

**southco**

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.

**F5 FLUSH CAPTIVE SCREW ASSEMBLIES  
INSTALLED IN 1008-1010 STEEL**

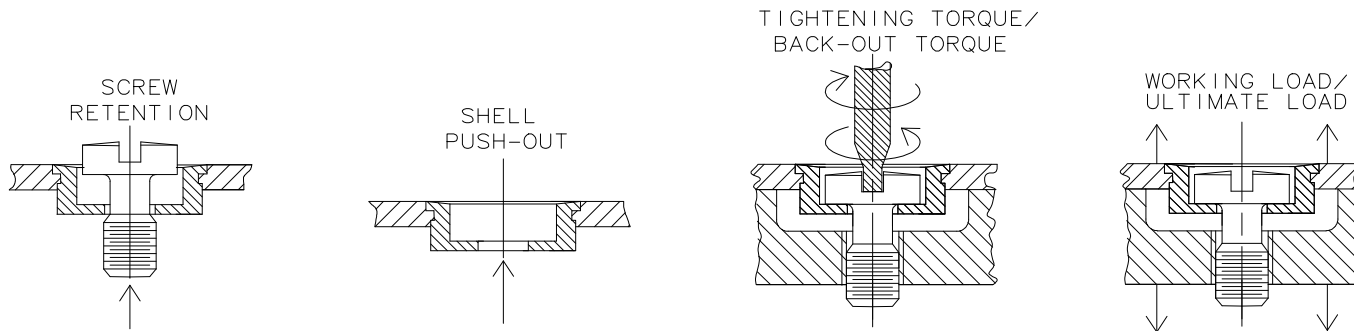
DATE	DRAWN	CHKD	SCALE	DRAWING NUMBER
3/89	SML	ACZ	NTS	TD-F5-01-J

REV	DATE	DRAWN/CHKD	DESCRIPTION
B	09APR2002	GDM	UPDATE FORMAT
C	18DEC2002	GDM	SEE RECORD PRINT

THIRD ANGLE PROJECTION

A PAPER SIZE

SOUTHCO PERFORMANCE GUIDELINES  
THE PERFORMANCE GUIDELINES SHOWN ON THIS PAGE ARE SUPPLIED AS A GENERAL GUIDE ONLY, AS CONDITIONS VARY WITH EACH APPLICATION AND METHOD OF INSTALLATION. STRENGTH DATA GIVEN IS FOR FAILURE OF THE PRODUCT OR FOR SUFFICIENT DEFORMATION TO MAKE PRODUCT INOPERABLE. NO SAFETY FACTOR HAS BEEN APPLIED. IT IS RECOMMENDED THAT THE USER REQUEST A PRODUCT SAMPLE FOR TESTING TO DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURPOSE INTENDED AND USER'S PARTICULAR APPLICATION.



THREAD SIZE	PART NUMBER	AVG. INSTALLATION FORCE (in Steel)	AVG. SCREW RETENTION	AVG. SHELL PUSH-OUT	RECOMMENDED MAX. TIGHTENING TORQUE (A)	AVG. BACK-OUT TORQUE (B)	WORKING LOAD (C)	AVG. ULTIMATE LOAD (D)
No. 4-40/ M3x0.5	F5-60-4XX-20 F5-90-4XX-20	10,430 N/ 2350 LBS. ①	716 N/ 160 LBS.	2000 N/ 450 LBS.	0.6 Nm/ 5 IN-LBS.	0.6 Nm/ 5 IN-LBS. ④	890 N/ 200 LBS.	2040 N/ 460 LBS.
No. 6-32	F5-60-6XX-20	11,160 N/ 2510 LBS. ②	1420 N/ 320 LBS.	2120 N/ 480 LBS.	1.6 Nm/ 14 IN-LBS.	1.7 Nm/ 15 IN-LBS.	1330 N/ 300 LBS.	2620 N/ 590 LBS.
No. 8-32/ M4x0.7	F5-832-1X F5-M40-9X	13,790 N/ 3100 LBS. ③	1420 N/ 320 LBS.	3790 N/ 850 LBS.	2.8 Nm/ 25 IN-LBS.	1.7 Nm/ 15 IN-LBS.	1780 N/ 400 LBS.	3370 N/ 760 LBS.

- (A) RECOMMENDED MAX. TIGHTENING TORQUE is the amount of torque required before the screw slot begins to deform.
  - (B) BACK-OUT TORQUE is amount of torque required to fully unthread the screw from the shell. The outer panel is held in contact with the frame during this test, so that the screw develops an axial force to back out through the shell.
  - (C) WORKING LOAD is the maximum recommended load at which the product continues to function acceptably.
  - (D) ULTIMATE LOAD is the load at which the product fails. Failure is the screw head shearing off of the screw.
- ① Installed in .069 in. thick sheet; hardness Rb 55      ③ Installed in .097 in. thick sheet; hardness Rb 60  
 ② Installed in .095 in. thick sheet; hardness Rb 58      ④ Screwdriver cammed out of slot before screw fully unthreaded from shell.

REF. F5-06, F5-07