

SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 32 MICROINCHES. OTHER SURFACES 125 MICROINCHES. GRIT BLASTED SURFACES 125 TO 250 MICROINCHES.

STUD STRAIGHT WITHIN .004 INCH PER INCH OF LENGTH. PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN .020 FIM. PITCH DIA PERPENDICULAR TO BASE WITHIN ±1 DEG.

LENGTH L DATA (LENGTH L IN SIXTEENTHS OF AN INCH)

CODE	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32
L	.250	.375	.500	.625	.750	.875	1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000

STUD MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA	ALUMINUM		ANODIZE	MIL-A-8625
CR	302, 303, 304 OR A-286 CRES	AMS 5513, 5516, 5636, 5637, 5638, 5639, 5640, 5641, 5647 AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS-QQ-P-35
CRA	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS-QQ-P-35
T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, OR 4967	NONE	

THREAD T DATA

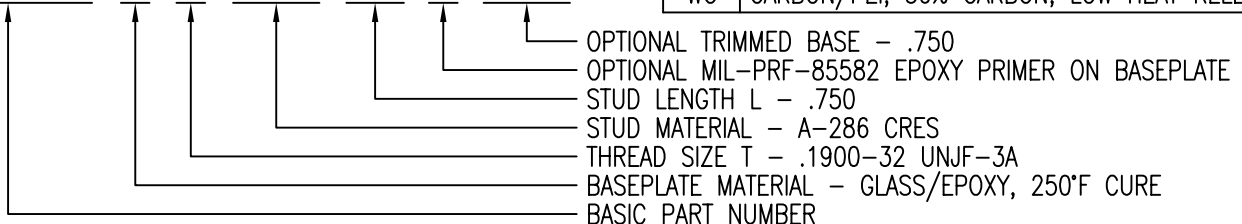
CODE	THREAD SIZE
06	.1380-32 UNJC-3A
08	.1640-32 UNJC-3A
3	.1900-32 UNJF-3A
4	.2500-28 UNJF-3A
5	.3125-24 UNJF-3A

BASEPLATE MATERIAL

CODE	MATERIAL
C	CARBON/EPOXY, 350°F CURE
E	GLASS/EPOXY, 350°F CURE
G	GLASS/EPOXY, 250°F CURE
U	GLASS/PEI, 30% GLASS
UC	CARBON/PEI, 30% CARBON
V	GLASS/PEI, 40% GLASS
VC	CARBON/PEI, 40% CARBON
W	GLASS/PEI, 30% GLASS, LOW HEAT RELEASE
WC	CARBON/PEI, 30% CARBON, LOW HEAT RELEASE

EXAMPLE PART NUMBER

CB4000 G 3 CRA 12 P 750



OPTIONAL TRIMMED BASE - .750  
 OPTIONAL MIL-PRF-85582 EPOXY PRIMER ON BASEPLATE  
 STUD LENGTH L - .750  
 STUD MATERIAL - A-286 CRES  
 THREAD SIZE T - .1900-32 UNJF-3A  
 BASEPLATE MATERIAL - GLASS/EPOXY, 250°F CURE  
 BASIC PART NUMBER

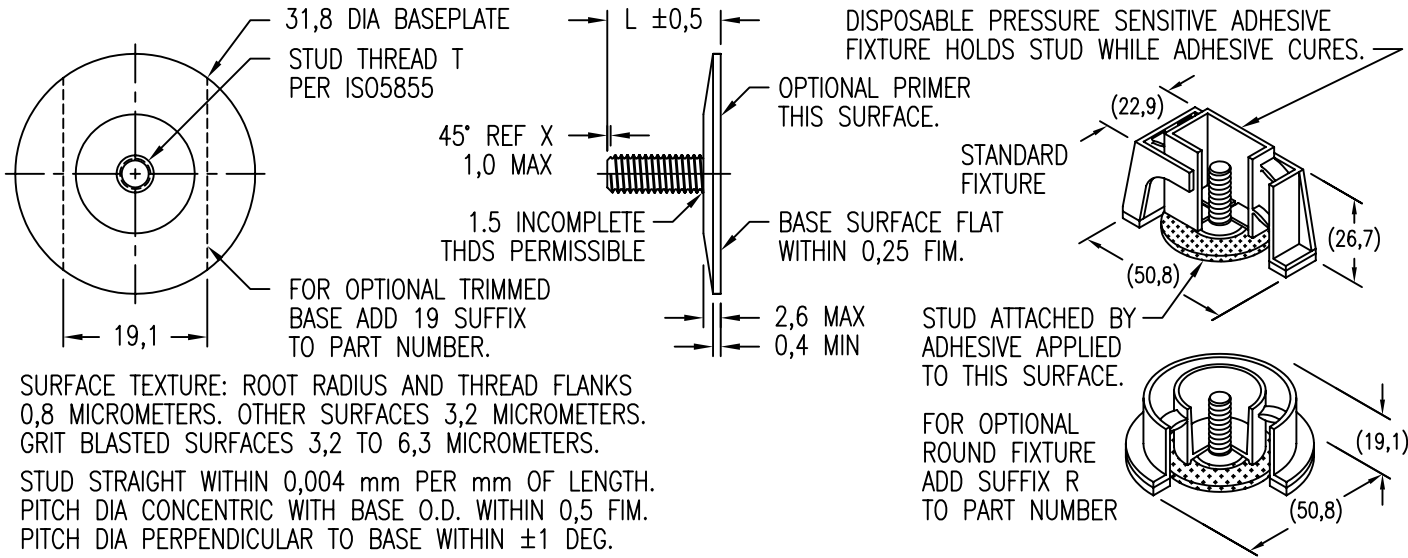
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

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**GLICK BOND**

CARSON CITY  
NEVADA 89706

CAD CB4000-1		APPROVALS		DATE	TITLE			
ANGLES	±1°	DRAWN	DAC	16DEC04	STUD, COMPOSITE BASE, ADHESIVE BONDED			
.XX	±.03	CHECKED	DAC/John	16DEC04	SIZE	CAGE CODE	DWG. NO.	REV.
.XXX	±.010	RELEASED	CGH	2JAN05	A	66530	CB4000	17
.XXXX	±.001	REVISED	DAC	16DEC04	SCALE	1/1 16DEC04		SHEET 1 OF 2



SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 0.8 MICROMETERS. OTHER SURFACES 3.2 MICROMETERS. GRIT BLASTED SURFACES 3.2 TO 6.3 MICROMETERS.

STUD STRAIGHT WITHIN 0.004 mm PER mm OF LENGTH. PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN 0.5 FIM. PITCH DIA PERPENDICULAR TO BASE WITHIN ±1 DEG.

STUD MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA	ALUMINUM		ANODIZE	MIL-A-8625
CR	302, 303, 304 OR A-286 CRES	AMS 5513, 5516, 5636, 5637, 5638, 5639, 5640, 5641, 5647 AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS-QQ-P-35
CRA	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS-QQ-P-35
T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, OR 4967	NONE	

LENGTH L DATA (LENGTH L IN MILLIMETERS)

CODE	6M	8M	10M	12M	15M	20M	25M	30M	35M
L	6	8	10	12	15	20	25	30	35

BASEPLATE MATERIAL

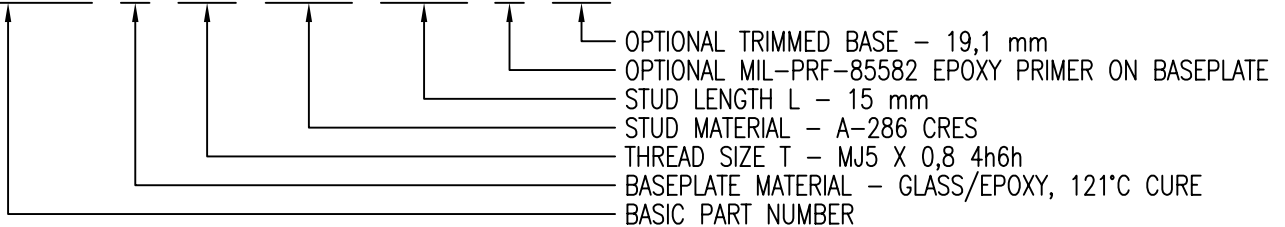
CODE	MATERIAL
C	CARBON/EPOXY, 177°C CURE
E	GLASS/EPOXY, 177°C CURE
G	GLASS/EPOXY, 121°C CURE
U	GLASS/PEI, 30% GLASS
UC	CARBON/PEI, 30% CARBON
V	GLASS/PEI, 40% GLASS
VC	CARBON/PEI, 40% CARBON
W	GLASS/PEI, 30% GLASS, LOW HEAT RELEASE
WC	CARBON/PEI, 30% CARBON, LOW HEAT RELEASE

THREAD T DATA

CODE	THREAD SIZE
3M	MJ3 X 0.5 4h6h
4M	MJ4 X 0.7 4h6h
5M	MJ5 X 0.8 4h6h
6M	MJ6 X 1.0 4h6h
8M	MJ8 X 1.0 4h6h

EXAMPLE PART NUMBER

CB4000 G 5M CRA 15M P 19



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NEVADA 89706

CAD CB4000-2 METRIC DIMENSIONS	
ANGLES	±1°
.XX	±0,8
.XXX	±0,25

APPROVALS	DATE
DRAWN <i>DAC</i>	16DEC04
CHECKED <i>DAC</i>	16DEC04
RELEASED <i>CGH</i>	2JAN05
REVISED <i>DAC</i>	16DEC04

TITLE STUD, COMPOSITE BASE, ADHESIVE BONDED			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB4000 (METRIC)	17
SCALE	1/1 16DEC04		SHEET 2 OF 2