

THE INFORMATION, TECHNICAL DATA AND DESIGNS DISCLOSED IN THIS DOCUMENT (THE "INFORMATION") ARE EITHER THE EXCLUSIVE PROPERTY OF BOMBARDIER INC., OR ARE SUBJECT TO PROPRIETARY RIGHTS OF OTHERS. THE INFORMATION IS NOT TO BE USED FOR DESIGN OR MANUFACTURE, OR DISCLOSED TO OTHERS WITHOUT THE EXPRESS PRIOR WRITTEN CONSENT OF BOMBARDIER INC. THE HOLDER OF THIS DOCUMENT, BY ITS RETENTION AND USE, AGREES TO HOLD THE INFORMATION IN CONFIDENCE. THESE RESTRICTIONS DO NOT APPLY TO PERSONS HAVING PROPRIETARY RIGHTS IN THE INFORMATION, TO THE EXTENT OF THOSE RIGHTS.

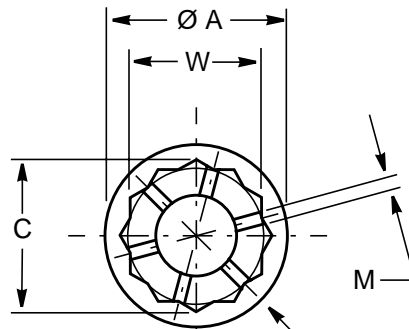
de HAVILLAND

CAGE CODE 71867

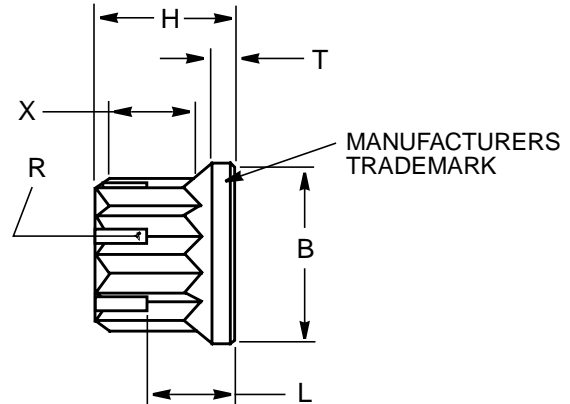
SOURCE CONTROL DRAWING

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

SOURCE CONTROL DRAWING



OPPOSITE SLOTS MUST COINCIDE WITHIN .005. SLOT C/L MUST BE WITHIN .005 OF THREAD P.D. AXIS



DASH NO.	THREAD UNJF 3B	ØA MAX	B MIN	C MIN	L 0.015	M +0.031 -0.000	H MAX	R MAX	X MIN	T MAX	W		AXIAL TENSILE STRENGTH (LBS) MIN
											MAX	MIN	
-3	.1900-32	.385	.355	.347	.138	.078	.236	.035	.118	.062	.313	.305	3,900
-4	.2500-28	.448	.418	.419	.143		.315		.190	.070	.376	.367	6,990
-5	.3125-24	.541	.511	.491	.183		.367		.239	.070	.439	.430	11,000
-6	.3750-24	.603	.573	.561	.234	.125	.416	.053	.270	.080	.502	.492	17,100
-7	.4375-20	.697	.667	.631	.293		.495		.317	.087	.564	.553	23,100
-8	.5000-20	.828	.761	.703	.343		.547		.341	.107	.627	.616	30,900
-9	.5625-18	.880	.850	.775	.390	.156	.620	.063	.385	.134	.690	.679	39,200
-10	.6250-18	.970	.940	.846	.453		.672		.416	.154	.752	.741	48,000
-12	.7500-16	1.252	1.222	1.059	.606		.836		.425	.180	.940	.928	71,100
-14	.8750-14	1.438	1.408	1.200	.665		.958		.568	.200	1.064	1.052	97,300

MATERIAL: ALLOY STEEL 8740 PER AMS6322, 4140 PER AMS6382, or 4340 PER AMS 6415

© **HEAT TREAT:** R_c 40 - 45

FINISH: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. BAKE AT 375°F FOR 23 HRS AFTER PLATING

LIST OF CURRENT SHEETS					
SHEET	1	2			
REV	C	C			

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	R. KROMKAMP	TITLE: NUT, 12 POINT, CASTELLATED, 180 KSI, 450°F	DSC 370
CHECKED	P. LAM		
STRESS	W. CLENNETT		PAGE 1 OF 2
APPROVED	S.SCHRATTNER		

© REDRAWN FROM 'B' SIZE SHT
TABLE - 'X' MIN WAS 'X' MAX
H.T. R_c 40 - 45 WAS R_c 45 MAX

REV: REV: REV: REV: C - 3 FEB 99 REV: B - 2 SEP 98 REV: A - 5 MAY 95 APPROVED: 21 JAN 1985

THE INFORMATION, TECHNICAL DATA AND DESIGNS DISCLOSED IN THIS DOCUMENT (THE "INFORMATION") ARE EITHER THE EXCLUSIVE PROPERTY OF BOMBARDIER INC., OR ARE SUBJECT TO PROPRIETARY RIGHTS OF OTHERS. THE INFORMATION IS NOT TO BE USED FOR DESIGN OR MANUFACTURE, OR DISCLOSED TO OTHERS WITHOUT THE EXPRESS PRIOR WRITTEN CONSENT OF BOMBARDIER INC. THE HOLDER OF THIS DOCUMENT, BY ITS RETENTION AND USE, AGREES TO HOLD THE INFORMATION IN CONFIDENCE. THESE RESTRICTIONS DO NOT APPLY TO PERSONS HAVING PROPRIETARY RIGHTS IN THE INFORMATION, TO THE EXTENT OF THOSE RIGHTS.

de HAVILLAND

CAGE CODE 71867

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 FOR USE IN DE HAVILLAND AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY DE HAVILLAND ENGINEERING STANDARDS

SOURCE CONTROL DRAWING

NOTES:

- ③ 1. THREADS TO MIL-S-8879.
- ③ 2. LOCKING TORQUE PER MIL-N-25027 FOR 5 CYCLES AT ROOM TEMPERATURE AND AFTER BAKE AT 450°F WHEN TESTED ON A CROSSDRILLED BOLT
- 3. THE PROCUREMENT DEPARTMENT SHALL SPECIFY THE DSC AND THE MANUFACTURER'S PART NUMBER ON THE PURCHASE ORDER.

APPROVED VENDORS LISTING

DE HAVILLAND NUMBER	SPS		KAYNAR	SPACE-LOK
DSC370-3	81811-1032	83957-1032		SLN180-1032
DSC370-4	81811-428	83957-428		SLN180-428
DSC370-5	81811-524	83957-524		SLN180-524
DSC370-6	81811-624	83957-624		SLN180-624
DSC370-7	81811-720	83957-720		SLN180-720
DSC370-8	81811-820	83957-820	H52844-8	SLN180-820
DSC370-9	81811-918	83957-918		SLN180-918
DSC370-10	81811-1018	83957-1018		SLN180-1018
DSC370-12	81811-1216	83957-1216		SLN180-1216
DSC370-14		83957-1414		SLN180-1414

③ **VENDORS ADDRESSES & CAGE CODES**

SPS TECHNOLOGIES INC

JENKINTOWN, PA

CAGE CODE - 56878

KAYNAR TECHNOLOGIES INC

FULLERTON, CA

CAGE CODE - 15653

SPACE-LOK INC

BURBANK, CA

CAGE CODE - 16258

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	R. KROMKAMP	TITLE: NUT, 12 POINT, CASTELLATED, 180 KSI, 450°F	DSC 370
CHECKED	P. LAM		
STRESS	W. CLENNETT		PAGE 2
APPROVED	S. SCHRATTNER		

③ REDRAWN FROM 'B' SIZE SHT
NOTE 1 ADDED, NOTE 2 - REF CROSSDRILLED BOLT ADDED
VENDORS ADDRESSES AND CAGE CODES ADDED

APPROVED: 21 JAN 1985 REV: A - 5 MAY 95 REV: B - 2 SEP 98 REV: 3 FEB 99 REV: REV: