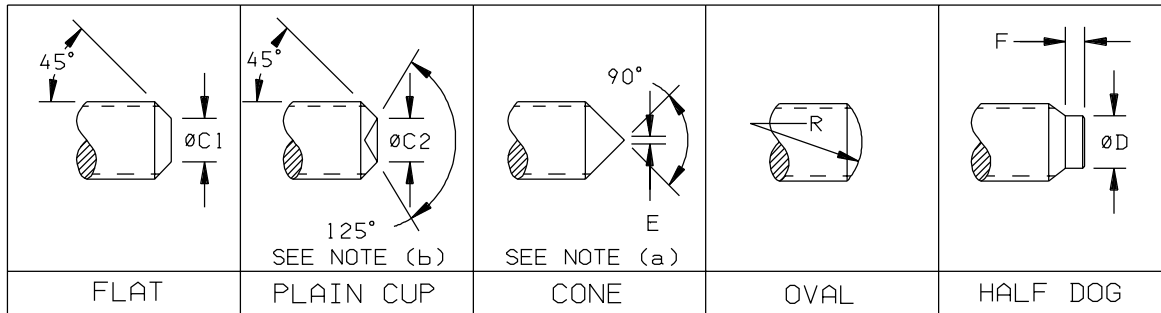
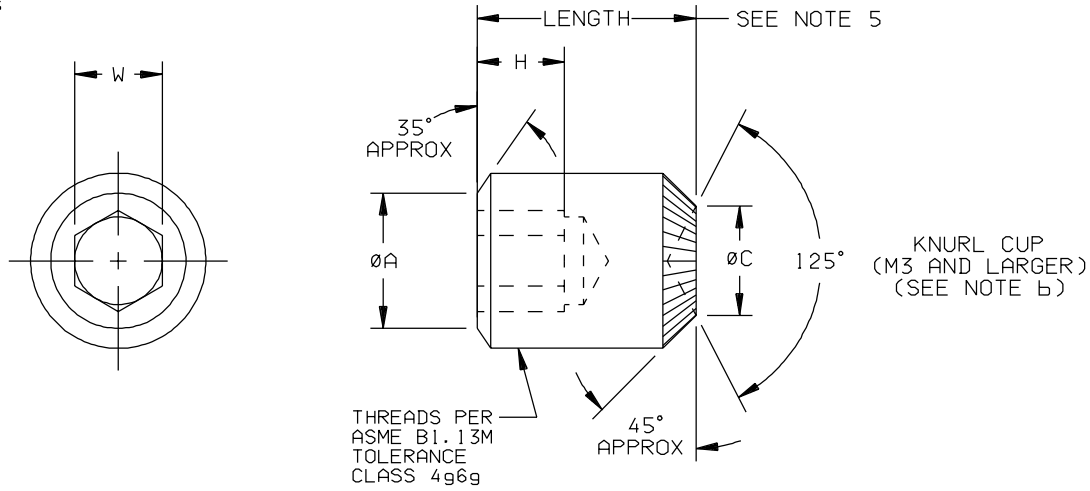




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(a) WHEN LENGTH EQUALS NOMINAL DIAMETER OR LESS, INCLUDED ANGLE IS 118°.
 (b) WHEN LENGTH EQUALS NOMINAL DIAMETER OR LESS, INCLUDED ANGLE IS 135°.

TABLE I

NOM DIA	THREADS	ØA MAX	ØC		ØC1		ØC2		D		E		F		H MIN **	R		W NOM
			MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN	
M1.6	MJ1.6X0.35	1.00	0.80	0.55	0.80	0.55	0.80	0.64	0.80	0.55	0.16	0	0.53	0.40	0.6	1.60	1.20	0.7
M2	MJ2X0.4	1.32	1.00	0.75	1.00	0.75	1.00	0.82	1.00	0.75	0.20	0	0.64	0.50	0.6	1.90	1.50	0.9
M2.5	MJ2.5X0.45	1.75	1.20	0.95	1.50	1.25	1.25	1.05	1.50	1.25	0.25	0	0.78	0.63	0.7	2.28	1.88	1.3
M3	MJ3X0.5	2.10	1.40	1.15	2.00	1.75	1.50	1.28	2.00	1.75	0.30	0	0.92	0.75	0.6	2.65	2.25	1.5
M4	MJ4X0.7	2.75	2.00	1.75	2.50	2.25	2.00	1.75	2.50	2.25	0.40	0	1.20	1.00	1.0	3.80	3.00	2.0
M5	MJ5X0.8	3.70	2.50	2.25	3.50	3.20	2.50	2.22	3.50	3.20	0.50	0	1.37	1.25	1.2	4.55	3.75	2.5
M6	MJ6X1.0	4.35	3.00	2.75	4.00	3.70	3.00	2.69	4.00	3.70	1.50	1.2	1.74	1.50	1.8	5.30	4.50	3.0
M8	MJ8X1.25	6.00	5.00	4.70	5.50	5.20	4.00	3.65	5.50	5.20	2.00	1.6	2.28	2.00	1.8	6.80	6.00	4.0
M10	MJ10X1.5	7.40	6.00	5.70	7.00	6.64	5.00	4.60	7.00	6.64	2.50	2.0	2.82	2.50	2.0	8.30	7.50	5.0
M12	MJ12X1.75	8.60	8.00	7.64	8.50	8.14	6.00	5.57	8.50	8.14	3.00	2.4	3.35	3.00	3.0	9.80	9.00	6.0
M16	MJ16X2.0	12.35	10.00	9.64	12.00	11.57	8.00	7.50	12.00	11.57	4.00	3.2	4.40	4.00	3.0	12.80	12.00	8.0
M20	MJ20X2.5	16.00	14.00	13.57	15.00	14.57	10.00	9.44	15.00	14.57	5.00	4.0	5.45	5.00	6.0	15.80	15.00	10.0
M24	MJ24X3.0	18.95	16.00	15.57	18.00	17.57	12.00	11.39	18.00	17.57	6.00	4.8	6.49	6.00	5.0	18.80	18.00	12.0

** VALUES SHOWN IN COLUMN H ARE FOR MINIMUM STOCK LENGTH FLAT & CUP POINT SCREWS

TABLE II

LENGTH TOLERANCE, mm	
LENGTHS EQUAL TO OR SHORTER THAN THE NOMINAL SCREW DIAMETER	+0.25mm -0.00mm
LENGTHS OVER THE NOMINAL SCREW DIAMETER THRU 50mm	±0.25
OVER 50mm THRU 80mm	±0.5
OVER 80mm THRU 120mm	±0.7
OVER 120mm	±0.8

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TOLERANCES ±0.25 AND ±2° SURFACE ROUGHNESS 3.2 UNLESS OTHERWISE NOTED DRAWN BY: KATHY SCHWARTZ APPROVED: S FOSTER APPROVED: L KLINE	THIS PRODUCT DRAWING IS DRAFTED IN ACCORDANCE WITH ASME Y14.5M DATE: 5/10/02	TITLE SET SCREW, HEXAGON RECESS VARIOUS POINT STYLES ALLOY STEEL	FSCM NO. 56878 CUSTODIAN: JENKINTOWN, PA.	STANDARDS AND SPECIFICATIONS SEE NOTE 1
	DATE: 8/02/02		PART NUMBER: SEE TABLE III & NOTE 5 SHEET 1 OF 2	ER-020



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TABLE III

BASIC PART NUMBER	POINT TYPE	GENERAL APPLICATIONS
95851F	FLAT	USE WHERE PARTS MUST BE FREQUENTLY RE-SET; HARDENED SHAFTS, ADJUSTING SCREW.
95851P	PLAIN CUP	USE WHERE HIGH TIGHTENING TORQUES ARE IMPRACTICAL; ZINC, DIE CASTINGS.
95851C	CONE	USE WHERE PERMANENT LOCATION IS NECESSARY; PIVOTS, FINE ADJUSTMENTS.
95851K	KNURL CUP	USE FOR QUICK AND PERMANENT LOCATION; GEARS, COLLARS. RESISTS SCREW LOOSENING.
95851V	OVAL	USE FOR FREQUENT ADJUSTMENT WITHOUT DEFORMATION AND AGAINST ANGULAR SURFACES.
95851H	HALF DOG	USE WHERE PERMANENT LOCATION IS NECESSARY; HOLLOW TUBE, REPLACES DOWEL PIN.

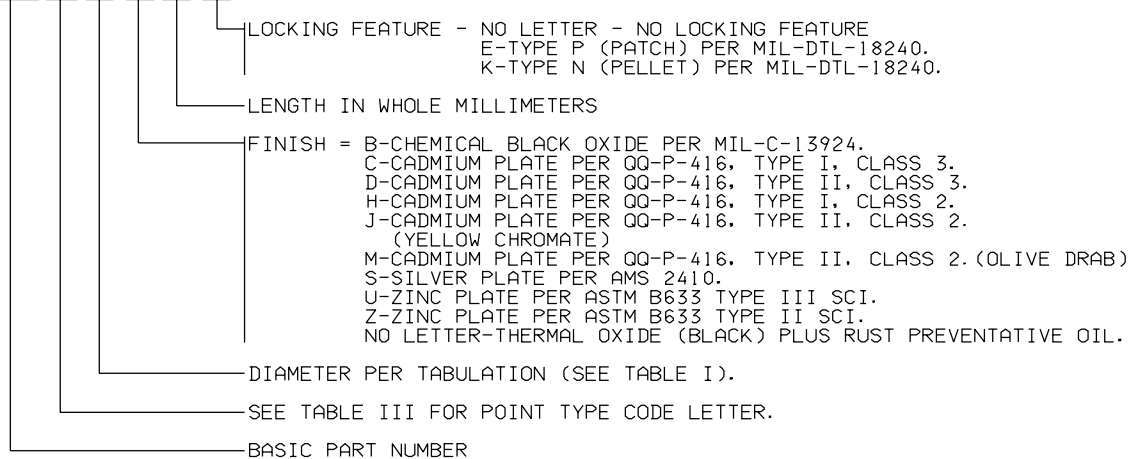
TABLE IV

SIZE	RECOMMENDED SEATING TORQUE	
	IN. -LBS.	Nm
M1.6	0.8	0.09
M2	1.8	0.21
M2.5	5.0	0.57
M3	8.0	0.92
M4	19.0	2.20
M5	35.0	4.00
M6	64.0	7.20
M8	150.0	17.00
M10	290.0	33.00
M12	480.0	54.00
M16	1190.0	134.00
M20	2100.0	237.00
M24	3860.0	440.00

THE RECOMMENDED SEATING TORQUES LISTED SERVE AS GUIDELINES ONLY. EVEN WHEN USING THE RECOMMENDED SEATING TORQUES, THE INDUCED LOADS OBTAINED MAY VARY AS MUCH AS ±25% DEPENDING UPON THE UNCONTROLLED VARIABLES SUCH AS MATING MATERIAL, PLATING, LUBRICATION, SURFACE FINISH, HARDNESS, BOLT/JOINT COMPLIANCE, METHOD OF TIGHTENING, ETC.

HOWEVER, THE BEST WAY TO DETERMINE THE CORRECT TORQUE IS TO RUN TESTS ON THE PARTICULAR JOINT BY TIGHTENING SAMPLE BOLTS UNTIL THEY JUST BEGIN TO YIELD. THE OPTIMUM TORQUE IS 80% OF THIS VALUE.

1. MATERIAL: ALLOY STEEL PER THE CHEMISTRY OF ASTM F912M.
2. HEAT TREAT: 45-53 HRC. FOR PARTS WITH NYLON PLUG - 28 HRC MINIMUM.
3. FINISH: SEE NOTE 5.
4. DIMENSIONS AND TOLERANCING PER ASME B18.3.6M- INCLUDING MANUFACTURING NOTES NOT LISTED IN THIS DRAWING.
5. PART NUMBERING: 95851 () () () () ()



TOLERANCES ±.010 AND ±2°
SURFACE ROUGHNESS 125/
UNLESS OTHERWISE NOTED



PART NUMBER: SEE TABLE III & NOTE 5
SHEET 2 OF 2