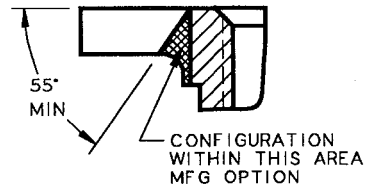
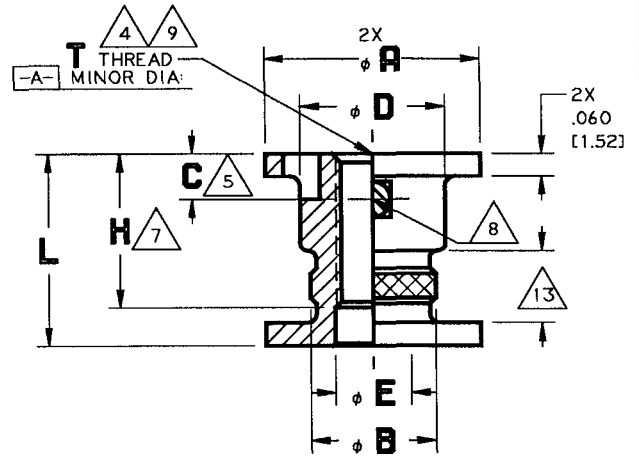
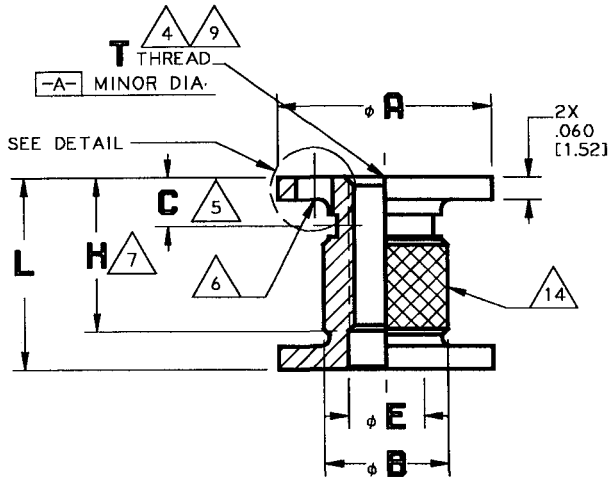
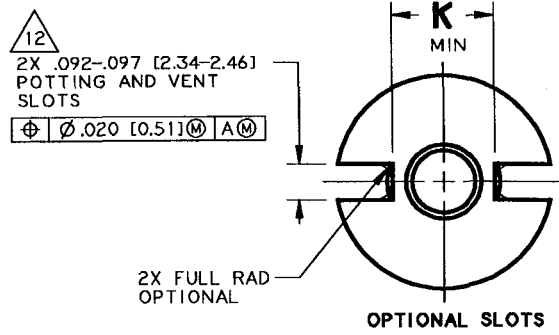
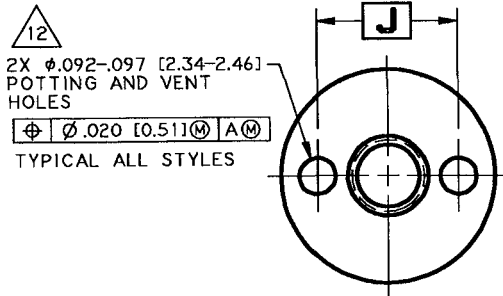




INSERTS FOR ALL TYPE SANDWICH PANELS



EXAMPLE OF PART CODING:

SL602 -3 - 500 C S N (INCH)

SL602 M5 - 12.7 C S N [METRIC]

- NYLON PELLET THREAD LOCK IN STEEL OR CRES INSERT
- SPECIAL FINISH CODE (SEE TABLE III)
- MATERIAL AND FINISH CODE (SEE TABLE II)
- INCH = PANEL THKNS IN THOUSANDTHS
- METRIC = PANEL THKNS IN MILLIMETERS
- - INDICATES THREAD LOCK
- N INDICATES NO THREAD LOCK
- SIZE CODE (SEE TABLE I)
- BASIC PART NUMBER

DETAIL - OPTIONAL SLOTS.
TYPICAL ALL STYLES

NOTES:

SEE SHEET 2.

APPLICATION:

AN EPOXY POTTED-IN THROUGH THREADED INSERT WITH FLUSH FACES ON BOTH SIDES OF PANEL. INSERT SERVES AS NUT FOR MAKING ATTACHMENTS WITH SCREW OR BOLT.

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,
THROUGH THREADED**

SL602

SHEET 1 OF 2



INSERTS FOR ALL TYPE SANDWICH PANELS

TABLE I

SIZE CODE	T THREAD 	φ A +.000 -.010 [0.0] [0.25]	φ B	C REF	D	φ E	H 	J BASIC	K MIN	L MIN 	INSTALLATION HOLE SIZE
06	.1380-32UNJC-3B	.560 [14.22]	.30 [7.6]	.12 [3.0]	.375 [9.52]	.139-.145 [3.53-3.68]	.276 [7.01]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
M3	M3X0.5 4H6H										
08	.1640-32UNJC-3B	.560 [14.22]	.30 [7.6]	.12 [3.0]	.375 [9.52]	.168-.174 [4.27-4.42]	.328 [8.33]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
M4	M4X0.7 4H6H										
3	.1900-32UNJF-3B	.560 [14.22]	.30 [7.6]	.12 [3.0]	.375 [9.52]	.195-.201 [4.95-5.11]	.380 [9.65]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
M5	M5X0.8 4H6H										
4	.2500-28UNJF-3B	.685 [17.40]	.37 [9.4]	.14 [3.6]	.440 [11.18]	.256-.263 [6.50-6.68]	.500 [12.70]	.467 [11.86]	.360 [9.14]	.312 [7.92]	.686-.691 [17.42-17.55]
M6	M6X1 4H5H										
5	.3125-24UNJF-3B	.685 [17.40]	.47 [11.9]	.16 [4.1]	.500 [12.70]	.315-.322 [8.00-8.18]	.625 [15.88]	.467 [11.86]	.360 [9.14]	.312 [7.92]	.686-.691 [17.42-17.55]
M8	M8X1.25 4H5H										
6	.3750-24UNJF-3B	.841 [21.36]	.50 [12.7]	.22 [5.6]	.550 [13.97]	.376-.383 [9.55-9.73]	.750 [19.05]	.591 [15.01]	.484 [12.29]	.375 [9.52]	.842-.848 [21.39-21.54]
M10	M10X1.5 4H5H										
7	.4375-20UNJF-3B	.873 [22.17]	.62 [15.7]	.25 [6.4]	.687 [17.45]	.452-.459 [11.48-11.66]	.875 [22.22]	.718 [18.24]	.611 [15.52]	.437 [11.10]	.874-.880 [22.20-22.35]
8	.5000-20UNJF-3B	.935 [23.75]	.68 [17.3]	.25 [6.4]	.750 [19.05]	.514-.523 [13.06-13.28]	1.000 [25.40]	.783 [19.89]	.674 [17.12]	.500 [12.70]	.936-.942 [23.77-23.93]

TABLE II

MATL CODE	MATERIAL	STANDARD FINISH
A	AL ALLOY 2024-T4 OR T351 PER QQ-A-225/6	ANODIZE PER MIL-A-8625 TYPE I, CLASS OPTIONAL
C	CRES 303 PER ASTM A582	PASSIVATE PER AMS-QQ-P-35
S	CARBON STEEL PER ASTM A108. ULTIMATE TENSILE STRENGTH 85 KSI MIN	CADMIUM PLATE PER QQ-P-416 TYPE II, CLASS 2

TABLE III

FINISH CODE	SPECIAL FINISH
M	SOLID FILM LUBRICANT PER AS5272, TYPE I, THREAD ONLY
S	SILVER PLATE PER AMS2410 OR AMS2411
C	CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. ON CRES INSERTS

NOTES:

- SHUR-TAB FURNISHED WITH EACH INSERT.
- REFER TO SLT600 DATA SHEET FOR SHUR-TAB AND GUIDE TOOL.
- 3. REFER TO SL600 DATA SHEET FOR INSTALLATION PROCEDURES.
- INCH THREAD PER MIL-S-8879 METRIC THREAD PER LN9163 OR FED-STD-H28
- LOCKING TORQUE:
INCH THREAD PER MIL-DTL-25027
METRIC THREAD PER NA00009
PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.
- BURRS PERMISSIBLE UNDER POTTING HOLES OR SLOTS AS LONG AS HOLES OR SLOTS ARE NOT RESTRICTED.
- MIN THREAD SHALL BE 2 DIAMETERS WHERE LENGTH PERMITS. LENGTHS SHORTER THAN 2 DIAMETERS SHALL BE THREADED THE ENTIRE LENGTH (SEE TABLE I).
- NONMETALLIC THREAD LOCK L-P-410 LOCATED NO CLOSER THAN 10 DEGREES FROM EDGE OF EITHER POTTING HOLE OR SLOT.
- MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
- MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- 11. THIS PART SERIES MEETS THE REQUIREMENTS OF NAS1833 (INCH ONLY).
- POTTING AND VENT HOLES OR SLOTS MANUFACTURER'S OPTION.
- EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375 [9.53].
- STRAIGHT OR DIAMOND ANTIROTATIONAL KNURL MANUFACTURERS OPTION.
- ALL DIAMETERS .010 [0.25] A

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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, THROUGH THREADED

SL602

SHEET 2 OF 2

REVISION J 08 SEPTEMBER 1999