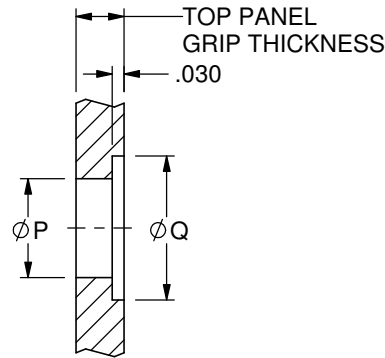
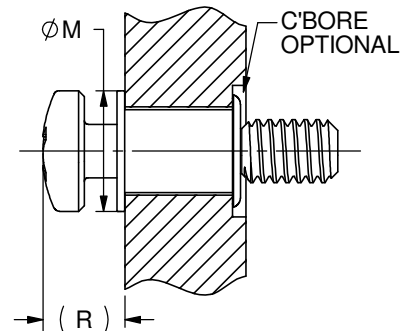


**SCREW ASSEMBLY  
BEFORE MOUNTING**



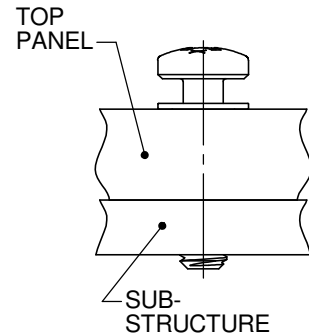
**PANEL  
PREPARATION**



**SCREW ASSEMBLY  
AFTER MOUNTING**

USE INSTALLATION TOOL H8603-(X) OR  
H8603-(XF) FOR MULTI-LEAD THREADS  
(X) INDICATES SIZE

THREAD SIZE CODE	X	Ø M ±.006	Ø G	H	Ø N ±.005	Ø P +.004 - .001	Ø Q	(R)	T	U NOM	MIN. TENSILE STR. LBS	MIN. ULT. SHEAR STR. LBS
6	6	.265	.263	.092	.202	.209	.312	.112	.091	.203	900	1100
8	8	.314	.315	.110	.215	.221	.343	.130	.108	.250	1700	1400
10	10	.365	.360	.128	.250	.257	.375	.148	.124	.250	2000	2600
12	1/4	.492	.475	.169	.313	.323	.437	.189	.161	.281	3500	4300



**SCREW ASSEMBLY  
AFTER MOUNTING**

**PART NUMBER STRUCTURE**

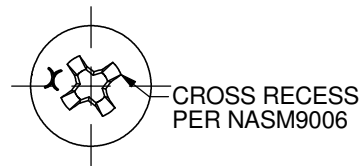
PPDS 7900 - ( ) - ( ) - ( ) <sup>3</sup>  
 PPD 7900 - ( ) - ( ) - ( )  
 PLD 7900 - ( ) - ( ) - ( )

MODEL  
 SERIES

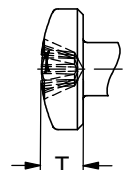
LENGTH CODE	L
1	.285
2	.410
3	.535
3.5	.597
4	.660
4.5	.722
5	.785
5.5	.847
6	.910
7	1.035
8	1.160
8.5	1.222

GRIP CODE	TOP PANEL GRIP THICKNESS	K	Y
A	.031-.062	.085	.020
B	.063-.125	.147	
C	.126-.187	.210	
D	.188-.250	.272	
E	.251-.312	.335	
F	.313-.375	.397	.062
G	.376-.437	.460	
H	.438-.500	.522	
J	.501-.562	.583	
K	.563-.625	.647	

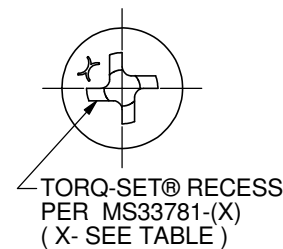
THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD
6	.138-32 UNJC-3A	SINGLE
8	.164-32 UNJC-3A	
10	.190-32 UNJF-3A	
12	.250-28 UNJF-3A	



**PPDS7900  
PPD7900**



**CROSS RECESS DEPTH**



**PLD7900**

**W** PER DCN 10143, CORRECTED TABLE - 10 DIA. ULT. SHEAR STRENGTH, REVISED SHEET FORMAT PER CURRENT STANDARD

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

DRAWN BY J. SCHLOBOHM SIGNER INITIALS  
 CHECKED BY J. CALLAWAY

**PPD( )/PLD7900**

**S-0998**

ISSUED 1/2/2004  
 REVISED 10/21/2011  
 PAGE 1 OF 2

**CAPTIVE SCREW, ALL SIZES,  
TORQ-SET® & CROSS RECESS**

DIMENSIONS IN INCHES

THIS DRAWING, THE STRUCTURAL DESIGN DISCLOSED THEREIN AND THE TECHNICAL DATA AND ENGINEERING SERVICE REPRESENTED THEREBY ARE THE EXCLUSIVE PROPERTY OF HUCK INTERNATIONAL, INC.

W



NOTES UNLESS SPECIFIED OTHERWISE:

- ① .335 FOR 1/4-28 UNJF
- ② THREADED PORTION CAN ONLY BE MET WHEN STUD LENGTH L PERMITS. SEE THREAD LENGTH AVAILABILITY TABLE.
- ③ CONDENSED PART NUMBERS TO MEET DATA ENTRY FIELD LENGTH LIMITATIONS (EXAMPLE: PPD79-10-B-2 VS PPD7900-10-B-2) ARE EQUIVALENT TO THE STANDARD PART NUMBER CALLOUT.

**MATERIAL :**

**STUD :**

ALL SIZES :

PPD & PLD : 8740 ALLOY STEEL PER AMS 6322 OR EQUIVALENT; HEAT TREAT TO HRC 38-41  
PPDS : A-286 CRES PER AMS 5732 OR 5737; HEAT TREAT TO 160 KSI MIN.

**SLEEVE :**

ALL SIZES : 304 CRES PER MIL-S-23195 AND AMS 5639 AND AMS-QQ-S-763

**FINISH :**

STUD AND SLEEVE: CAD PLATE PER AMS QQ-P-416, TYPE II, CLASS 2

THREAD LENGTH AVAILABILITY TABLE										
GRIP CODE	SIZES 6, 8, 10									
	1	2	3	3.5	4	4.5	5	5.5	6	7-8.5
A	.140									
B		.203								
C		.140								U
D			.203							NOM
E			.140	.203						
F				.140	.203					
G					.140	.203				
H						.140	.203			
J							.140	.203		
K								.140	.203	

GRIP CODE	SIZE 12									
	3	3.5	4	4.5	5	5.5	6	7	8	8.5
A										
B										
C	.260									U = .281
D	.197	.260								
E		.197	.260							
F			.197	.260						
G				.197	.260					
H					.197	.260				
J						.197	.260			
K							.197	.260		

ASSEMBLIES NOT AVAILABLE  
 ASSEMBLIES AVAILABLE WITH FULL THREAD LENGTH; OTHERWISE, LENGTH AS INDICATED

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<b>W</b>	PER DCN 10143, CORRECTED TABLE - 10 DIA. ULT. SHEAR STRENGTH, REVISED SHEET FORMAT PER CURRENT STANDARD		TOLERANCE UNLESS OTHERWISE NOTED: .X = ±.05 .XX = ±.02 .XXX = ±.015 ANGLES ±0.5°	DRAWN BY	J. SCHLOBOHM	SIGNER INITIALS
	ISSUED	1/2/2004		CHECKED BY	J. CALLAWAY	
	REVISIED	10/21/2011		<b>PPD( )/PLD7900</b>		
PAGE	2 OF 2	CAPTIVE SCREW, ALL SIZES, TORQ-SET ® & CROSS RECESS		<b>S-0998</b>		
				DIMENSIONS IN INCHES		