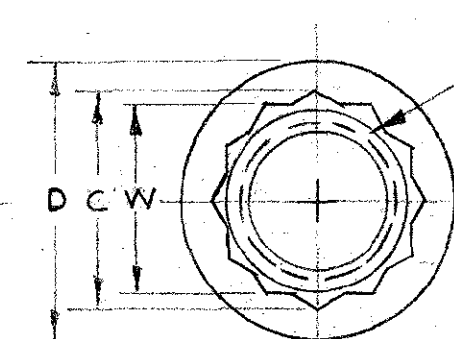
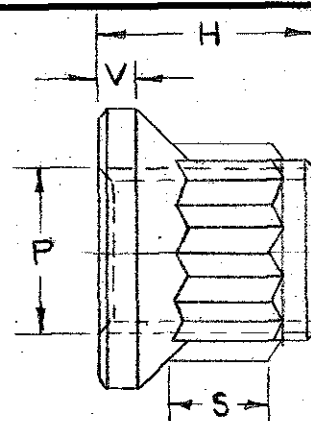


This drawing is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without the permission of THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED

REPORT ALL DRAWING ERRORS
TO ENGINEERING

REVISIONS

CHANGE	ITEM NO.	DESCRIPTION	DATE	DRAWN	CHECKED	STRESS	APPROVD.
A		47 FLW SERIES ADDED TO VENDOR LIST. TYPE II CLASS 3 ADDED TO FINISH SPEC	05/10/73	PK	SCHLEGEL		
B		KAYNAR H50439 SERIES ADDED	20/06/85	P. LAW	PK		B
C		'P' DIM FOR -7 1/8 WAS .462 & .525 ESNA NDS FOR -7, 8 & 9 ADDED VOI-SHAN NUMBERS ADDED	29/12/88	PK	P. LAW		
D		SELF-LOCKING NOTE CLARIFIED	17/9/90	PK	P		



UPPER THREADED PORTION DEFORMED TO PROVIDE SELF-LOCKING ACTION.

PART NO.	THREAD SIZE	D MAX.	H MAX.	W MAX MIN	P MAX.	V MIN.	C REF.	S MIN.	ULT. TENSILE STR. LBS MIN	APPROX WEIGHT LB/100	APPROVED VENDORS				
											SPS	SPS'	KAYNAR	VOI-SHAN	ESNA
DSC 97-4	1/4-28 UNJF3B	.444	.290	.376-.367	.280	.040	.419	.096	7,270	.62	42FLW-428	47FLW-428	H50439-4	VN427C048	
-5	5/16-24	.547	.363	.439-.430	.342	.044	.491	.108	11,500	1.07	-524	-524	-5	054	
-6	3/8-24	.654	.438	.502-.492	.405	.056	.561	.147	17,100	1.75	-624	-624	-6	064	
-7	7/16-20	.753	.506	.564-.553	.473	.069	.631	.203	23,200	2.06	-720	-720	-7	070	LH18A-7
-8	1/2-20	.863	.549	.627-.616	.535	.074	.703	.229	30,900	3.71	-820	-820	-8	080	LH18A-8
-9	9/16-18	.938	.600	.690-.676	.597	.079	.775	.208	39,100	4.35	-918	-918	-9	098	LH18A-9
-10	5/8-18	1.050	.650	.783-.772	.660	.084	.881	.267	49,100	5.62	-1018	-1018	-10	108	
DSC 97-12	3/4-16 UNJF3B	1.230	.750	.940-.928	.785	.094	1.059	.296	71,200	9.90	42FLW-1216	47FLW-1216	H50439-12	VN427C126	

MATERIAL: ALLOY STEEL, HEAT TREATED.

FINISH: CAD. PLATE PER QQ-P-416 TYPE I, CLASS 3(42FLW SERIES) OR TYPE II CLASS 3(47FLW SERIES) (H50439 SERIES)

THREADS: MIL-S-8879

PERFORMANCE: LOCKING TORQUE PER MIL-N-25027. THE ABOVE TABULATED VALUES

WILL BE OBTAINED WHEN TENSILE TESTED ON A BOLT HAVING A MIN.

TENSILE STRENGTH OF 220,000 PSI.

THIS DESIGN IS SUITED FOR APPLICATION WITH HIGH STRENGTH BOLTS

SUCH AS MS21250 & MS20004 SERIES

PART CODING: DSC 97-4

THREAD SIZE (1/4-28 UNJF3B)
BASIC PART NO.

MAGNETIC PARTICLE INSPECTION 100% AS PER MIL-I-6868

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 LIMITED FOR THE USE IN DHC AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY THE DE HAVILLAND AIRCRAFT OF CANADA LTD.

DRAWN	KROMKAMP
CHECKED	Shueh
STD, M&P	S. SCHRAITNER
STRESS	RADZINS
CH. DRAFT	SCHLEGEL
DATE	20 JUNE 73

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED
DOWNSVIEW ONTARIO

DRAWING TITLE

NUT - 12 POINT

LIGHTWEIGHT, SELF-LOCKING 180 KSI

CODE IDENT NO.	DWG SIZE	DRAWING NO.	RELEASE	REV.
71867	B	DSC 97		D
SCALE	WGT. CALC	ACTUAL	SHEET	