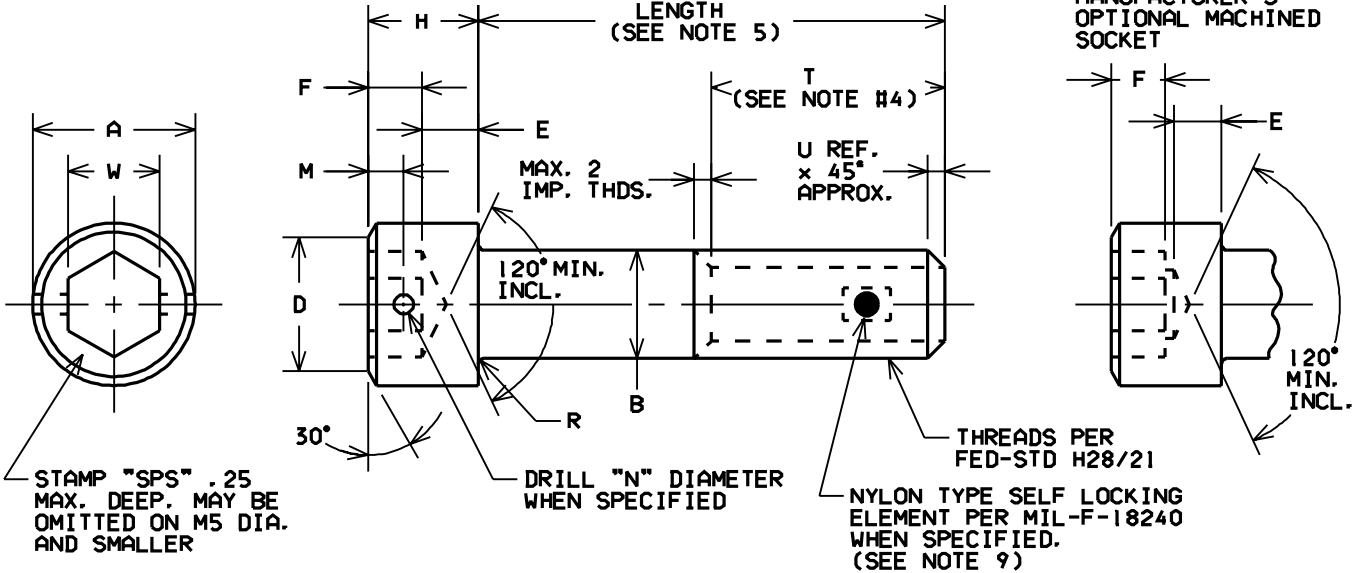


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DRAWING NUMBER
SD-300-111473

REVISION

FIRST DASH NO.	NOM. SIZE	THREAD SIZE	A DIA.	B DIA.	D DIA.	E MIN.	F MIN.	H	M	N	R	T	U REF.	W	X	Y
-204	M2	MJ2-.40	3.80 3.65	2.00 1.86	3.42 3.27	0.68	1.00	2.50 2.00	—	—	0.3 0.1	16.00	0.6	1.545 1.520	.15	.13
-254	M2.5	MJ2.5-.45	4.50 4.33	2.50 2.36	4.00 3.75	0.90	1.25	3.00 2.50	—	—	0.3 0.1	17.00	0.7	2.045 2.020	.15	.13
-350	M3	MJ3-.50	5.50 5.32	3.00 2.86	4.75 4.50	1.20	1.50	3.50 3.00	0.75	1.14 1.00	0.4 0.2	18.00	0.75	2.56 2.52	.15	.13
-470	M4	MJ4-.70	7.00 6.80	4.00 3.82	5.95 5.70	1.70	2.00	4.50 4.00	1.23	1.14 1.00	0.4 0.2	20.00	1.0	3.07 3.02	.15	.13
-580	M5	MJ5-.80	8.50 8.26	5.00 4.82	7.20 6.95	2.15	2.50	5.00 4.50	1.30	1.14 1.00	0.5 0.3	22.00	1.2	4.07 4.02	.15	.15
-610	M6	MJ6-1.00	10.00 9.78	6.00 5.82	8.70 8.45	2.60	3.00	6.50 6.00	1.40	1.54 1.40	0.7 0.5	24.00	1.5	5.08 5.02	.15	.18
-810	M8	MJ8-1.00	13.00	8.00	11.20	3.50	4.07	8.50	1.40	1.54	0.7	28.00	1.9	6.09	.16	.24
-812		MJ8-1.25	12.73	7.78	10.95			8.00						1.40		
-1012	M10	MJ10-1.25	16.00	10.00	14.00	4.55	5.00	10.50	1.50	1.74	0.8	32.00	2.3	8.11	.20	.30
-1015		MJ10-1.50	15.73	9.78	13.70			10.00						1.60		
-1212	M12	MJ12-1.25	18.00	12.00	16.15	5.50	6.02	12.50	2.00	1.74	0.9	36.00	2.6	10.12	.24	.36
-1217		MJ12-1.75	17.73	11.73	15.80			12.00						1.60		
-1415	M14	MJ14-1.50	21.00	14.00	18.60	6.50	7.00	14.50	2.50	1.74	1.1	40.00	3.0	12.13	.28	.54
-1420		MJ14-2.00	20.67	13.73	18.25			14.00						1.60		

MATERIAL: 6AL-4V TITANIUM PER AMS4928 OR AMS4967

HEAT TREATMENT: 1100 MPa MINIMUM ULTIMATE TENSILE STRENGTH.

FINISH: NONE OR TIODIZE T2 OR DRY FILM LUBE PER MIL-L-46010, TYPE I. (SEE CODES)

TOLERANCES: .25 AND: 2° UNLESS OTHERWISE SPECIFIED

STANDARDS AND SPECIFICATIONS AS NOTED	TITLE	DRAWN BY G.K. DATE 9/20/91
CAGE IDENT. NO. 80539	SCREW, SOCKET HEAD CAP 6-4 TITANIUM, METRIC	APPROVED DATE
CUSTODIAN: SANTA ANA, CA.		PART NUMBER 111473-(X)-(X)

NOTES:

- (1). CONCENTRICITY: HEAD O.D. TO BODY WITHIN "X" T. I. R.,
SOCKET TO BODY WITHIN "Y" T. I. R..
- (2). SQUARENESS: UNDERSIDE OF HEAD AND BODY WITHIN 1/2".
- (3). CODES: ADD A SECOND DASH NUMBER TO BASIC PART NUMBER TO DESIGNATE LENGTH IN MILLIMETERS.
LETTER "V" IN LIEU OF FIRST DASH INDICATES 6AL-4V TITANIUM.
LETTER "T2" AFTER SECOND DASH NUMBER DESIGNATES TIODIZE TYPE 2.
LETTER "H" IN LIEU OF SECOND DASH INDICATES CROSSDRILLED HEAD.
LETTER "K" AFTER SECOND DASH NUMBER INDICATES A NYLON (PELLET TYPE) SELF LOCKING
ELEMENT PER MIL-F-18240.
LETTER "E" AFTER SECOND DASH NUMBER INDICATES A NYLON (PATCH TYPE) SELF LOCKING
ELEMENT PER MIL-F-18240.
LETTER "M" AFTER SECOND DASH NUMBER INDICATES MIL-L-46010 DRY FILM LUBRICANT.
EXAMPLES: 111473V470-25K = MJ4-.70 X 25MM SHCS. 6-4 TITANIUM MATERIAL. WITH NYLON PELLET
SELF LOCKING ELEMENT.
111473V812-25E = MJ8-1.25 X 25MM SHCS. 6-4 TITANIUM MATERIAL. WITH NYLON PATCH SELF
LOCKING ELEMENT.
111473V1420H25M = MJ14-2.0 X 25MM SHCS. 6-4 TITANIUM MATERIAL. CROSS DRILLED HEAD
AND DRY FILM LUBRICANT.
- (4). THREAD LENGTH: THE MINIMUM FULL THREAD LENGTH SHALL BE TWICE THE THREAD DIAMETER. PLUS
12MM OR 1/2 THE LENGTH WHICH EVER IS THE GREATER. SCREWS TOO SHORT FOR
THE FORMULA SHALL BE THREADED AS CLOSE TO THE HEAD AS PRACTICABLE. MAXIMUM
THREAD LENGTH NEED NOT EXCEED 40MM.
- (5). LENGTH TOLERANCE. THROUGH 25MM \pm .40. OVER 25MM THROUGH 50MM \pm .75-.40. OVER 50MM \pm .75.
- (6). PARTS SHALL BE FREE FROM BURRS AND SHARP EDGES.
- (7). CHAMFER "U" PLUS INCOMPLETE THREADS SHALL NOT EXCEED TWO PITCHES.
- (8). DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE INDICATED.
- (9). WHEN LOCKED, MIL-F-18240 SHALL BE USED FOR ALL REQUIREMENTS BY USING THE CLOSEST
ENGLISH EQUIVALENT DIAMETER.