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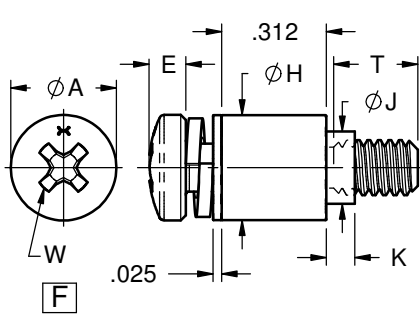
Alcoa Fastening Systems & Rings



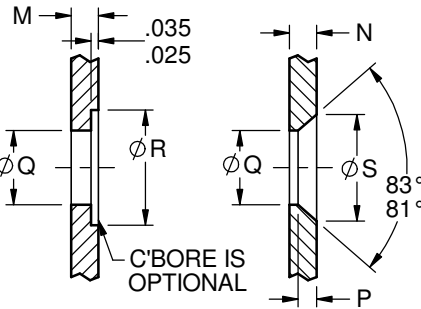
CURRENT DESIGN ACTIVITY
 CAGE CODE 0HDW7
 AFSR TUCSON OPERATIONS
 3724 EAST COLUMBIA STREET
 TUCSON, ARIZONA 85714
 PHONE (520) 519-7400
 FAX (520) 519-7454

CAPTIVE SCREW

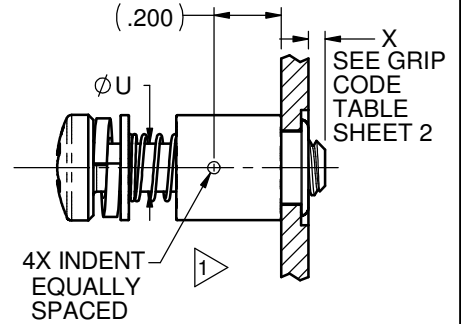
ENGINEERING STANDARD



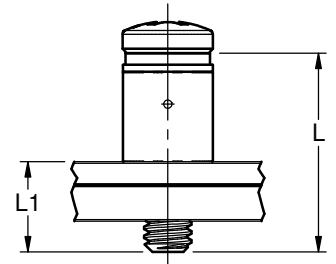
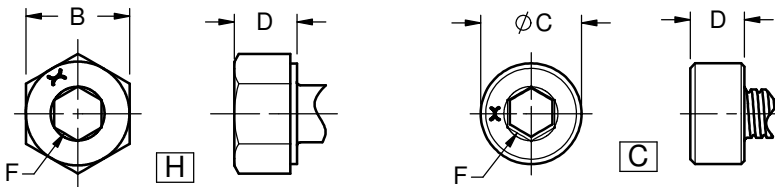
ASSEMBLY BEFORE MOUNTING



PANEL PREPARATION



ASSEMBLY AFTER MOUNTING



ASSEMBLY AFTER MOUNTING

THREAD SIZE CODE	Ø A	B ±.004	C	D	E	F	Ø H ±.010	Ø J ±.005	Ø Q +.004 - .001	Ø R +.020 - .000	Ø S +.004 - .001	T	Ø U	W
4	.212	.185	.180	.110	.075	3/32	.219	.178	.187	.281	.248	.203	.067-.072	4
6	.263	.247	.222	.136	.092	7/64	.265	.202	.209	.312	.287	.203	.090-.095	6
8	.314		.266	.162	.110	9/64	.312	.215	.221	.343	.317	.250	.126-.129	8
10	.365	.309	.308	.187	.128	5/32	.365	.250	.257	.375	.353	.250	.153-.157	10
12	.482	.371	.370	.247	.168	3/16	.437	.313	.323	.437	.431	.281	.210-.213	1/4

PART NUMBER CALLOUT

() LW 7900 () - () - () - ()

MODEL

SERIES

LENGTH CODE	L				L1 ±.020	LENGTH CODE	L				L1 ±.020		
	4	6	8	10			12	4	6	8		10	12
1	.612	.618			NA	.250	6	.924	.930	.939	.946	.961	.562
2	.674	.680	.690	.697	.712	.312	6.5	.956	.962	.970	.977	.993	.594
2.5	.705	.712	.720	.728	.743	.344	7	.987	.993	1.002	1.009	1.024	.625
3	.737	.743	.752	.759	.774	.375	7.5	1.018	1.024	1.033	1.040	1.055	.656
3.5	.768	.774	.783	.790	.805	.406	8	1.049	1.055	1.064	1.071	1.086	.687
4	.799	.805	.814	.821	.836	.437	8.5	1.080	1.086	1.095	1.102	1.117	.718
4.5	.831	.837	.845	.852	.868	.469	9	1.112	1.118	1.127	1.134	1.149	.750
5	.862	.868	.877	.884	.899	.500	9.5	1.143	1.149	1.158	1.165	1.180	.781
5.5	.893	.899	.908	.915	.930	.531	10	1.174	1.180	1.189	1.197	1.211	.812

GRIP CODE	M	N	K ±.005	P MAX				GRIP CODE	M	N	K ±.005	P MAX			
				4	6	8, 10	12					4	6	8, 10	12
AA	NA	.055-.070	.065	.030				DD	NA	.231-.255	.240				
A	.020-.031	.071-.105	.085	.045				D	.188-.250	.256-.305	.272				
BB	.041-.093	.106-.134	.116	.035 .045				EE	NA	.306-.325	.303	.035	.045	.055	.062
B	.063-.125	.135-.160	.147	.055 .062				E	.251-.312	.326-.355	.335				
CC	NA	.161-.195	.178					FF	NA	.356-.380	.365				
C	.126-.187	.196-.230	.210					F	.313-.375	.381-.425	.397				

MATL CODE	TYPE
NONE	302
L	A-286

RECESS CODE	DRIVING RECESS AND SPECIFICATION
C	HEX SOCKET HEAD PER ANSIB18.6
F	CROSS RECESS PER NASM 9006
H	HEX HEAD/RECESS PER ANSIB18.6

THREAD SIZE CODE	THREAD SIZE PER ASME B1.1	LEAD	THREAD SIZE CODE	THREAD SIZE PER ASME B1.1	LEAD
4	.112-40 UNC-2A	SINGLE	4F	.112-40 UNC-2A	DOUBLE
6	.138-32 UNC-2A		6F	.138-32 UNC-2A	
8	.164-32 UNC-2A		8F	.164-32 UNC-2A	
10	.190-32 UNF-2A		10F	.190-32 UNF-2A	
12	.250-28 UNF-2A		12F	.250-28 UNF-2A	QUAD

AC PER DCN 12954, CHANGED FROM Alcoa Fastening Systems AND AFS TO Alcoa Fastening Systems & Rings AND AFSR

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

DRAWN BY: J. SCHLOBOHM
 CHECKED BY: SIGNATURE ON FILE

ISSUED 10/6/2004
 REVISED 3/31/2015
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CAPTIVE SCREW, INTERNAL FLOAT, HIGH PROFILE, SPRING-LOADED, FIXED THREAD LENGTH

DIMENSIONS IN INCHES

() LW7900 S-2374

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AC

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THREAD CODE	GRIP CODE											
	X			X IS NOT APPLICABLE								
	AA	A	BB	B	CC	C	DD	D	EE	E	FF	F
4	.063	.048	.030	FULLY RETRACTABLE								
6												
8	.070	.050										
10												
12												

ASSEMBLIES NOT AVAILABLE

MATERIAL

STUD:
NONE: 302 CRES PER AMS 5636 OR ASTM-A-493
L: A-286 CRES PER AMS 5737, H.T TO 160 KSI MIN.

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 2 DYED RED.

SLEEVE: ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.

ALL OTHER COMPONENTS: PASSIVATE PER AMS2700

NOTES UNLESS SPECIFIED OTHERWISE:

- 1 SOME ASSEMBLIES DO NOT REQUIRE A BUSHING OR TO BE INDENTED.
- 2 FOR LONGER ASSEMBLIES CONTACT ENGINEERING DEPARTMENT.

INSTALLATION TOOLS

() INDICATES THREAD SIZE CODE

HANDLE	PULLER	NOSE PIECE		ARBOR PRESS TOOL	
		C'SINK	C'BORE	C'SINK	C'BORE
TA7533	HP7523-()	HNG7513-()	HN7513-()	DW7600-()	HW7600-()

AC

PER DCN 12954, CHANGED FROM Alcoa Fastening Systems AND AFS
TO Alcoa Fastening Systems & Rings AND AFSR

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

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PAGE 2 OF 2

**CAPTIVE SCREW, INTERNAL FLOAT,
HIGH PROFILE, SPRING-LOADED, FIXED THREAD LENGTH**

DIMENSIONS IN INCHES

**()LW7900
S-2374**