

lisi AEROSPACE
 Tour Gamma-A
 193, rue de Bercy
 75582 PARIS CEDEX 12
 Phone 33 (0)1 44 67 85 85
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Insert, self-locking,
 self-broaching keys,
 floating, 425°C max.
 first oversize.

SCD204

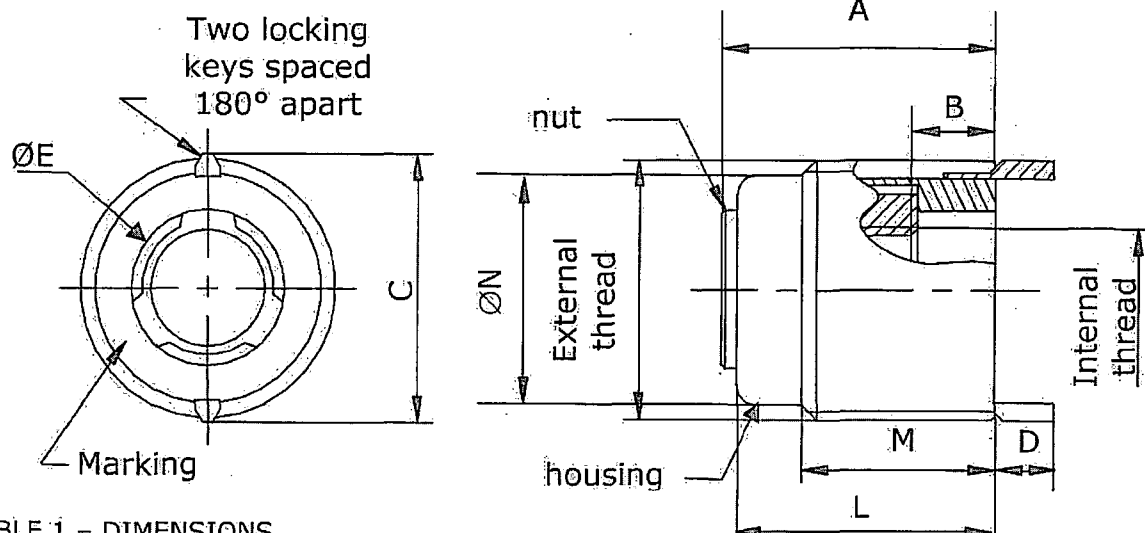


TABLE 1 – DIMENSIONS

Diameter code		064
Internal thread		.250-28 UNJF-3B
External thread (Minor dia. modified)	UNS - 2A	.5625-18
	Minor dia.	12,62 12,42
	Pitch dia.	13,33 13,22
	Major dia.	14,25 14,03

Diameter code	064
A±0,3	12,9
B min. (1)	3,55
C max.	14,3
D min.	3,15
ØE	7,45 7,40
M	9,25 8,00
ØN max.	11,50

RECU 20 JUL. 2006

(1) Measured when the nut is in contact with the housing.

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Issue
PAGE 1/3	Y. DOUARD		19/5/06	F. VERDIER		13/5/06	A

DIFFUSION CONTROLEE
 A-AI-C-E-G-H-I-L-M-P-S-T-V

20 JUL. 2006



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Materials :

Nut and housing : A286 as per AMS5737 or AMS5731 (160 KSI), hardness 36 HRC min.

Keys : Corrosion resistant steel – Heat treatment to final hardness HV>650.

Finish: Passivated as per AMS-QQ-P-35.

Lubrication : Dry film lubricant on nut only, as per AS 1701 Class V or VI.

Internal thread: in accordance with AS8879.

External thread: in accordance with ASME B1.1 except modified minor diameter per TABLE 1.

Marking : Manufacturer's symbol " T ".

Technical specification : MIL-I-45914.

The insert shall accept a minimum free rotation of four turns on a corresponding test bolt having class 3A thread.

Minimum radial float: 0,5 mm.

A light bead is accepted at bottom of external thread intersecting longitudinal slots , subject to pass free in a go threaded gage according to TABLE 2, and not to be detrimental to driving in locking keys during insert installation.

Temperature class : 425°C.

Part number designation : SCD204-064

SCD204 designates basic part number and 064 designates diameter code.

Use SCD205 for oversize replacement.

TABLE 2 – GO THREADED GAGE FOR EXTERNAL THREAD.

Diameter code	064
Minor dia. +0,05 0	13,30
Pitch dia. +0,05 0	13,37
Major dia. +0,05 0	14,29

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Revision	Date	Name	Modification(s)	Justification(s)
-	10/11/2004	A. BERTON	New document	-
A	19/07/2006	Y.DOULARD	-Dmini=3,15 instead of D=3,96±0,25 -Add of ØE	-According to production -Functional dimension to fit tooling

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