



PROPRIETARY ITEM - EXCEPT FOR USES EXPRESSLY GRANTED IN WRITING INFORMATION DISCLOSED HEREON IS CONFIDENTIAL AND ALL RIGHTS PATENT AND OTHERWISE ARE RESERVED BY SOUTHCO, INC.

SOUTHCO NO. 52 CAPTIVE FASTENER ASSY,
M4 THREAD, PRESS-IN STYLE

DATE	DRAWN	CHKD	SCALE
14OCT2002	RJB	TVA	2:1

DRAWING NUMBER
J-52-4-1

REV	DATE	DRAWN/CHKD	DESCRIPTION	PART NUMBER	PANEL THICKNESS		SCREW PROJECTION		T
					MIN	MAX	P-1	P-2	
A	07NOV2002	AJH/CHW	PRN: P2002-0864						
B	27JAN2003	DLH/VNI	PRN: P2003-0077	52-4X-51-4			0.9	6.1	17
C	11NOV2003	LTS/MJS	PRN: P2003-1024	52-4X-53-4	0.9	---	2.5	7.6	18.6

MILLIMETERS

ALL DIMENSIONS WITHOUT TOLERANCES ARE FOR REFERENCE ONLY.

THIRD ANGLE PROJECTION

A3 PAPER SIZE

NOTES:

A - MATERIAL AND FINISH

SCREW: STEEL, HARDENED, ZINC PLATE, CHROMATE PLUS SEALER
 SPRING: 302 STAINLESS STEEL, PASSIVATED
 STANDOFF: STEEL, ZINC PLATE, CHROMATE PLUS SEALER

B - INSTALLATION INSTRUCTIONS:

1. PREPARE HOLE IN PANEL AS SHOWN. OUTSIDE EDGE MUST BE SHARP; DO NOT CHAMFER.
2. PUNCH SURFACE AND BACK-UP TOOL SURFACE MUST REMAIN PARALLEL DURING INSTALLATION. A HARDENED STEEL BACK-UP TOOL WITH A CLEARANCE HOLE AS SHOWN, IS RECOMMENDED.
3. PRESS THE ASSEMBLY INTO THE PANEL UNTIL ONLY THE TOP OF THE KNURL ON THE STANDOFF IS VISIBLE. RECOMMENDED LOAD OF 10,000N FOR STEEL, $R_a < 60$ MAX. RECOMMENDED LOAD OF 5,500N FOR 5052-H32 ALUMINUM.

C - TORX® IS A REGISTERED TRADEMARK OF THE CAMCAR DIVISION OF TEXTRON INC.

D - RECOMMENDED MAXIMUM TORQUE OF 220 N-cm.

E - COSMETIC APPEARANCE PER SOUTHCO CAPTIVE SCREW SPECIFICATION S-115.

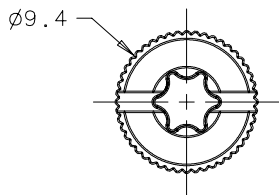
"X" SCREW RECESS

- 7 - TORX®/SLOT, KNURLED
- 9 - PHILLIPS/SLOT, KNURLED
- 8 - TORX®/SLOT, SMOOTH
- A - PHILLIPS/SLOT, SMOOTH

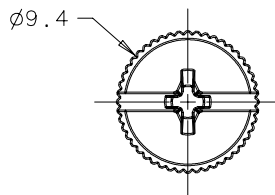
"Y" FINISH

- 4 - BRIGHT

KNURLED

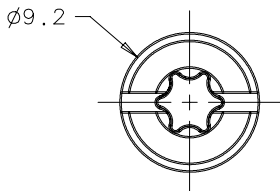


T25 TORX®/SLOT RECESS

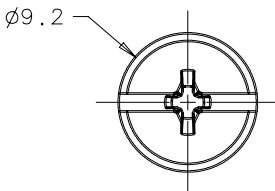


No. 2 PHILLIPS/SLOT RECESS

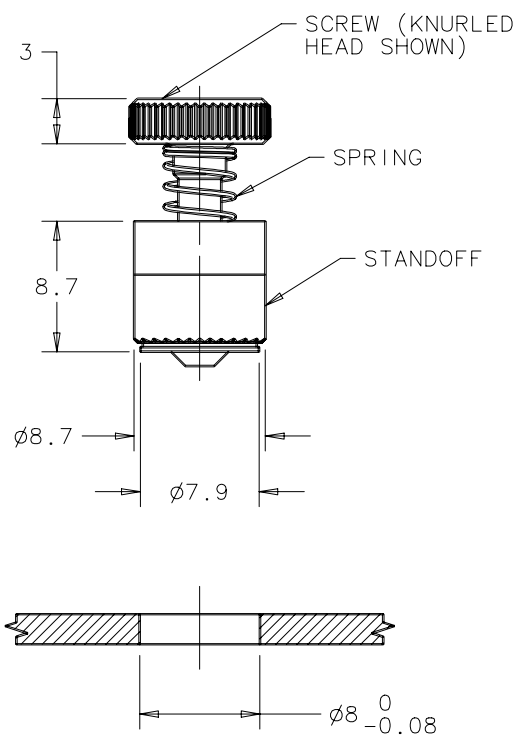
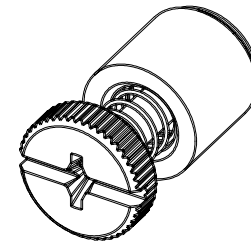
SMOOTH



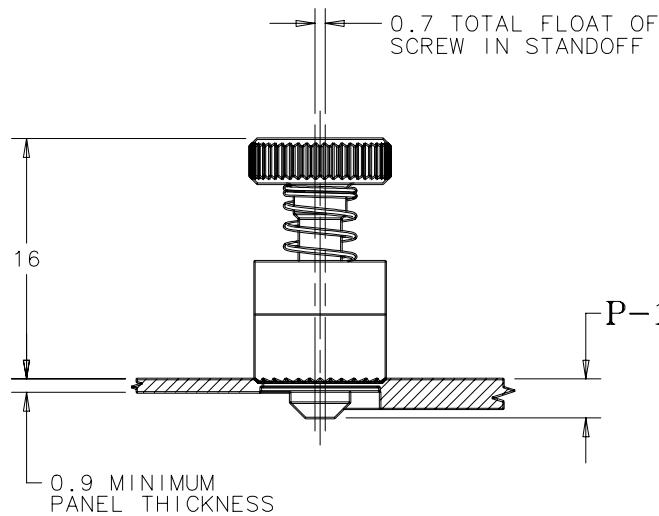
T25 TORX®/SLOT RECESS



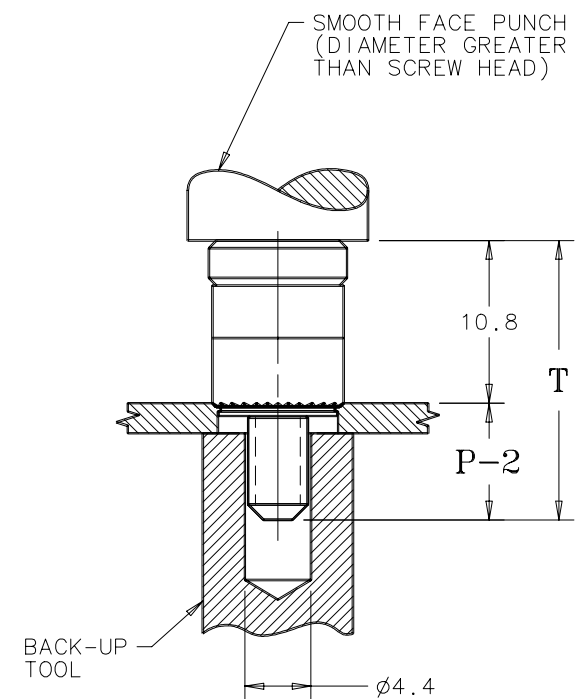
No. 2 PHILLIPS/SLOT RECESS



PANEL PREPARATION



UNFASTENED



FASTENED

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J-52-4-1