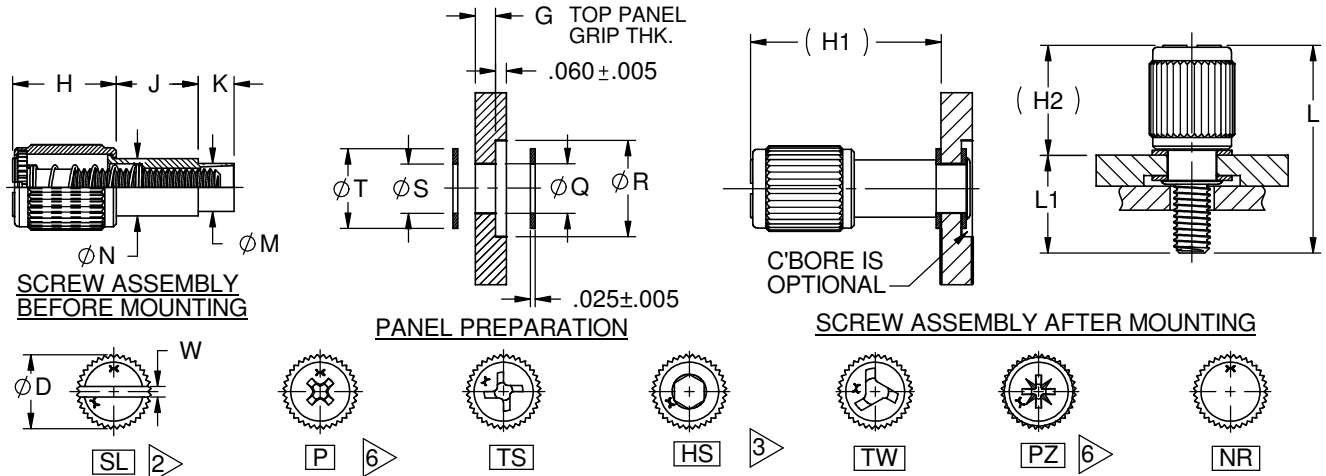


# Alcoa Fastening Systems & Rings



CURRENT DESIGN ACTIVITY  
CAGE CODE 0HDW7  
AFSR TUCSON OPERATIONS  
3724 EAST COLUMBIA STREET  
TUCSON, ARIZONA 85714  
PHONE (520) 519-7400  
FAX (520) 519-7454

# TURN-LOC® ENGINEERING STANDARD



THREAD SIZE CODE	Ø D	H		(H1)		(H2)		J	Ø M ±.005	Ø N ±.005	Ø Q +.004 -.001	Ø R	Ø S +.004 -.001	Ø T ±.010	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	.444	.374	.746	.676	.481	.411	.265	.177	.206	.250	.390	.185	.309	.040	4	2	2	3/32
6, 6F, M3.5	.356	.449	.379	.764	.694	.494	.424	.280	.202	.241	.272	.406	.209	.333	.044	4	3	4	7/64
8, 8F, M4	.420	.559	.489	.986	.916	.606	.536	.385	.215	.258	.281	.468	.223	.385	.049	6	4	6	9/64
10, 10C, 10F, M5	.451	.599	.529	1.061	.991	.641	.571	.427	.250	.297	.316	.500	.257	.415	.055	8	5	8	5/32
12, 12C, 12F, M6	.531	.604	.534	1.066	.996	.641	.571	.428	.313	.371	.386	.578	.323	.495	.062	10	6	10	3/16

### PART NUMBER CALLOUT

FRS ( ) 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	.639	.228	.650	.226	.685	.149	.832	.261	.745	.174
2	.764	.353	.775	.351	.810	.274	.957	.386	.870	.299
3	.889	.478	.900	.476	.935	.399	1.082	.511	.995	.424
4	1.014	.603	1.025	.601	1.060	.524	1.207	.636	1.120	.549
5	1.139	.728	1.150	.726	1.185	.649	1.332	.761	1.245	.674

CODE	FINISH
NONE	CLEAR
B	BLACK

THREAD SIZE CODE	THREAD SIZE	5	LEAD	THREAD SIZE CODE	THREAD SIZE	5	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		
12	.250-28 UNF-3A	SINGLE (COARSE)		M3.5	M3.5 x 0.6-4h6h	METRIC	
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
A	.020-.031	.125
B	.032-.093	.187
C	.094-.155	.250
D	.156-.217	.312
E	.218-.279	.375
F	.280-.341	.437

RECESS CODE	DRIVING RECESS AND SPECIFICATION	RECESS CODE	DRIVING RECESS AND SPECIFICATION
2	SLOT RECESS PER ANSI B18.6.3	PZ	RECESS PER TYPE 1A ANSI B18.6.3
6	HS	TS	RECESS PER NASM 33781
	NR	TW	RECESS PER NAS 4000
	P		CROSS RECESS PER NASM 9006

J PER DCN 12953, CHANGED INTERNATIONAL NOTE

TOLERANCE UNLESS OTHERWISE NOTED:  
.X = ±.05  
.XX = ±.02  
.XXX = ±.015  
ANGLES ±0.5°

DRAWN BY J. SCHLOBOHM  
CHECKED BY SIGNATURE ON FILE

ISSUED 10/19/2005  
REVISED 3/31/2015  
PAGE 1 OF 2

TURN-LOC®, HIGH PROFILE,  
OPTIONAL RECESS, CRES, .031 RADIAL FLOAT

DIMENSIONS IN INCHES

FRS( )7500  
S-1910

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