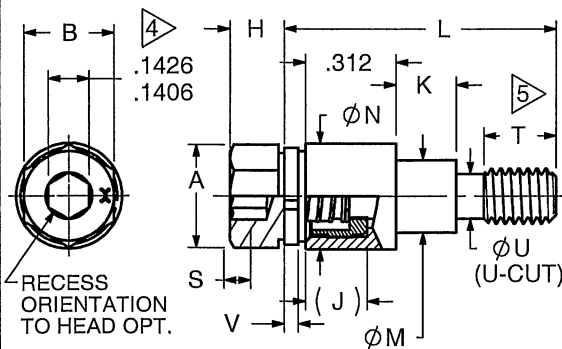
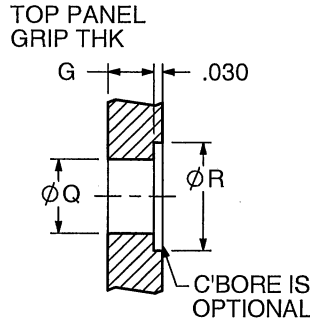


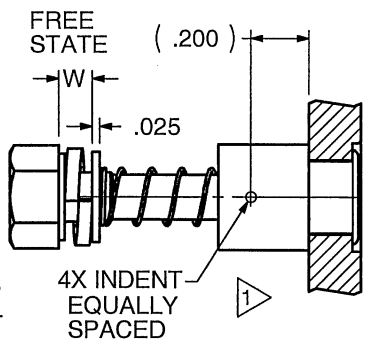
REV L
DRAWING NO. S-2549



ASSEMBLY BEFORE MOUNTING



PANEL PREPARATION



ASSEMBLY AFTER MOUNTING

THREAD SIZE CODE	A MIN	B	H +.006 -.000	Ø N	ØM ±.005	ØQ +.004 -.001	ØR +.020 -.000	S MAX	T	ØU	V	W
10	.340	.312 .305	.181	.365	.250	.257	.375	.114	.250	.157 .153	.047	.094
12	.409	.375 .367	.306	.437 .427	.313	.323	.437	.161	.281	.213 .206	.056	.112

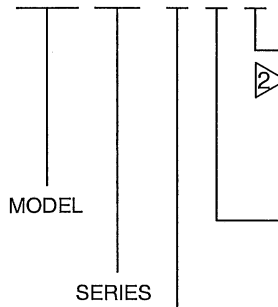
INSTALLATION TOOLS:
() INDICATES THREAD SIZE CODE

HAND TOOL:
H7503-() (INCLUDES NOSE PIECE, PULLER & HANDLE)

ARBOR PRESS TOOL: HW7600-()

PART NUMBER CALLOUT

HLWA 7900 -()-()-()



LENGTH CODE	L		L1 ±.020
	10	12	
5	.884	.899	.500
6.5	.977	.993	.593
7	1.009	1.024	.650
11	1.259	1.274	.870

GRIP CODE	G TOP PANEL GRIP THK	K	J
	B	.063-.125	.147
C	.126-.187	.210	.212
D	.188-.250	.272	.275

THREAD SIZE CODE	THREAD SIZE	3	LEAD
	10	.190-32 UNJF-3A	
12	.250-28 UNJF-3A		

NOTES:

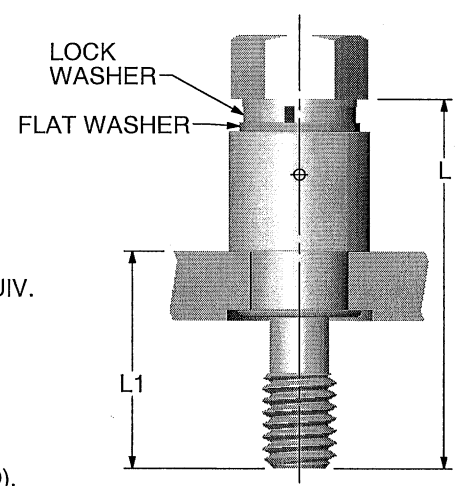
- 1 SOME ASSEMBLIES DO NOT REQUIRE A BUSHING OR TO BE INDENTED.
- 2 FOR LONGER ASSEMBLIES CONTACT ENGINEERING DEPARTMENT.
- 3 FORMED THREADS PER SAE-AS-8879.
- 4 HEX HEAD/HEX RECESS PER ANSI B18.6
- 5 ASSY -10-D-5 HAS .187 (T) THD LENGTH.

MATERIAL

- STUD: 302 CRES PER AMS 5636, AMS 5637 OR ASTM-A-493
- SLEEVE: 6061-T6 ALUM PER AMS 4117 AND AMS-QQ-A-225/8
- SPRING: 302 CRES PER AMS 5688 OR ASTM-A-313
- FLAT WASHER: 300 SERIES CRES PER MIL-S-5059, AMS 5517, OR EQUIV.
- LOCK WASHER: 300 SERIES CRES PER ASME B18.21.1
- BUSHING: 7075 ALUM PER AMS 4122 OR AMS-QQ-A-225/9

FINISH

- BUSHING: ANODIZE PER MIL-A-8625, TYPE II, CLASS 1 (OPT DYE RED).
- SLEEVE: ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
- ALL OTHER COMPONENTS: PASSIVATE PER AMS QQ-P-35



ASSEMBLY AFTER MOUNTING

ORIGINAL
Huck Industries
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L	DCN 4354	06-26-06
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 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, HEX HEAD, HEX RECESS, INTERNAL FLOAT, FIXED THREAD LENGTH, SPRING-LOADED			
DATE 12/21/2004	PART NUMBER HLWA7900		
DRAWN JLS	DRAWING NO. S-2549		
CHECK <i>[Signature]</i>	CAGE CODE 0HDW7	REV L	
APPROVE	SCALE: 1.5:1	SHEET 1 OF 1	