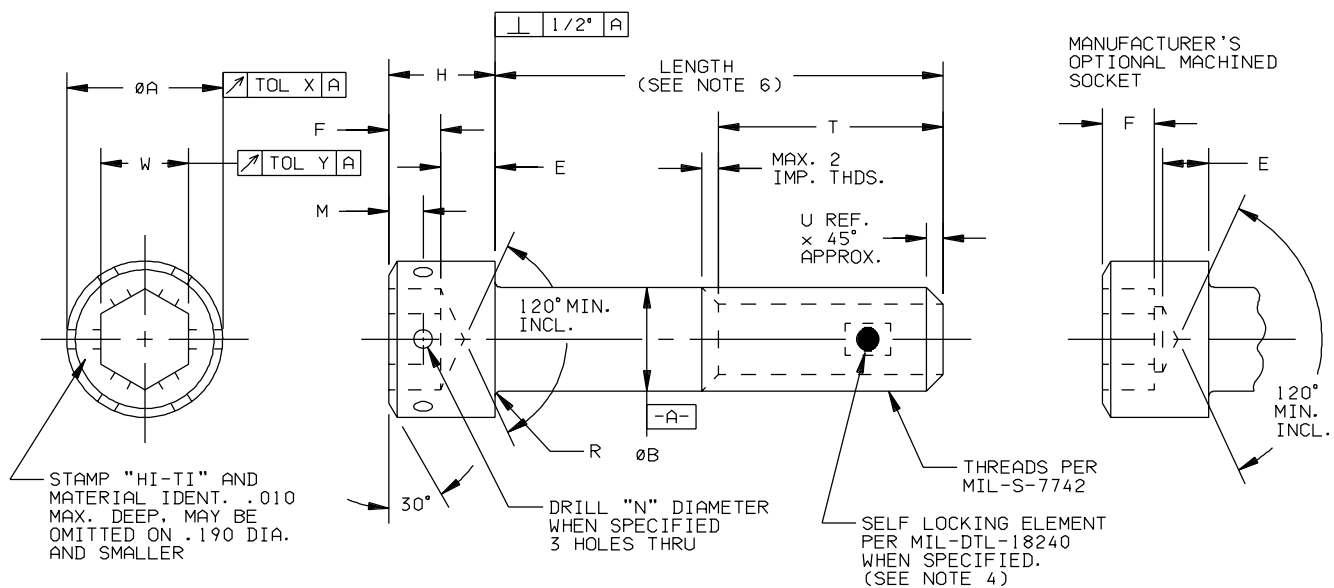




DRAWING NUMBER
SD. 300. 66927
ISSUE DATE
2/01/86
REVISION
(2) 7/19/02 REVISED AND REDRAWN



FIRST DASH NUMBER	THREADS	ØA	ØB	E MAX.	F MIN.	H	M	ØN	R	T MIN. (5)	U REF.	W	X	Y	LENGTH MIN.	
															UNC	UNF
-030	.0600-80 UNF-3A	.096 .093	.0600 .0583	.043	.030	.060 .057	-	-	.007 .003	.500	.02	.0520 .0500	.006	.005		.062
-164	.0730-64 UNC-3A	.118	.0730	.053	.039	.073	-	-	.007	.625	.02	.0520	.006	.005	.062	.062
-172	.0730-72 UNF-3A	.114	.0711			.070			.003		.02	.0500				
-256	.0860-56 UNC-3A	.140	.0860			.086			.008		.02	.0645	.006	.005	.078	.062
-264	.0860-64 UNF-3A	.136	.0840	.060	.044	.083	-	-	.004	.625	.02	.0625	.006	.005	.078	.062
-348	.0990-48 UNC-3A	.161	.0990			.099			.008	.625	.03	.0801	.006	.005	.093	.078
-356	.0990-56 UNF-3A	.157	.0968	.069	.052	.096	-	-	.004	.625	.02	.0781	.006	.005	.093	.078
-440	.1120-40 UNC-3A	.183	.1120			.112	.044	.042	.010		.03	.0801	.006	.005	.109	.093
-448	.1120-48 UNF-3A	.178	.1096	.080	.061	.109	.024	.034	.005	.750	.03	.0781	.006	.005	.109	.093
-540	.1250-40 UNC-3A	.205	.1250			.125	.049	.042	.010		.03	.0957	.006	.005	.109	.093
-544	.1250-44 UNF-3A	.200	.1226	.090	.068	.122	.029	.034	.005	.750	.03	.0937	.006	.005	.109	.093
-632	.1380-32 UNC-3A	.226	.1380			.138	.054	.042	.010		.04	.0957	.006	.005	.125	.109
-640	.1380-40 UNF-3A	.221	.1353	.096	.071	.134	.034	.034	.005	.750	.03	.0937	.006	.005	.125	.109
-832	.1640-32 UNC-3A	.270	.1640			.164	.059	.042	.015		.04	.1280	.006	.005	.125	.125
-836	.1640-36 UNF-3A	.265	.1613	.113	.088	.160	.039	.034	.008	.875	.03	.1250	.006	.005	.125	.125
-1024	.1900-24 UNC-3A	.313	.1900			.190	.066	.042	.015		.05	.1592	.006	.006	.187	.125
-1032	.1900-32 UNF-3A	.306	.1867	.132	.109	.185	.046	.034	.008	.875	.04	.1562	.006	.006	.187	.125
-420	.2500-20 UNC-3A	.375	.2500			.250	.085	.068	.020	1.000	.06	.1905	.006	.008	.281	.156
-428	.2500-28 UNF-3A	.367	.2464	.164	.126	.244	.065	.060	.010		.04	.1875	.006	.008	.281	.156
-518	.3125-18 UNC-3A	.438	.3125			.313	.104	.068	.020		.07	.2217	.006	.009	.250	.187
-524	.3125-24 UNF-3A	.429	.3084	.206	.163	.306	.084	.060	.010	1.125	.05	.2187	.006	.009	.250	.187
-616	.3750-16 UNC-3A	.563	.3750			.375	.123	.068	.020		.08	.3155	.008	.011	.250	.187
-624	.3750-24 UNF-3A	.552	.3705	.248	.186	.368	.103	.060	.010	1.250	.05	.3125	.008	.011	.250	.187
-714	.4375-14 UNC-3A	.625	.4375			.438	.141	.068	.025		.09	.3155	.009	.013	.312	.218
-720	.4375-20 UNF-3A	.615	.4326	.290	.213	.430	.121	.060	.015	1.375	.06	.3125	.009	.013	.312	.218
-813	.5000-13 UNC-3A	.750	.5000			.500	.160	.068	.030		.10	.3780	.010	.015	.500	.500
-820	.5000-20 UNF-3A	.739	.4948	.332	.245	.492	.140	.060	.020	1.500	.06	.3750	.010	.015	.500	.500

INFORMATION ON THIS DOCUMENT IS A TRADE SECRET, PROPRIETARY, AND SHALL NOT BE USED OR REPRODUCED IN WHOLE OR IN PART WITHOUT WRITTEN AUTHORIZATION OF SPS TECHNOLOGIES.

TOLERANCES ±.010 AND ±2°
SURFACE ROUGHNESS 125
UNLESS OTHERWISE NOTED
DRAWN BY: KATHY SCHWARTZ
APPROVED: S FOSTER
APPROVED: R HUKARI

THIS
PRODUCT DRAWING
IS DRAFTED
IN ACCORDANCE
WITH ASME Y14.5M
DATE: 7/19/02
DATE: 7/25/02



TITLE

SCREW, SOCKET HEAD CAP
TITANIUM ALLOY

FSCM NO. 56878
CUSTODIAN:
JENKINTOWN, PA.

STANDARDS AND SPECIFICATIONS
NAS621 EXCEPT
NOTE 2 ON SHEET 2

PART NUMBER: 66927() () () () ()
SHEET 1 OF 2



DRAWING NUMBER SD. 300. 66927	ISSUE DATE 11/17/82	REVISION (2) 7/19/02 REVISED AND REDRAWN
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1. MATERIAL: 6AL-4V TITANIUM PER AMS 4928.
COMMERCIALLY PURE TITANIUM.
2. TENSILE STRENGTH PER NAS 621 EXCEPT SIZES .164 DIAMETER AND SMALLER. THE TENSILE REQUIREMENTS FOR THESE DIAMETERS SHALL BE 150,000 PSI MINIMUM, EXCEPT FOR THOSE PARTS FABRICATED OF COMMERCIALLY PURE MATERIAL. THE TENSILE STRENGTH OF ALL PARTS OF COMMERCIALLY PURE MATERIAL WILL VARY WITH THE MATERIAL SPECIFIED.
3. FINISH: DRY FILM LUBRICANT WHEN SPECIFIED BY PART NUMBER. SEE NOTE 4.
4. PART NUMBER: 66927() () () () () () ()

M = DRY FILM LUBRICANT
NO LETTER = NO LUBRICANT

K = TYPE N (PELLET TYPE) SELF LOCKING ELEMENT
N = TYPE P (PATCH TYPE) SELF LOCKING ELEMENT

LENGTH IN SIXTEENTHS

"- " = NO CROSSDRILLED HOLES IN HEAD
H = CROSSDRILLED HOLES IN HEAD

DASH NUMBER PER TABULATION

V = 6AL-4V TITANIUM
"- " = COMMERCIALLY PURE TITANIUM

BASIC PART NUMBER
5. THREAD LENGTH: THE MINIMUM FULL THREAD LENGTH SHALL BE TWICE THE THREAD DIAMETER, PLUS 1/2 INCH 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 PRACTICAL. MAXIMUM THREAD LENGTH NEED NOT EXCEED 1.50 INCH FOR PARTS UNDER .500 DIAMETER.
6. LENGTH TOLERANCE: THROUGH ONE INCH $\pm .015$; OVER ONE INCH THROUGH TWO INCHES $+.031-.015$; OVER TWO INCHES $\pm .031$.
7. PARTS SHALL BE FREE FROM BURRS AND SHARP EDGES.
8. CHAMFER "U" PLUS INCOMPLETE THREADS SHALL NOT EXCEED TWO PITCHES.
9. DIMENSIONS ARE IN INCHES.

TOLERANCES $\pm .010$ AND $\pm 2^\circ$
SURFACE ROUGHNESS 125
UNLESS OTHERWISE NOTED

THIS
PRODUCT DRAWING
IS DRAFTED
IN ACCORDANCE
WITH ASME Y14.5M



PART NUMBER: 66927() () () () () () ()

SHEET 2 OF 2