

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.

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

DATE	DRAWN	CHKD	SCALE
14OCT2002	RJB	TVA	2:1

DRAWING NUMBER
J-52-4-2

REV	DATE	DRAWN/CHKD	DESCRIPTION	PART NUMBER	PANEL THICKNESS		"L"	"Y"	SCREW PROJECTION		"T"
					"A" MIN	"A" MIN			"P-1"	"P-2"	
A	07NOV2002	AJH/CHW	PRN: P2002-0864								
B	27JAN2003	DLH/VNI	PRN: P2003-0077	52-4X-21-4	1.5	3.2	1.8	0.4	1.8	6.8	17
C	11NOV2003	LTS/MJS	PRN: P2003-1024								

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 PLUS SEALER
 SPRING: 302 STAINLESS STEEL, PASSIVATED
 STANDOFF: 6000 SERIES ALUMINUM, NATURAL

B - INSTALLATION INSTRUCTIONS:

1. PREPARE THE HOLE IN THE PANEL, COUNTERSINK UNDERSIDE OF THE PANEL AS SHOWN.
2. PUNCH SURFACE AND INSTALLATION TOOL MUST REMAIN PARALLEL DURING FLARING OF STANDOFF. ONLY USE LIGHT PRESSURE TO FLARE STANDOFF. RECOMMENDED LOAD OF 3,000N.
3. USE SOUTHCO INSTALLATION TOOL, PART NUMBER 47-108, TO FLARE THIS ASSEMBLY.

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.

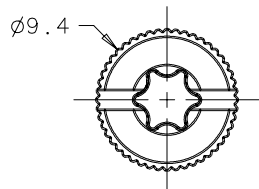
"X" SCREW RECESS

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

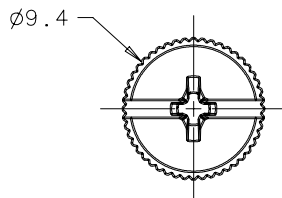
"Y" FINISH

- 4 - BRIGHT

KNURLED

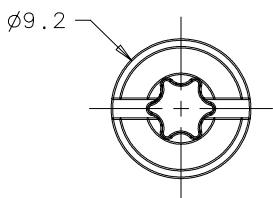


T25 TORX®/SLOT RECESS

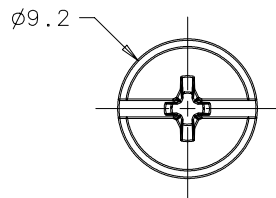


No. 2 PHILLIPS/SLOT RECESS

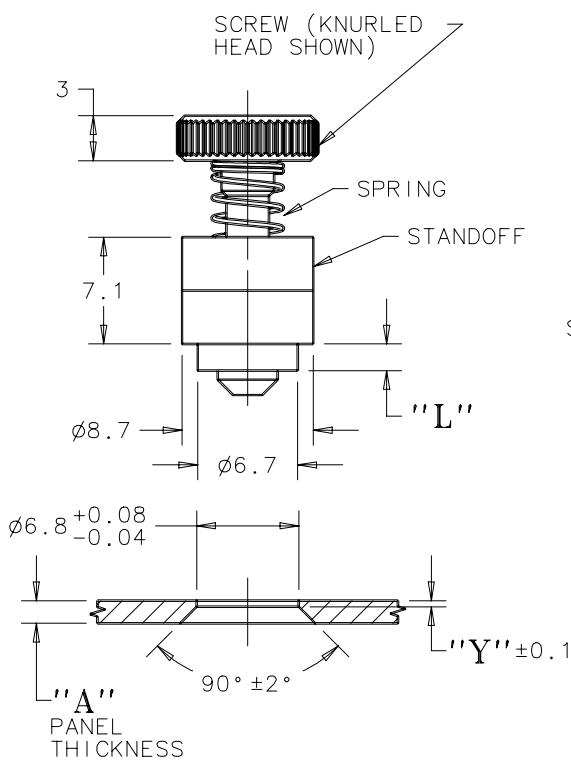
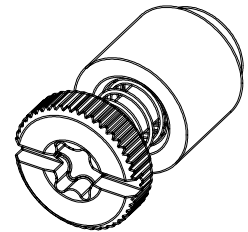
SMOOTH



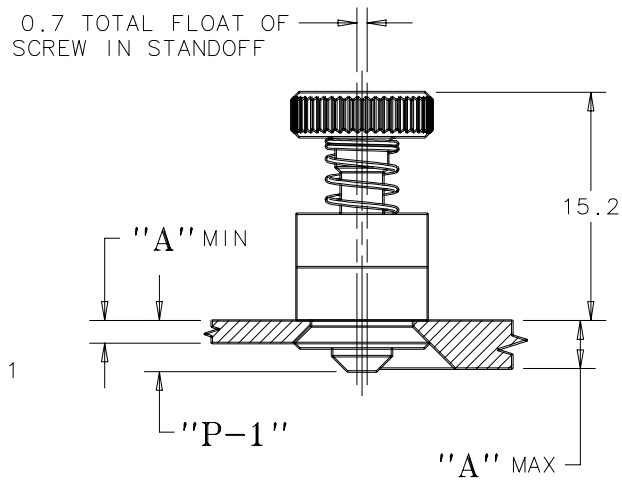
T25 TORX®/SLOT RECESS



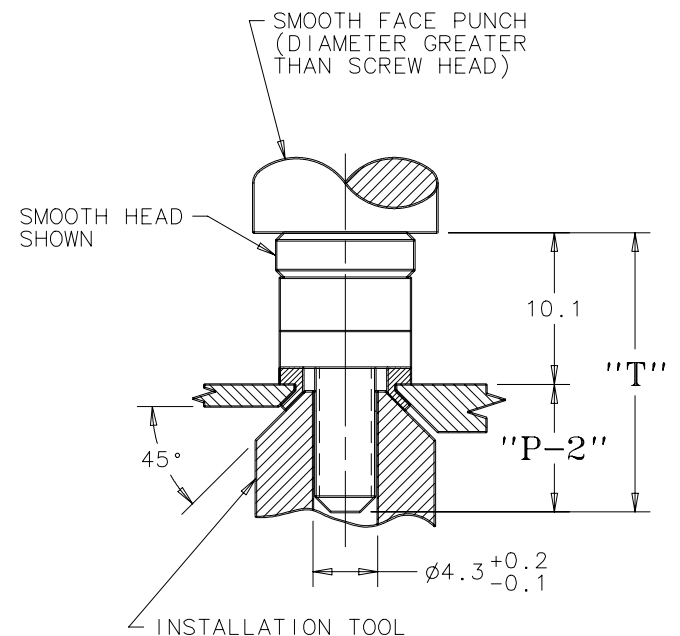
No. 2 PHILLIPS/SLOT RECESS



PANEL PREPARATION



UNFASTENED



FASTENED

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