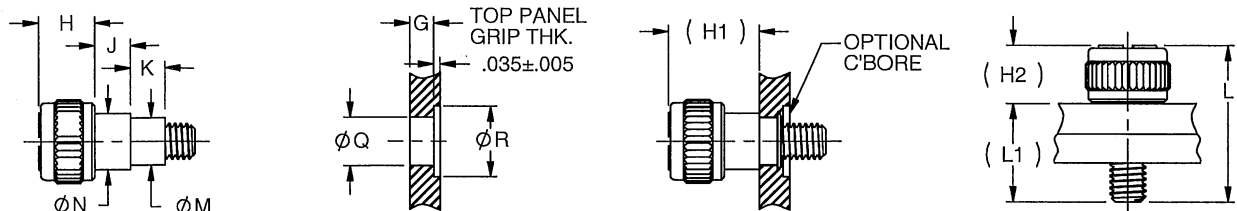


REV PP  
S-0206  
DRAWING NO.



THREAD SIZE CODE	Ø D	H		(H1)		(H2)		J	Ø M +.005 -.005	Ø N +.005 -.005	Ø Q +.004 -.001	Ø R	W	RECESS SIZE			
		HS	P, PZ, SL, TS, TW, NR	HS	P, PZ, SL, TS, TW, NR	HS	P, PZ, SL, TS, TW, NR							P, PZ	TW	TS	HS
4, 4F, M3	.325	.339	.269	.524	.454	.364	.294	.176	.177	.206	.187	.281	.040	4	2	.2	3/32
6, 6F, M3.5	.356								.202	.241	.209	.312	.044	4	3	4	7/64
8, 8F, M4	.420	.354	.284	.554	.484	.379	.309	.188	.215	.258	.223	.343	.049	6	4	6	9/64
10, 10C, 10F, M5	.451								.250	.297	.257	.375	.055	8	5	8	5/32
12, 12C, 12F, M6	.531	.374	.304	.594	.524	.399	.329	.204	.313	.371	.323	.437	.062	10	6	10	3/16

PART NUMBER CALLOUT

D ( ) 7500 ( ) - ( ) - ( ) - ( )

MODEL  
SERIES

LENGTH CODE	4, 4F, M3		6, 6F, M3.5		8, 8F, M4		10, 10C, 10F, M5		12, 12C, 12F, M6	
	L +.025 -.015	L1	L +.025 -.015	L1	L +.025 -.015	L1	L +.025 -.015	L1	L +.025 -.015	L1
1	.576	.282	.587	.293	.622	.316	.644	.335	.682	.353
1.5	.607	.313	.619	.325	.655	.349	.676	.367	.714	.385
2	.639	.345	.650	.356	.685	.379	.707	.398	.745	.416
2.5	.702	.408	.713	.419	.748	.442	.770	.461	.808	.479
3	.764	.470	.775	.481	.810	.504	.832	.523	.870	.541
3.5	.827	.533	.838	.544	.873	.567	.895	.586	.933	.604
4	.889	.595	.900	.606	.935	.629	.957	.648	.995	.666
4.5	.952	.658	.963	.669	.998	.692	1.020	.711	1.058	.729
5	1.014	.720	1.025	.731	1.060	.754	1.082	.773	1.120	.791
6	1.139	.845	1.150	.856	1.185	.879	1.207	.898	1.245	.916
7	1.264	.970	1.275	.981	1.310	1.004	1.332	1.023	1.370	1.041
8	1.389	1.095	1.400	1.106	1.435	1.129	1.457	1.148	1.495	1.166

THREAD SIZE CODE	THREAD SIZE	LEAD	THREAD SIZE CODE	THREAD SIZE	LEAD
4	.112-40 UNC-3A	SINGLE	8F	.164-32 UNC-3A	QUAD
6	.138-32 UNC-3A		10F	.190-32 UNF-3A	
8	.164-32 UNC-3A		12F	.250-28 UNF-3A	
10	.190-32 UNF-3A		M3	M3 x 0.5-4h6h	METRIC
12	.250-28 UNF-3A	M3.5	M3.5 x 0.6-4h6h		
10C	.190-24 UNC-3A	M4	M4 x 0.7-4h6h		
12C	.250-20 UNC-3A	M5	M5 x 0.8-4h6h		
4F	.112-40 UNC-3A	DOUBLE	M6	M6 x 1.0-4h6h	
6F	.138-32 UNC-3A				

GRIP CODE	G (TOP PANEL GRIP THICKNESS)	K ±.005
AAA	.015-.029	.055
AA	.030-.055	.095
A	.031-.062	.125
B	.063-.125	.187
C	.126-.187	.250
D	.188-.250	.312
E	.251-.312	.375
F	.313-.375	.437

CODE	FINISH
NONE	CLEAR
B	BLACK

RECESS CODE	DRIVING RECESS AND SPECIFICATION	RECESS CODE	DRIVING RECESS AND SPECIFICATION
SL	SLOT RECESS PER ANSI B18.6.3	PZ	RECESS PER TYPE 1A ANSI B18.6.3
HS	HEX SOCKET RECESS PER ANSI B18.3	TS	RECESS PER NASM 33781
NR	NO RECESS	TW	RECESS PER NAS 4000
P	CROSS RECESS PER NASM 9006		

PP	DCN 4279	05-22-06
REV	DESCRIPTION/EC NO.	DATE

**ALCOA** **Alcoa Fastening Systems**

AEROSPACE FASTENER DIVISION  
3724 EAST COLUMBIA STREET  
TUCSON, ARIZONA 85714  
PHONE 520 519-7400  
FAX 520 519-7427  
www.huckaerospace.com

TITLE <b>TURN-LOC, LOW PROFILE, OPTIONAL RECESS</b>	
DATE 09/27/2004	PART NUMBER <b>D7500</b>
DRAWN JLS	DRAWING NO. <b>S-0206</b>
CHECK <i>[Signature]</i>	CAGE CODE OHDW7
APPROVE <i>[Signature]</i>	REV <b>PP</b>
SCALE: 1:1	SHEET 1 OF 2

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES  
TOLERANCE UNLESS OTHERWISE NOTED:  
.X = ±.05 ANGLES ±0.5°  
.XX = ±.02  
.XXX = ±.015

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REV PP  
 S-0206  
 DRAWING NO.

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AVAILABILITY TABLE

GRIP CODE	4, 4F, M3						6, 6F, M3.5, 8, 8F, M4						10, 10C, 10F, M5, 12, 12C, 12F, M6																			
	1	1.5	2	2.5	3	3.5	4	4.5	5	6	1	1.5	2	2.5	3	3.5	4	4.5	5	6	1	1.5	2	2.5	3	3.5	4	4.5	5	6	7	8
A																																
B																																
C																																
D	O	O	O								O	O									O											
E	O	O	O	O							O	O	O								O	O	O									
F	O	O	O	O							O	O	O	O							O	O	O	O								

- ASSEMBLIES NOT AVAILABLE
- ARBOR PRESS FORMING TOOL
- INSTALLATION TOOL H8603-( ) OR ARBOR PRESS FORMING TOOL

MATERIAL

STUD: HS, NR, P, PZ, & SLOT RECESSES  
 ALL SIZES - 302 CRES PER ASTM-A-493 OR AMS 5636

STUD: TS AND TW RECESSES  
 ALL SIZES - A-286 CRES PER AMS 5737, HEAT TREAT TO 160 KSI MIN. ULTIMATE TENSILE STRENGTH

KNOB : 6061 ALUMINUM ALLOY PER AMS QQ-A-225/8, OR AMS 4117, OR EQUIVALENT

SLEEVE: 6061 ALUMINUM ALLOY PER AMS QQ-A-225/8, OR AMS 4117, OR EQUIVALENT

SPRING: 302 CRES PER ASTM-A313 OR AMS 5688

FINISH

NONE: STUD & SPRING: PASSIVATE PER AMS QQ-P-35  
 KNOB & SLEEVE: ANODIZE PER MIL-A-8625, TYPE II, CLASS I

B: STUD:  
 BLACK OXIDE PER MIL-C-13924, CLASS 4 (300 SERIES)  
 BLACK OXIDE PER MIL-C-13924, CLASS 3 (A-286)  
 KNOB: BLACK ANODIZE PER MIL-A-8625, TYPE II, CLASS 2

NOTES:

- 1 LETTERS AT THE END OF PART NUMBER DESIGNATE SPECIAL ASSEMBLIES:  
 DL - ASSEMBLIES WITH DRI LUBE THREADS PER MIL-PRF-46010  
 PL - ASSEMBLIES WITH PATCH LOCK PER MIL-DTL-18240
- 2 NO CODE REQUIRED FOR SLOTTED HEADS.
- 3 WHEN USING THE HEX SOCKET CONFIGURATION, ADD .070 TO "L" LENGTH.
- 4 FOR LONGER LENGTHS, ADD .125 INCREMENTS PER LENGTH CODE
- 5 MAY BE USED WITH .020 DEEP C'BORE.
- 6 RECESS IS ONE SIZE SMALLER THAN NOMINAL SIZE REQUIRED FOR 100° FLAT HEAD.
- 7 -3A THREADS PER ASME B1.1. "M" THREADS PER ASME B1.13M.
- 8 COMPONENTS ARE FINISHED PRIOR TO THE ASSEMBLY PROCESS. DISCOLORATION OF THE BLACK ANODIZE MAY OCCUR ON THE CRIMPED PORTION OF THE KNOB DURING ASSEMBLY. A HIGH-ADHESION BLACK PAINT IS PERMITTED FOR TOUCH-UP AFTER ASSEMBLY.

INSTALLATION TOOLS: ( ) = THREAD SIZE CODE

ARBOR PRESS TOOL HW7600-( ), NOSE PIECE HN7513-( ), PULLER HP7523-( ), HANDLE ASSY TA7533;

COMPLETE HAND TOOL ASS'Y H8603-( ) (INCLUDES NOSE PIECE, PULLER & HANDLE)

PP	DCN 4279	05-22-06	 <b>Alcoa Fastening Systems</b> AEROSPACE FASTENER DIVISION 3724 EAST COLUMBIA STREET TUCSON, ARIZONA 85714 PHONE 520 519-7400 FAX 520 519-7427 www.alcofasteners.com	TITLE <b>TURN-LOC, LOW PROFILE, OPTIONAL RECESS</b>	
REV	DESCRIPTION/EC NO.	DATE		DATE 09/27/2004 DRAWN JLS CHECK <i>[Signature]</i> APPROVE	PART NUMBER <b>D7500</b> DRAWING NO. <b>S-0206</b> CAGE CODE <b>0HDW7</b>

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES

TOLERANCE UNLESS OTHERWISE NOTED:  
 .X = ±.05      ANGLES ±0.5°  
 .XX = ±.02  
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