

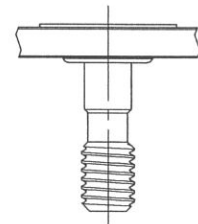
ASSEMBLY BEFORE MOUNTING

PANEL PREPARATION

ASSEMBLY AFTER MOUNTING

NOTE:
1 SEE APPROPRIATE THREAD LENGTH AVAILABILITY TABLE (SHEET 2) FOR "T" DIMENSION

THREAD SIZE CODE	(B)	Ø D ±.005	Ø D1	Ø D2 ±.005	Ø D3 ±.010	Ø N +.000 - .005	Ø Q +.005 - .000	T	(X)	RECESS SIZE	
										TW	P
10	.052	.495	.320	.385	.325	.253	.256	NOTE	.064	5	6
12	.036	.525	.312	.414	.319	.316	.322	1	.038	5	8



ASSEMBLY AFTER MOUNTING

PART NUMBER CALLOUT

DLMC 7900 () () - () - () - ()

MODEL	SERIES	LENGTH CODE	L ±.010	LENGTH CODE	L ±.010
3.5	.597	7	1.035		
4	.660	7.5	1.097		
4.5	.722	8	1.160		
5	.785	8.5	1.222		
5.5	.847	9	1.284		
6	.910	9.5	1.348		

INSTALLATION TOOLS:
() INDICATES THREAD SIZE CODE

ARBOR PRESS TOOL: HW7600-()
NOSE PIECE: HN7513-()
PULLER: HP7523-()
HANDLE: TA7533
COMPLETE HAND TOOL ASSEMBLY:
H8603-() (INCLUDES NOSE PIECE, PULLER & HANDLE)

THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD
10	.190-32 UNJF-3A	SINGLE
12	.250-28 UNJF-3A	

GRIP CODE	G (TOP PANEL GRIP THICKNESS)	K	A
B	.090-.125	.147	.087
C	.126-.187	.210	.095
D	.188-.250	.272	.157
E	.251-.312	.335	.220
F	.313-.375	.397	.282
G	.376-.437	.459	.344
H	.437-.500	.521	.406
J	.501-.562	.583	.468
M	.563-.625	.645	.530

CODE	SCREW MATERIAL
NONE	8740 ALLOY STEEL
L	A-286 CRES
T	6AL-V TITANIUM

CODE	DRIVING RECESS
P	CROSS RECESS PER NASM 9006
TW	TRI-WING RECESS PER NAS 4000

M PER DCN 10027, REVISED FINISH MATERIAL DESIGNATIONS CHANGED TO CURRENT STANDARDS FORMAT, REMOVED DASH

ISSUED	5/12/2005
REVISED	12/19/11
PAGE	1 OF 2

CAPTIVE SCREW, SIZE 10 & 12,
100° FLUSH HEAD

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

DRAWN BY: J. SCHLOBOHM
CHECKED BY: J. CALLAWAY
DLMC7900
S-1632



GRIP CODE	SIZE 10 THREAD AVAILABILITY TABLE													
	("T"=.250 UNLESS OTHERWISE INDICATED BELOW)													
	3	3.5	4	4.5	5	5.5	6	6.5	7	7.5	8	8.5	9	9.5
B														
C														
D	.223													
E	.160	.223								.250				
F	O	.160	.223											
G	O	O	.160	.223										
H	O	O	O	.160	.223									
J	O	O	O	O	.160	.223								
M	O	O	O	O	O	.160	.223							



ASSEMBLIES NOT AVAILABLE



ASSEMBLIES AVAILABLE WITH FULL THREAD LENGTH " T "

GRIP CODE	SIZE 12 THREAD AVAILABILITY TABLE													
	("T"=.280 UNLESS OTHERWISE INDICATED BELOW)													
	3	3.5	4	4.5	5	5.5	6	6.5	7	7.5	8	8.5	9	9.5
B														
C														
D	.223													
E	.160	.223								.280				
F	O	.160	.223											
G	O	O	.160	.223										
H	O	O	O	.160	.223									
J	O	O	O	O	.160	.223								
M	O	O	O	O	O	.160	.223							



ASSEMBLIES NOT AVAILABLE



ASSEMBLIES AVAILABLE WITH FULL THREAD LENGTH " T "

MATERIAL

STUD:

8740 ALLOY STEEL PER AMS 6322, HEAT TREAT TO 160 KSI MIN. ULTIMATE TENSILE STRENGTH
A-286 CRES PER AMS 5732 OR AMS 5737 OR EQUIV, HEAT TREAT TO 160 KSI MIN. ULTIMATE TENSILE STRENGTH
6Al-4V TITANIUM PER AMS 4928 OR AMS 4967, HEAT TREAT TO 160 KSI MIN. ULTIMATE TENSILE STRENGTH

SLEEVE: 304 CRES PER AMS 5639 OR AMS-QQ-S-763

FINISH

CODE L AND CODE NONE COMPONENTS:

CAD PLATE (YELLOW) PER AMS QQ-P-416, TYPE II, CLASS 2 EXCEPT THAT INCOMPLETE COVERAGE AND DIS-COLORATION IS ALLOWED ON SCREW SHANK AREA.
A-286 AND 304 COMPONENTS: PASSIVATE PER AMS2700 AND AMS-QQ-P-35 BEFORE PLATING.

CODE T COMPONENTS:

6Al-4V TITANIUM: ANODIZE PER AMS2488
304 CRES: A-286 AND 304 COMPONENTS: PASSIVATE PER AMS 2700 AND AMS-QQ-P-35.

ISSUED	5/12/2005	PER DCN 10027, REVISED FINISH MATERIAL DESIGNATIONS CHANGED TO CURRENT STANDARDS FORMAT, REMOVED DASH	TOLERANCE UNLESS OTHERWISE NOTED: X = ±.05 XX = ±.02 XXX = ±.015 ANGLES ±0.5°	DRAWN BY	J. SCHLOBOHM	SIGNER	
				CHECKED BY	J. CALLAWAY		
				DLMC7900			
REVISID	12/19/11	CAPTIVE SCREW, SIZE 10 & 12, 100° FLUSH HEAD	DIMENSIONS IN INCHES	S-1632			
PAGE	2 OF 2						

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