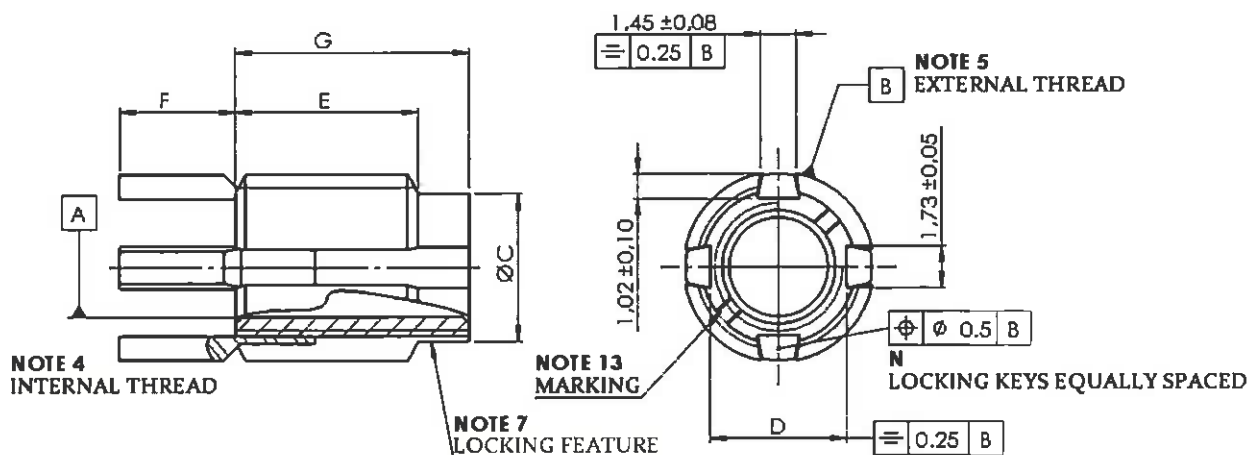




Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

INSERT, THIN WALL, SELF-LOCKING, KEY LOCKED ,SCREW THREAD 17- 4Ph STAINLESS STEEL , LONG THREAD

SCD166



GENERAL NOTES

1- MATERIALS

- Insert : Z5CNU17 (17-4 PH) per AMS 5643
Strength class 1100 Mpa Minimum (160,000 PSI)
- Keys : Z12CN18-10 per AIR 9160 or AISI302 corrosion resistant steel per Q.Q.W.423
Annealed, cold worked , tempering to final hardness Hv > 380

2- FINISH : passivated per AMS2700

3- LUBRIFICATION : MoS2 dry film lubricant on all surfaces optional on keys per EN2491

4- INTERNAL THREAD A : according to AS8879

5- EXTERNAL THREAD B : according to MIL-S-7742 except modified minor diameter per table 1

THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LISI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 1/5	D PERNES		20/10/2012	B.REGNARD		20/10/2012	D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

INSERT, THIN WALL, SELF-LOCKING, KEY LOCKED ,SCREW THREAD 17- 4Ph STAINLESS STEEL , LONG THREAD

SCD166

TABLEAU 1- DIMENSIONS in millimeters

Diameter code		048	064	079	095	111	127
A UNJF-3B		10-32	1/4-28	5/16-24	3/8-24	7/16-20	1 1/2-20
B	UNC-2A	5/16-18	3/8-16	7/16-14	1 1/2-13	9/16-12	5/8-11
	Minor Dia.	6.5 6.32	8.13 7.92	9.73 9.52	11.18 10.97	12.78 12.57	14.35 14.00
	Pitch Dia.	6.99 6.89	8.46 8.35	9.9 9.78	11.39 11.26	12.87 12.74	14.34 14.20
	Major Dia	7.91 7.69	9.49 9.25	11.08 10.82	12.66 12.39	14.25 13.96	15.83 15.53
C	MAXI	6.3	7.9	9.5	11.0	12.6	14.00
D	± 0.10	5.6	7.2	8.75	10.35	11.9	13.5
E	± 0.20	7.5	10.4	13.2	16.3	19.2	22.4
F	± 0.35	4.75	4.75	4.75	4.75	5.55	5.55
G	± 0.30	9.6	12.7	15.8	19.05	22.2	25.4
N	Nb of keys	2	2	4	4	4	4

6-THREAD RUN OUT : Per ISO3353

7-LOCKING FEATURE : by deformation of threads

8-UTILISATION TEMPERATURE LIMIT: 350° C maxi

9-SURFACE FINISH : Ra µm : 3.2

10-A light bead is accepted at bottom of external threads intersecting longitudinal lots , 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 .

THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LISI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 2/5	D PERNES			B.REGNARD			D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

INSERT, THIN WALL, SELF-LOCKING, KEY LOCKED ,SCREW THREAD 17- 4Ph STAINLESS STEEL , LONG THREAD

SCD166

TABLE 2

EXTERNAL THREAD	MINOR DIA. + 0.05 0	PITCH DIA. + 0.05 0	MAJOR DIA. + 0.05 0
5/16-18	6.88	7.020	7.937
3 /8-16	8.41	8.493	9.525
7 /16-14	10.06	9.933	11.112
1 /2-13	11.48	11.430	12.700
9/16-12	13.08	12.913	14.287
5/8-11	14.66	14.376	15.875

11-PROCUREMENT SPECIFICATION : MIL.I.45914

12-INSTRUCTION FOR INSTALLATION : SC601

13-MARKING :

LISI ST OUEN : none
LISI FTB (IZMIR), 2 parallel radial lines located at 180°

14-PART NUMBER DESIGNATION :

Example:

SCD 166 - 064



THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LISI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 3/5	D PERNES			B.REGNARD			D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

INSERT, THIN WALL, SELF-LOCKING, KEY LOCKED ,SCREW THREAD 17- 4Ph STAINLESS STEEL , LONG THREAD

SCD166

Revision Date	INDICE	Modifications
14.10.92	-	New Standard form
08.12.92	A	Marking on drawing removed Table 1 : F was Ø CODE 048 to 095: 5.55 Ø CODE 111 and 127 : 8.85 Key material was EZ6NCT25 Identification note 7 deleted
20.11.2012	B	Protection QQ-P-35 replaced by AMS2700 Lubrification : EN2491 added 13- MARKING added
13.12..2012	C	KEY chanel depth tolerance modified from 0.01 to 0,1 mm
19.12..2012	D	KEY chanel depth value modified from 1 to 1,02

THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LSI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 4/5	D PERNES			B.REGNARD			D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

**INSERT, THIN WALL, SELF-LOCKING,
KEY LOCKED ,SCREW THREAD
17- 4Ph STAINLESS STEEL , LONG
THREAD**

SCD166

LISTE DE DIFFUSION

Revision	Date de diffusion	Client	Address	Nom
D	17/12/2012	LISI IZMIR	-	Arnaud BROS

THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LISI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 5/5	D PERNES			B.REGNARD			D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

INSERT, THIN WALL, SELF-LOCKING, KEY LOCKED ,SCREW THREAD 17- 4Ph STAINLESS STEEL , LONG THREAD

SCD166

TABLE 2

EXTERNAL THREAD	MINOR DIA. + 0.05 0	PITCH DIA. + 0.05 0	MAJOR DIA. + 0.05 0
5/16-18	6.88	7.020	7.937
3 /8-16	8.41	8.493	9.525
7 /16-14	10.06	9.933	11.112
1 /2-13	11.48	11.430	12.700
9/16-12	13.08	12.913	14.287
5/8-11	14.66	14.376	15.875

11-PROCUREMENT SPECIFICATION : MIL-I.45914

12-INSTRUCTION FOR INSTALLATION : SC601

13-MARKING :

LISI ST OUEN : none
LISI FTB (IZMIR), 2 parallel radial lines located at 180°

14-PART NUMBER DESIGNATION :

Example:

SCD 166 - 064

Diameter code in tenth of mm

Basic part number

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 3/5	D PERNES			B.REGNARD			D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

INSERT, THIN WALL, SELF-LOCKING, KEY LOCKED ,SCREW THREAD 17- 4Ph STAINLESS STEEL , LONG THREAD

SCD166

Revision Date	INDICE	Modifications
14.10.92	-	New Standard form
08.12.92	A	Marking on drawing removed Table 1 : F was Ø CODE 048 to 095: 5.55 Ø CODE 111 and 127 : 8.85 Key material was EZ6NCT25 Identification note 7 deleted
20.11.2012	B	Protection QQ-P-35 replaced by AMS2700 Lubrication : EN2491 added 13- MARKING added
13.12..2012	C	KEY chanel depth tolerance modified from 0.01 to 0,1 mm
19.12..2012	D	KEY chanel depth value modified from 1 to 1,02

THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LISI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 4/5	D PERNES			B.REGNARD			D



Central Seine
46-50 quai de la Rapée
CS 11 233
75583 PARIS CEDEX 12
TEL : +33 (0)1 40 19 82 00
FAX : +33 (0)1 40 19 82 01

**INSERT, THIN WALL, SELF-LOCKING,
KEY LOCKED ,SCREW THREAD
17- 4Ph STAINLESS STEEL , LONG
THREAD**

SCD166

LISTE DE DIFFUSION

Revision	Date de diffusion	Client	Address	Nom
D	17/12/2012	LISI IZMIR	-	Arnaud BROS

THIS DRAWING AND ALL TECHNICAL INFORMATION DISCLOSED THEREIN ARE THE EXCLUSIVE PROPERTY OF LISI AEROSPACE

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 5/5	D PERNES			B.REGNARD			D