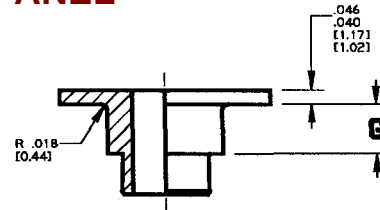
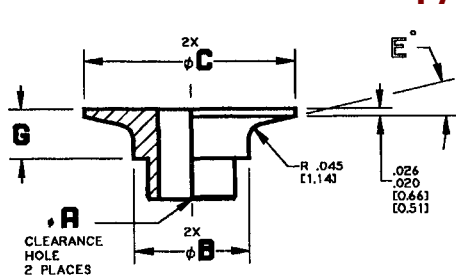
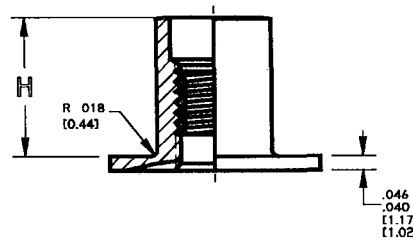
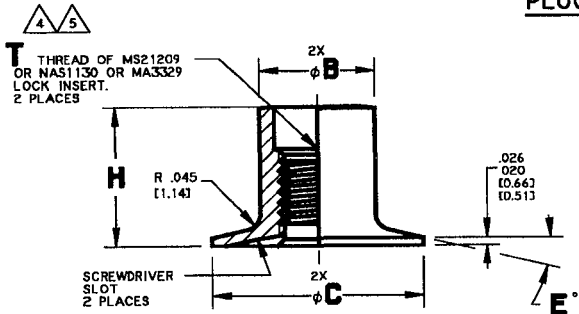




# INSERTS FOR METALLIC FACE SKIN PANEL



**PLUG HEAD STYLES**



**SLEEVE HEAD STYLES**

**TABLE II**

MATL. CODE	MATERIAL	STANDARD FINISH
0	AL. ALLOY 2024-T4 PER AMS-QQ-A-225/6	CHEM FILM PER MIL-C-5541, CLASS 1A
3	CRES 13-8Mo	PASSIVATE PER AMS-QQ-P-35
6	CRES 303 PER ASTM A582	PASSIVATE PER AMS-QQ-P-35
9	CARBON STEEL PER ASTM A108	CADMIUM PLATE PER QQ-P-416, TYPE II, CL. 2

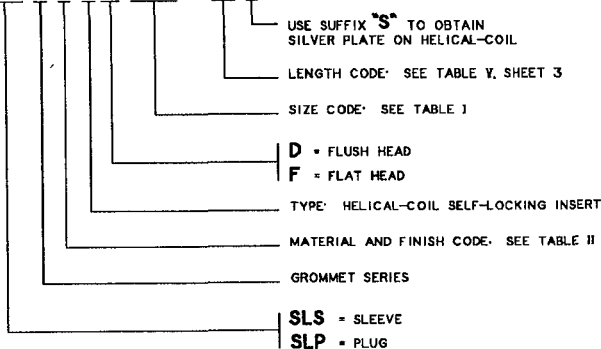
**TABLE I**

PLUG SIZE CODE	SLEEVE SIZE CODE	T THREAD	phi A +.002 -.003 (+0.05) (-0.08)	phi B ±.002 (±0.05)	phi C	E
6	632	1380-32UNC-3B	.142 (3.61)	.309 (7.85)	.500 (12.70)	13'
M3	M3	M3X0.5-4H6H				
8	832	1640-32UNC-3B	.168 (4.27)	.309 (7.85)	.500 (12.70)	13'
M4	M4	M4X0.7-4H6H				
10	1032	1900-32UNF-3B	.194 (4.93)	.341 (8.66)	.625 (15.88)	13'
M5	M5	M5X0.8-4H6H				
25	428	2500-28UNF-3B	.256 (6.50)	.403 (10.24)	.750 (19.05)	14'
M6	M6	M6X1-4H5H				
31	524	3125-24UNF-3B	.318 (8.08)	.497 (12.62)	.875 (22.22)	14'
M8	M8	M8X1.25-4H5H				

**EXAMPLE OF PART CODING**

SLEEVE = SLS 1 0 6 F 1032 - 08 S (INCH)  
 PLUG = SLP 1 0 6 D 10 - 1 (INCH)

SLEEVE = SLS 1 0 6 F M5 - 08 S (METRIC)  
 PLUG = SLP 1 0 6 D M5 - 1 (METRIC)



**NOTES:**

- ANY COMBINATION OF SLEEVE AND PLUG MAY BE USED.
- REFER TO TABLE V, SHEET 3 FOR SELECTION OF SLEEVE/PLUG COMBINATIONS FOR STANDARD PANEL CONFIGURATION.
- REFER TO SLD100 DATA SHEET FOR INSTALLATION PROCEDURE.
- LOCKING INSERT: MS21209 OR NAS1130 = INCH SERIES  
MA3329 = METRIC SERIES  
INSTALL PER MS33537 (INCH)  
MA1567 (METRIC)
- THREADED SLEEVE CAN BE USED WITH UN OR UNJ (INCH) OR M OR MJ (METRIC) EXTERNAL THREADS.
- TOLERANCES: .XXX ± .005 [0.13]  
ANGLES: ± 1°

**APPLICATION:**

A MECHANICAL SPACER FOR USE IN PANELS WITH METAL FACE SKINS. INSTALLATION TO BE MADE FROM BOTH SIDES OF PANEL.

UNLESS OTHERWISE SPECIFIED INTERPRET DIMENSIONS & TOLERANCES PER ANSI Y14.5M. ALL DIMENSIONS APPLY AFTER PLATING AND PRIOR TO THE ADDITION OF SOLID FILM LUBRICANT. 125 [3.2] ALL SURFACES  
 TOLERANCES  
 .XX .XXX ANGLES [X.X] [X.X X]  
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]  
 DIMENSIONS IN [ ] ARE MILLIMETERS

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**SL106**

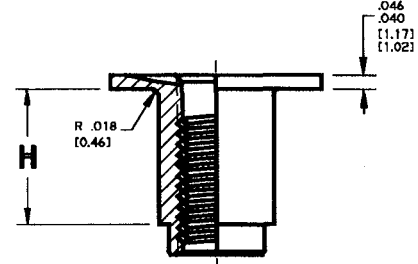
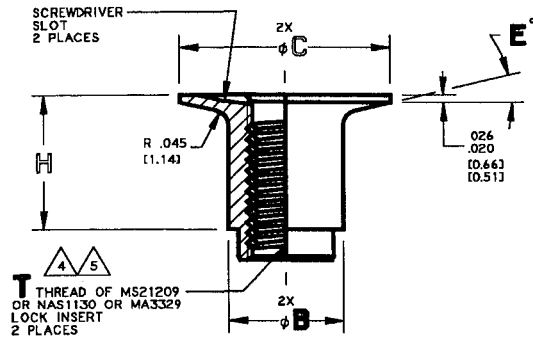
**INSERT, GROMMET TYPE, SELF-LOCKING.  
 HELICAL-COIL, STANDARD PANEL**

SHEET 1 OF 3

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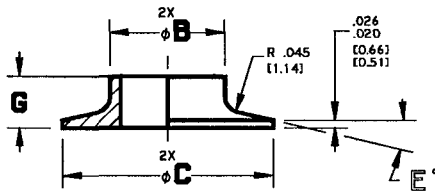
# INSERTS FOR METALLIC FACE SKIN PANEL



D

## PLUG HEAD STYLES

F



D

## SLEEVE HEAD STYLES

F

TABLE IV

MATL CODE	MATERIAL	STANDARD FINISH
0	AL ALLOY 2024-T4 PER AMS-QQ-A-225/6	CHEM FILM PER MIL-C-5541, CLASS 1A
3	CRES 13-8M	PASSIVATE PER AMS-QQ-P-35
4	CRES 303 PER ASTM A582	PASSIVATE PER AMS-QQ-P-35
9	CARBON STEEL PER ASTM A108	CADMIUM PLATE PER QQ-P-416, TYPE II, CL 2

TABLE III

SLEEVE SIZE CODE	PLUG SIZE CODE	T THREAD	Ø B ±.002 ±(0.05)	Ø C [12.70]	E [13']
6	632	.1380-32UNC-3B	.309	.500	13'
M3	M3	M3X0.5-4H6H	[7.85]	[12.70]	
8	832	.1640-32UNC-3B	.309	.500	13'
M4	M4	M4X0.7-4H6H	[7.85]	[12.70]	
10	1032	.1900-32UNC-3B	.341	.625	13'
M5	M5	M5X0.8-4H6H	[8.66]	[15.88]	
25	428	.2500-28UNF-3B	.403	.750	14'
M6	M6	M6X1-4H5H	[10.24]	[19.05]	
31	524	.3125-24UNF-3B	.497	.875	14'
M8	M8	M8X1.25-4H5H	[12.62]	[22.22]	

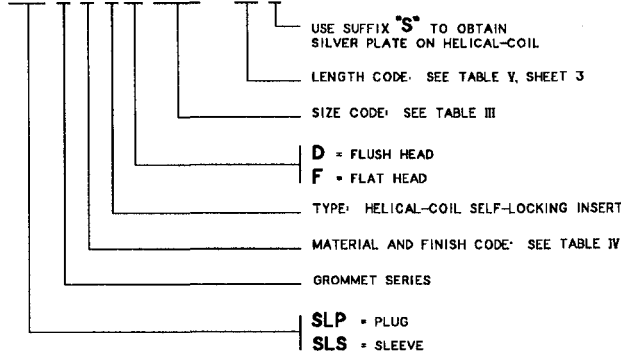
### EXAMPLE OF PART CODING

PLUG = SLP 1 0 6 F 1032 - 08 S (INCH)

SLEEVE = SLS 1 0 6 D 10 - 1 (INCH)

PLUG = SLP 1 0 6 F M5 - 08 S (METRIC)

SLEEVE = SLS 1 0 6 D M5 - 1 (METRIC)



### APPLICATION

A MECHANICAL SPACER FOR USE IN PANELS WITH METAL FACE SKINS. INSTALLATION TO BE MADE FROM BOTH SIDES OF PANEL.

### NOTES

- ANY COMBINATION OF SLEEVE AND PLUG MAY BE USED.
- REFER TO TABLE VI, SHEET 3, FOR SELECTION OF PLUG/SLEEVE COMBINATIONS FOR THIN PANEL CONFIGURATION.
- REFER TO SLD100 DATA SHEET FOR INSTALLATION PROCEDURE.
- LOCKING INSERT: MS21209 OR NAS1130 = INCH SERIES MA3329 = METRIC SERIES INSTALL PER MS3357 (INCH) MA1567 (METRIC)
- THREADED PLUG CAN BE USED WITH UN OR UNJ (INCH) OR M OR MJ (METRIC) EXTERNAL THREADS.
- TOLERANCES: XXX ± .005 [0.13] ANGLES: ± 1'

UNLESS OTHERWISE SPECIFIED INTERPRET DIMENSIONS & TOLERANCES PER ANSI Y14.5M. ALL DIMENSIONS APPLY AFTER PLATING AND PRIOR TO THE ADDITION OF SOLID FILM LUBRICANT. 125 [3.2] ALL SURFACES  
TOLERANCES XX .XXX ANGLES [X.X] [X.X X] ±.03 ±.010 ±2° ±[0.8] ±[0.25]  
DIMENSIONS IN [ ] ARE MILLIMETERS

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**INSERT, GROMMET TYPE, SELF-LOCKING,  
HELICAL-COIL, THIN PANEL**

**SL106**

SHEET 2 OF 3

REVISION (J) 18 OCTOBER 1999

# INSERTS FOR METALLIC FACE SKIN PANEL



**TABLE V SLEEVE/PLUG COMBINATIONS FOR STANDARD PANEL**

SLEEVE				PLUG				STANDARD PANEL THICKNESS
TYPE & HEAD	SIZE CODE	LENGTH CODE	H	TYPE & HEAD	SIZE CODE	LENGTH CODE	G	
SLS106D SLS106F	632 832 1032 M3 M4 M5	08	.415 [10.54]	SLP106D SLP106F	6 8 10 M3 M4 M5	0	.085 [2.16]	.500 [12.70]
						1	.116 [2.95]	.531 [13.49]
						2	.147 [3.73]	.562 [14.27]
						3	.179 [4.55]	.593 [15.06]
SLS106D SLS106F	632 832 1032 428 M3 M4 M5 M6	10	.540 [13.72]	SLP106D SLP106F	6 8 10 25 M3 M4 M5 M6	0	.085 [2.16]	.625 [15.88]
						1	.116 [2.95]	.656 [16.66]
						2	.147 [3.73]	.687 [17.45]
						3	.179 [4.55]	.718 [18.24]
SLS106D SLS106F	632 832 1032 428 M3 M4 M5 M6	12	.665 [16.89]	SLP106D SLP106F	6 8 10 25 M3 M4 M5 M6	0	.085 [2.16]	.750 [19.05]
						1	.116 [2.95]	.781 [19.84]
						2	.147 [3.73]	.812 [20.62]
						3	.179 [4.55]	.843 [21.41]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	14	.790 [20.07]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	.875 [22.22]
						1	.116 [2.95]	.906 [23.01]
						2	.147 [3.73]	.937 [23.80]
						3	.179 [4.55]	.968 [24.59]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	16	.915 [23.24]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.000 [25.40]
						1	.116 [2.95]	1.031 [26.19]
						2	.147 [3.73]	1.062 [26.97]
						3	.179 [4.55]	1.093 [27.76]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	18	1.040 [26.42]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.125 [28.57]
						1	.116 [2.95]	1.156 [29.36]
						2	.147 [3.73]	1.187 [30.15]
						3	.179 [4.55]	1.218 [30.94]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	20	1.165 [29.59]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.250 [31.75]
						1	.116 [2.95]	1.281 [32.54]
						2	.147 [3.73]	1.312 [33.32]
						3	.179 [4.55]	1.343 [34.11]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	22	1.290 [32.77]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.375 [34.92]
						1	.116 [2.95]	1.406 [35.71]
						2	.147 [3.73]	1.437 [36.50]
						3	.179 [4.55]	1.469 [37.31]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	24	1.415 [35.94]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.500 [38.10]
						1	.116 [2.95]	1.531 [38.89]
						2	.147 [3.73]	1.562 [39.67]
						3	.179 [4.55]	1.594 [40.49]

**TABLE V CONTD**

SLEEVE				PLUG				STANDARD PANEL THICKNESS
TYPE & HEAD	SIZE CODE	LENGTH CODE	H	TYPE & HEAD	SIZE CODE	LENGTH CODE	G	
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	26	1.540 [39.12]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.625 [41.27]
						1	.116 [2.95]	1.656 [42.06]
						2	.147 [3.73]	1.687 [42.85]
						3	.179 [4.55]	1.719 [43.64]
SLS106D SLS106F	632 832 1032 428 524 M3 M4 M5 M6 M8	28	1.665 [42.29]	SLP106D SLP106F	6 8 10 25 31 M3 M4 M5 M6 M8	0	.085 [2.16]	1.750 [44.45]
						1	.116 [2.95]	1.781 [45.24]
						2	.147 [3.73]	1.812 [46.02]
						3	.179 [4.55]	1.844 [46.84]

**TABLE VI PLUG/SLEEVE COMBINATIONS FOR THIN PANEL**

PLUG				SLEEVE				STANDARD PANEL THICKNESS
TYPE & HEAD	SIZE CODE	LENGTH CODE	H	TYPE & HEAD	SIZE CODE	LENGTH CODE	G	
SLP106D SLP106F	632 832 1032 M3 M4 M5	04	.151 [3.84]	SLP106D SLP106F	6 8 10 M3 M4 M5	0	.094 [2.39]	.250 [6.35]
						1	.125 [3.17]	.281 [7.14]
						2	.156 [3.96]	.312 [7.92]
						3	.187 [4.75]	.343 [8.71]
SLP106D SLP106F	632 832 1032 428 M3 M4 M5 M6	06	.281 [7.14]	SLP106D SLP106F	6 8 10 25 M3 M4 M5 M6	0	.094 [2.39]	.375 [9.53]
						1	.125 [3.17]	.406 [10.31]
						2	.156 [3.96]	.437 [11.10]
						3	.187 [4.75]	.468 [11.89]
SLP106D SLP106F	428 524 M6 M8	08	.401 [10.19]	SLP106D SLP106F	25 31 M6 M8	0	.094 [2.39]	.500 [12.70]
						1	.125 [3.17]	.531 [13.49]
						2	.156 [3.96]	.562 [14.27]
						3	.187 [4.75]	.593 [15.06]
SLP106D SLP106F	524 M8	10	.526 [13.36]	SLP106D SLP106F	31 M8	0	.094 [2.39]	.625 [15.88]
						1	.125 [3.17]	.656 [16.66]
						2	.156 [3.96]	.687 [17.45]
						3	.187 [4.75]	.718 [18.24]
SLP106D SLP106F	524 M8	12	.651 [16.54]	SLP106D SLP106F	31 M8	0	.094 [2.39]	.750 [19.05]
						1	.125 [3.17]	.781 [19.84]
						2	.156 [3.96]	.812 [20.62]
						3	.187 [4.75]	.843 [21.41]

UNLESS OTHERWISE SPECIFIED  
INTERPRET DIMENSIONS & TOLERANCES PER  
ANSI Y14.5M. ALL DIMENSIONS APPLY AFTER  
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TOLERANCES  
.XX .XXX ANGLES [X.X] [X.X X]  
±.03 ±.010 ±2° ±[0.8] ±[0.25]  
DIMENSIONS IN [ ] ARE MILLIMETERS

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**INSERT, GROMMET TYPE, SELF-LOCKING,  
HELICAL-COIL, SELECTION TABLES**

**SL106**

SHEET **3** OF **3**

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