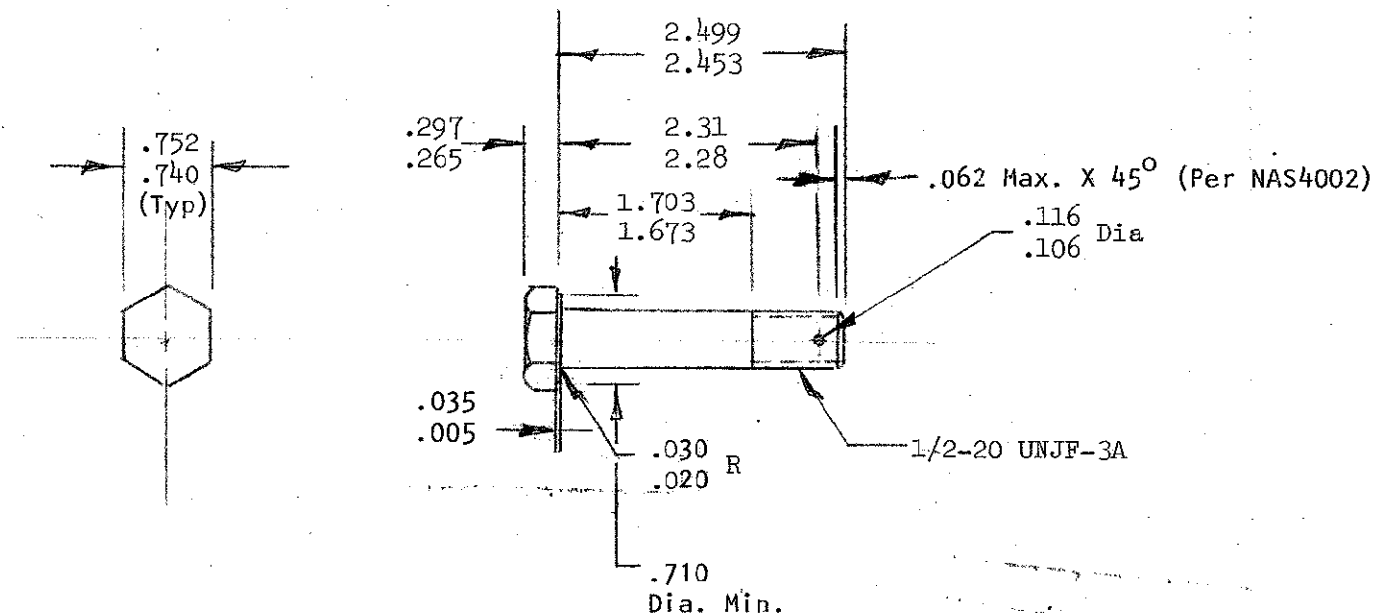


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**THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED**

**REPORT ALL DRAWING ERRORS TO  
ENGINEERING**

REVISIONS					
CHANGE	ITEM NO.	DESCRIPTION	DATE	DRAWN	CHECKED
A		Strength was 125-150 ksi, Rockwell Hardness was C26-C32, Lord part no. removed.	11/3/87	AK	AK



MATERIAL: Alloy Steel

HEAT TREAT: 160-180 ksi per MIL-H-6875  
Rockwell Hardness C36-C40.

FINISH: Cad. Plate per QQ-P-416 Type II, Class 2 or Type I Class 3, no-brightener

- NOTE:
1. Bolts are to be 100% magnetic particle inspected to MIL-I-6868 and heads dye marked green. Threads to MIL-S-8879.
  2. Parts shall be baked at a minimum of 375<sup>0</sup>±25<sup>0</sup>F (191<sup>0</sup>±14<sup>0</sup>C) for 23 hours or more, within 4 hours after plating to provide hydrogen embrittlement relief.

HEAD MARKING: Diameter and manufacturer's symbol.

NO NAS OR MS NUMBER TO BE MARKED ON HEAD.

THE PROCUREMENT DEPT. SHALL SPECIFY THE DSC AND THE MANUFACTURER'S PART NUMBER ON THE PURCHASE ORDER.

**SOURCE CONTROL DRAWING**

ONLY THE ITEM(S) LISTED ON THIS DRAWING AND IDENTIFIED BY VENDOR'S NAME(S), ADDRESS(ES) AND PART NUMBER(S) HAVE BEEN APPROVED BY THE DE HAVILLAND AIRCRAFT OF CANADA LTD FOR THE USE IN DHC AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY THE DE HAVILLAND AIRCRAFT OF CANADA LTD.

PART NO.	APPROVED VENDORS				
	LORD	SCREWCORP	SPS		
DSC 277-1	SC2698	123504			

DRAWN	KROMKAMP
CHECKED	P. LAM
APPROVED	R. J. Dumas
STRESS	Stochel
STD., M.&P.	SCHWARTZ
CH. DRAFTN.	

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED DOWNSVIEW ONTARIO				
DRAWING TITLE				
BOLT, DRILLED SHANK, 160 ksi				
CODE IDENT NO.	DWG SIZE	DRAWING NO.	RELEASE	REV.
71867		DSC 277		A
SCALE	WGT. CALC	ACTUAL	SHEET	