Alcoa Fastening Systems

AEROSPACE FASTENER DIVISION
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TURN-LOC, HIGH PROFILE, OPTIONAL RECESS, ALUM KNOB .031 RADIAL FLOAT

TITLE

DATE 09/28/2004
PART NUMBER FRSS7500
DRAWING NO. S-1051
CHECK J.L.S.
CAGE CODE 0HDW7
REV. K

SCALE: 1:1 SHEET 1 OF 2
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<th>GRP CODE</th>
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<th>6, 6F, M3.5</th>
<th>8, 8F, M4</th>
<th>10, 10C, 10F, M5</th>
<th>12, 12C, 12F, M8</th>
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- **ASSEMBLIES NOT AVAILABLE**
- **FULLY RETRACTABLE ASSEMBLIES**
- **ASSEMBLIES NOT FULLY RETRACTABLE (STUD WILL PROTRUDE BELOW MINIMUM TOP PANEL THICKNESS)**

**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: 304 CRES per AMS QQ-S-763 or AMS 5639

SPRING: 302 CRES per ASTM-A313 or AMS 5888

WASHERS: 301 CRES per ASTM A 666 or AMS 5519 or Equivalent

**FINISH**

None: Stud, Spring, Sleeve & Washers: Passivate per AMS-QQ-P-35

KNOB: Anodize per MIL-A-8625, Type II, Class I

B: Stud & Washers:
- 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 drip 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. -3A threads per ASME B1.1. "M" threads per ANSI/ASME B1.13M.

6. Recess is one size smaller than nominal size required for 100° flat head.

7. 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:** ( ) indicates thread size code

Arbor Press Tool HN7600-( ), Removal Adapter Tool FRN7505-( ), Nose Piece HN7513-( ), Puller HP7523-( ), Handle Assembly T7533;
Complete Hand Tool Assy: H8603-( ) (includes nose piece, puller & handle)

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