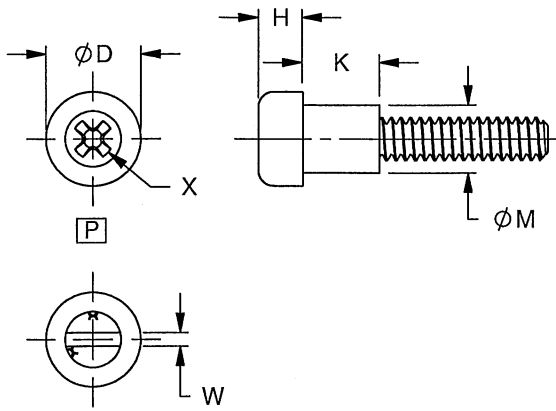


ORIGINAL
Red Ink Indicates
Original Copy

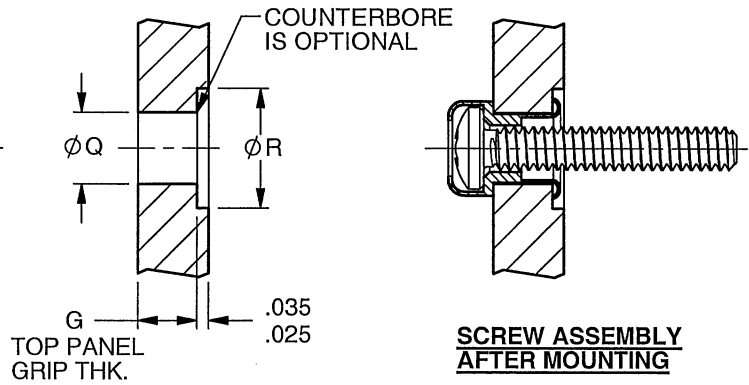
REV **N**

S-2995

DRAWING NO.



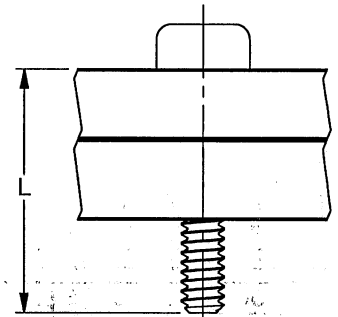
SCREW ASSEMBLY BEFORE MOUNTING



PANEL PREPARATION

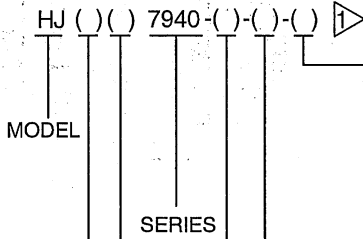
SCREW ASSEMBLY AFTER MOUNTING

THREAD SIZE CODE	Ø D MAX	H MAX	Ø M +.005 -0.000	Ø Q +.004 -0.001	Ø R +.020 -0.000	W		X DRIVER SIZE
						MAX	MIN	
2, M2.5	.230	.135	.160	.171	.296	.031	.023	1
4, M3	.268	.143	.175	.187	.312	.039	.031	1
6, M3.5	.332	.157	.200	.213	.332	.048	.039	2
8, M4	.372	.166	.213	.228	.341	.054	.045	2
10, 10C, M5	.380	.180	.248	.257	.355	.060	.050	2
12, 12C, M6	.465	.219	.311	.323	.394	.075	.064	3



SCREW ASSEMBLY AFTER MOUNTING

PART NUMBER CALLOUT



LENGTH CODE	L
.75	.188
1	.250
2	.375
3	.500
4	.625
5	.750
6	.875

GRIP CODE	G (TOP PANEL GRIP THK)	K ±.005
A	.031-.062	.104
B	.063-.093	.135
C	.094-.125	.167
D	.126-.156	.198
E	.157-.188	.230
F	.189-.219	.261

CODE	FINISH
NONE	CLEAR
B	BLACK

THREAD SIZE CODE	THREAD SIZE PER ASME B1.1	LEAD	THREAD SIZE CODE	THREAD SIZE PER ASME B1.13M	LEAD
2	.086-56 UNC-2A	SINGLE	M2.5	M2.5 x 0.45-6g	METRIC
4	.112-40 UNC-2A		M3	M3 x 0.5-6g	
6	.138-32 UNC-2A		M3.5	M3.5 x 0.6-6g	
8	.164-32 UNC-2A		M4	M4 x 0.7-6g	
10	.190-32 UNF-2A		M5	M5 x 0.8-6g	
12	.250-28 UNF-2A		M6	M6 x 1.0-6g	
10C	.190-24 UNC-2A	SINGLE (COARSE)			
12C	.250-20 UNC-2A				

RECESS CODE	DRIVING RECESS AND SPECIFICATION
	SLOT RECESS PER ANSIB18.6.3
P	CROSS RECESS PER NASM 9006

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N	DCN 4162	04-04-06
REV	DESCRIPTION/EC NO.	DATE

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

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

TITLE			
CAPTIVE SCREW, ALL SIZES, OPTIONAL RECESS			
DATE	PART NUMBER	HJ () () 7940	
11/03/2005			
DRAWN	DRAWING NO.	S-2995	
JLS			
CHECK	CAGE CODE	OHDW7	REV N
APPROVE	SCALE: 2:1	SHEET 1 OF 2	

ORIGINAL
Red Ink Indicates

Original Copy
DRAWING NO.

REV
N

S-2995

MATERIAL

STUD: 302 CRES PER AMS 5636 OR ASTM-A-493

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

FINISH

NONE: BOTH COMPONENTS: PASSIVATE PER AMS QQ-P-35

B: BOTH COMPONENTS: BLACK OXIDE PER MIL-C-13924, CLASS 4

NOTES:

- 1 ▷ LETTERS AT THE END OF PART NUMBER DESIGNATE SPECIAL ASSEMBLIES:
DL - ASSEMBLIES WITH DRI LUBE THREADS PER MIL-PRF-46010
DL IS NOT AVAILABLE ON BLACK OXIDE ASSEMBLIES
- 2 ▷ NO CODE REQUIRED FOR SLOTTED RECESSED HEADS.
- 3 AXIAL FLOAT TO BE .020 MAXIMUM
- 4 ▷ USE OF THE HAND TOOL IS NOT RECOMMENDED FOR SIZE 2, 4 & 6 SCREWS.
USE ARBOR PRESS TOOL ONLY. ANVIL AND ARBOR PRESS TOOL ARE TO BE
UTILIZED TOGETHER FOR SIZES 4 & 6 ONLY. HOWEVER, HJ7503-2 HAND TOOL
WITH SPECIAL NOSE PIECE HNJ7513-2 IS AVAILABLE FOR SIZE 2 ONLY, PER
CUSTOMER REQUEST.

INSTALLATION TOOLS:

() INDICATES THREAD SIZE CODE


COMPLETE ASSEMBLY H8603-() INCLUDES NOSE PIECE, PULLER, AND HANDLE ASSY

OR

ARBOR PRESS INSTALLATION TOOL
(* ANVIL AND ARBOR ARE TO BE UTILIZED TOGETHER)
REMOVAL TOOL RJC7610-(), ARBOR PRESS * HW7600-(), ANVIL* DT1071-()

HAND INSTALLATION TOOL
NOSE PIECE HN7513-(), PULLER HP7523-(), HANDLE ASSEMBLY TA7533

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N	DCN 4162	04-04-06	 Alcoa Fastening Systems AEROSPACE FASTENER DIVISION 3724 EAST COLUMBIA STREET TUCSON, ARIZONA 85714 PHONE 520 519-7400 FAX 520 519-7427 www.alcoafasteners.com	TITLE CAPTIVE SCREW, ALL SIZES, OPTIONAL RECESS	
REV	DESCRIPTION/EC NO.	DATE		DATE 11/03/2005 DRAWN JLS CHECK <i>[Signature]</i> APPROVE	PART NUMBER HJ() ()7940 DRAWING NO. S-2995 CAGE CODE 0HDW7
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES TOLERANCE UNLESS OTHERWISE NOTED: .X = ±.05 ANGLES ±0.5° .XX = ±.02 .XXX = ±.015					