

Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi-Shan

MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE  
WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITED

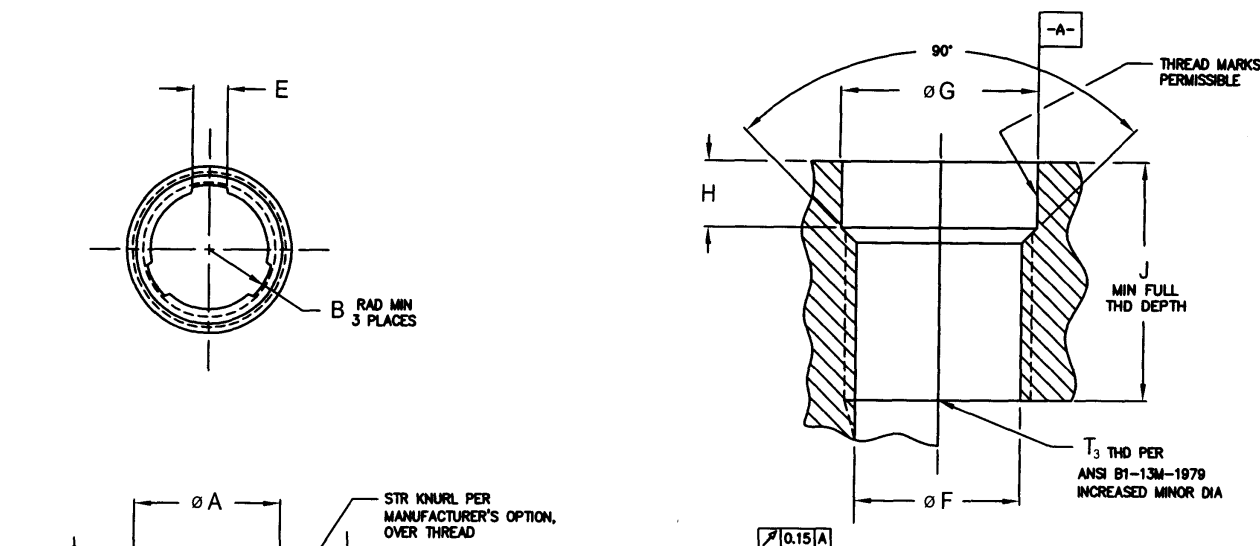


FIG 1  
HOLE PREPARATION

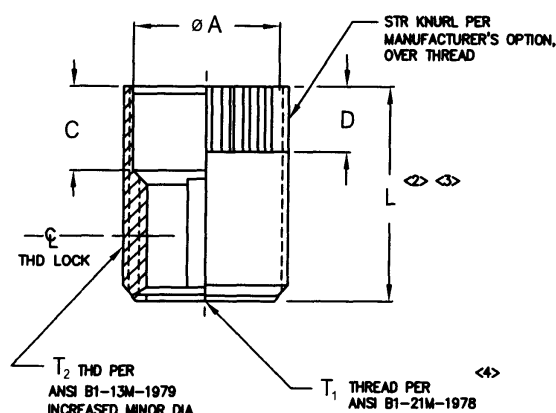


FIG 2  
SLIMERT INSERT  
WRENCHED IN

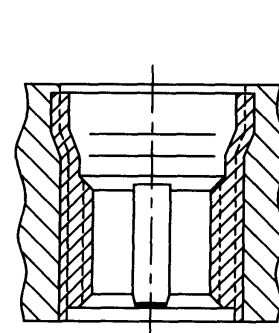


FIG 3  
SLIMERT INSERT  
INSTALLED

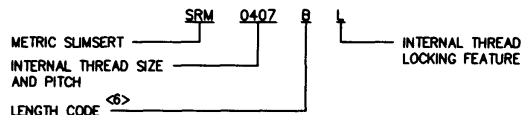
NOTES: UNLESS OTHERWISE SPECIFIED.

1. MATERIAL: 17-4PH CRES PER AMS 5643
2. HEAT TREAT: CONDITION H1025 1100 MPa MIN UTS
3. FINISH: SOLID FILM LUBRICANT

<4> TOLERANCE CLASS:

-4H6H FOR  $\leq$  MJ5x0.8, 4H5H FOR  $>$  MJ5x0.8

<5> PART NUMBER EXAMPLE:



<6> DIRECTION FOR "L" LENGTH DETERMINATION (SEE TABLES I & II).

7. DIMENSIONS APPLY BEFORE ADDITION OF SOLID FILM LUBE.

<8> WEIGHTS APPROXIMATIVE, CALCULATED WITH A DENSITY OF 7.93 Kg/dm<sup>3</sup>.

| INTERIM DOCUMENT REVISION |           |        |
|---------------------------|-----------|--------|
| Rev.                      | Date      | DAF#   |
| D1                        | 10/8/2018 | 117431 |

#### INSTALLATION PROCEDURE

- a. THE SLIMERT IS WRENCHED INTO THE PARENT MATERIAL TO DEPTH SHOWN IN FIG 2 WITH WRENCH PER TABLE II.
- b. SWAGE THE COLLAR OF THE INSERT OUT UNTIL IT PRESSES INTO THE WALL OF THE COUNTERBORE "G" DIA (SEE FIGURE 3), USING SWAGE TOOL PER TABLE II.
- c. THE SLIMERT IS INSTALLED WHEN THE SHOULDER OF THE SWAGE TOOL BOTTOMS ON THE SURFACE OF THE PARENT MATERIAL.
- d. FOR INSTALLATION INTO HARD MATERIALS CONTACT ALCOA ENGINEERING DEPARTMENT.

ORIGINAL DESIGN ACTIVITY: CAGE CODE 83324

APPROVED DATE

8-9-67

REV. LETTER AND DATE

D 12/30/84

DAF NUMBER

66300

CURRENT DESIGN ACTIVITY:



ARCONIC

Arconic Fastening Systems

ROSAN PRODUCTS  
3018 W. LOMITA BLVD.  
TORRANCE, CA 90505

TITLE:

SLIMERT INSERT - METRIC  
INTERNAL THREAD LOCK  
FOR TEMPERATURES UP TO 235°C

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES &  
ASME Y14.5M TOLERANCES:

ANGLES =  $\pm 3^\circ$   
DECIMALS .XX =  $\pm 0.02$   
.XXX =  $\pm 0.010$

CURRENT DESIGN ACTIVITY:

CAGE CODE: 83324

SALES DRAWING NO.

SRM()()L SERIES  
INSP - INSTL

SHEET 1 OF 2

THIS DRAWING EMBODIES A CONFIDENTIAL, PROPRIETARY DESIGN & ALL DESIGN, MANUFACTURING  
PRODUCTION, USE & SALE RIGHTS REGARDING SAME ARE EXPRESSLY RESERVED.

Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi-Shan

TABLE I

| MINIMUM TENSILE<br>STRENGTH OF<br>SCREW CONNECTION | SHEAR STRENGTH<br>OF PARENT MATERIAL |         |
|----------------------------------------------------|--------------------------------------|---------|
|                                                    | A                                    | B       |
| 900 MPa                                            | 220 MPa                              | 170 MPa |
| 1100 MPa                                           | 260 MPa                              | 200 MPa |

TABLE II

| BASIC<br>PART<br>NUMBER | SLIMSERT DIMENSIONS                     |                                  |          |                     |                |              |              |                     |                     |                       |                     |
|-------------------------|-----------------------------------------|----------------------------------|----------|---------------------|----------------|--------------|--------------|---------------------|---------------------|-----------------------|---------------------|
|                         | T <sub>1</sub><br>THD<br><br>-4H6H/4H5H | T <sub>2</sub><br>THD<br><br>-4g | A<br>DIA | B<br>RAD<br><br>MIN | C<br><br>±0.20 | D<br><br>REF | E<br><br>MIN | L ±0.3              |                     | WEIGHT<br>Kg/1000 PCS |                     |
|                         |                                         |                                  |          |                     |                |              |              | A<br>LENGTH<br>CODE | B<br>LENGTH<br>CODE | A<br>LENGTH<br>CODE   | B<br>LENGTH<br>CODE |
|                         |                                         |                                  |          |                     |                |              |              |                     |                     |                       |                     |
| SRM0305( )L             | MJ3x0.5                                 | M5x0.8                           | 3.17     | 1.42                | 2.15           | 1.6          | 0.90         | —                   | 5.1                 | —                     | 0.33                |
| SRM0407( )L             | MJ4x0.7                                 | M6x1                             | 4.21     | 1.86                | 2.55           | 1.9          | 1.15         | —                   | 6.9                 | —                     | 0.51                |
| SRM0508( )L             | MJ5x0.8                                 | M7x1                             | 5.23     | 2.28                | 2.95           | 2.3          | 1.25         | 7.6                 | 9.1                 | 0.68                  | 0.83                |
| SRM0610( )L             | MJ6x1                                   | M8x1                             | 6.28     | 2.72                | 3.15           | 2.4          | 1.50         | 8.9                 | 10.7                | 1.05                  | 1.28                |
| SRM0710( )L             | MJ7x1                                   | M9x1                             | 7.29     | 3.22                | 3.55           | 2.7          | 1.75         | 10.9                | 13.3                | 1.51                  | 1.86                |
| SRM0812( )L             | MJ8x1.25                                | M10x1                            | 8.32     | 3.64                | 3.95           | 2.9          | 2.00         | 12.8                | 15.7                | 2.07                  | 2.54                |
| SRM0810( )L             | MJ8x1                                   | M10x1                            | 8.32     | 3.64                | 3.95           | 2.9          | 2.00         | 12.8                | 15.7                | 2.02                  | 2.47                |
| SRM1015( )L             | MJ10x1.5                                | M12x1                            | 10.37    | 4.57                | 4.65           | 3.3          | 2.50         | 16.2                | 19.9                | 3.38                  | 4.28                |
| SRM1012( )L             | MJ10x1.25                               | M12x1                            | 10.37    | 4.57                | 4.65           | 3.3          | 2.50         | 16.2                | 19.9                | 3.30                  | 4.13                |
| SRM1215( )L             | MJ12x1.5                                | M14x1                            | 12.37    | 5.57                | 4.65           | 3.5          | 2.50         | 19.9                | 24.8                | 5.20                  | 6.50                |
| SRM1212( )L             | MJ12x1.25                               | M14x1                            | 12.37    | 5.57                | 4.65           | 3.5          | 2.50         | 19.9                | 24.8                | 5.04                  | 6.25                |
| SRM1415( )L             | MJ14x1.5                                | M16x1                            | 14.37    | 6.57                | 4.65           | 3.6          | 2.50         | 23.1                | 28.8                | 7.06                  | 8.95                |

TABLE II (CONTINUED)

| BASIC<br>PART<br>NUMBER | HOLE PREPARATION DIMENSIONS |                       |             |                |                            |                     | TOOLING                 |                           |                         |
|-------------------------|-----------------------------|-----------------------|-------------|----------------|----------------------------|---------------------|-------------------------|---------------------------|-------------------------|
|                         | T <sub>3</sub><br>THD       | F<br>TAP DRILL<br>DIA | G<br>DIA    | H              | J<br>MIN FULL<br>THD DEPTH |                     | STEP<br>DRILL<br>NUMBER | DRIVE<br>WRENCH<br>NUMBER | SWAGE<br>TOOL<br>NUMBER |
|                         | -4H5H                       |                       |             | +0.25<br>-0.00 | A<br>LENGTH<br>CODE        | B<br>LENGTH<br>CODE |                         |                           |                         |
| SRM0305( )L             | M5x0.8                      | 4.14— 4.24            | 5.00— 5.10  | 1.70           | —                          | 6.1                 | SRM0305D                | SRM0305W                  | SRM0305S                |
| SRM0407( )L             | M6x1                        | 5.01— 5.11            | 6.00— 6.10  | 2.00           | —                          | 7.9                 | SRM0407D                | SRM0407W                  | SRM0407S                |
| SRM0508( )L             | M7x1                        | 6.03— 6.13            | 7.00— 7.10  | 2.40           | 8.6                        | 10.1                | SRM0508D                | SRM0508W                  | SRM0508S                |
| SRM0610( )L             | M8x1                        | 7.07— 7.17            | 8.00— 8.10  | 2.50           | 9.9                        | 11.7                | SRM0610D                | SRM0610W                  | SRM0610S                |
| SRM0710( )L             | M9x1                        | 8.10— 8.20            | 9.00— 9.10  | 2.80           | 11.9                       | 14.3                | SRM0710D                | SRM0710W                  | SRM0710S                |
| SRM0812( )L             | M10x1                       | 9.11— 9.24            | 10.00—10.13 | 3.00           | 13.8                       | 16.7                | SRM0812D                | SRM0812W                  | SRM0812S                |
| SRM0810( )L             | M10x1                       | 9.11— 9.24            | 10.00—10.13 | 3.00           | 13.8                       | 16.7                | SRM0812D                | SRM0812W                  | SRM0812S                |
| SRM1015( )L             | M12x1                       | 11.16—11.29           | 12.00—12.13 | 3.40           | 17.2                       | 20.9                | SRM1015D                | SRM1015W                  | SRM1015S                |
| SRM1012( )L             | M12x1                       | 11.16—11.29           | 12.00—12.13 | 3.40           | 17.2                       | 20.9                | SRM1015D                | SRM1015W                  | SRM1015S                |
| SRM1215( )L             | M14x1                       | 13.17—13.32           | 14.00—14.15 | 3.60           | 20.9                       | 25.8                | SRM1215D                | SRM1215W                  | SRM1215S                |
| SRM1212( )L             | M14x1                       | 13.17—13.32           | 14.00—14.15 | 3.60           | 20.9                       | 25.8                | SRM1215D                | SRM1215W                  | SRM1215S                |
| SRM1415( )L             | M16x1                       | 15.17—15.32           | 16.00—16.15 | 3.70           | 24.1                       | 29.8                | SRM1415D                | SRM1415W                  | SRM1415S                |

## INTERIM DOCUMENT REVISION

| Rev. | Date      | DAF#   |
|------|-----------|--------|
| D1   | 10/8/2018 | 117431 |

FOR NOTES REFER TO SHEET 1

ORIGINAL DESIGN ACTIVITY: CAGE CODE 83324

APPROVED DATE

8-9-67

CURRENT DESIGN ACTIVITY:



ARCONIC

Arconic Fastening Systems

 ROSAN PRODUCTS  
 3018 W. LOMITA BLVD.  
 TORRANCE, CA 90505

TITLE:

 SLIMSERT INSERT - METRIC  
 INTERNAL THREAD LOCK  
 FOR TEMPERATURES UP TO 235°C

 UNLESS OTHERWISE SPECIFIED  
 DIMENSIONS ARE IN INCHES &  
 ASME Y14.5M TOLERANCES:

 ANGLES  
 DECIMALS = ±3°  
 .XX = ±0.02  
 .XXX = ±0.010

CURRENT DESIGN ACTIVITY:

CAGE CODE: 83324

SALES DRAWING NO.

 SRM( ) ( ) L SERIES  
 INSP - INSTL

SHEET 2 OF 2

MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE  
WITHOUT WRITTEN CONSENT IS ABSOLUTELY PROHIBITEDTHIS DRAWING EMBODIES A CONFIDENTIAL PROPRIETARY DESIGN & ALL DESIGN, MANUFACTURING  
PRODUCTION, USE & SALE RIGHTS REGARDING SAME ARE EXPRESSLY RESERVED.