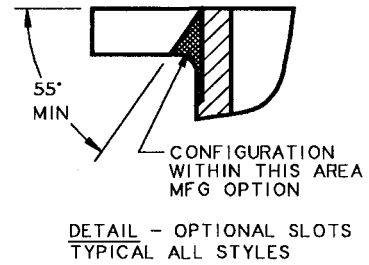
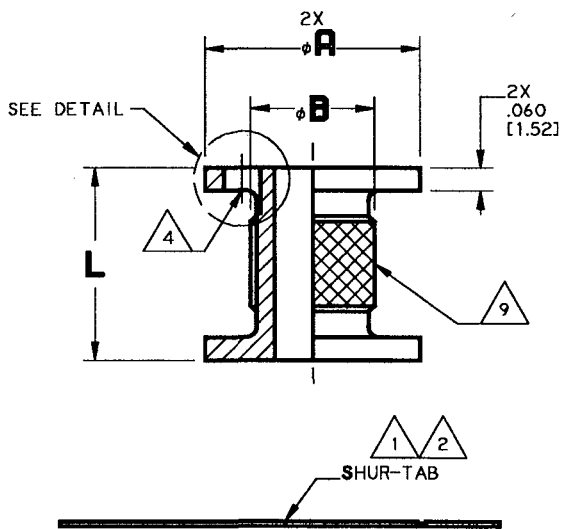
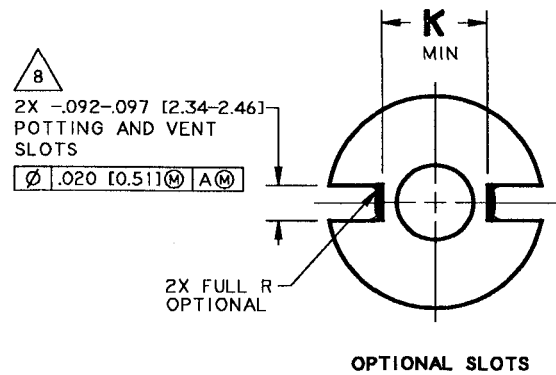
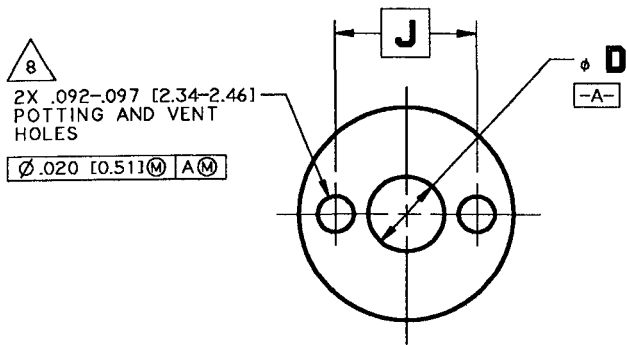




INSERTS FOR ALL TYPE SANDWICH PANELS



EXAMPLE OF PART CODING:

SL603	-3	-	500	C	S	(INCH)
SL603	M5	-	12.7	C	S	(METRIC)

SPECIAL FINISH CODE (SEE TABLE III)
 MATERIAL CODE (SEE TABLE II)
 INCH = PANEL THICKNESS IN THOUSANDTHS
 METRIC = PANEL THICKNESS IN MILLIMETERS
 SIZE CODE (SEE TABLE I)
 BASIC PART NUMBER

APPLICATION:

AN EPOXY POTTED-IN INSERT (SPACER) FOR FASTENING TO SANDWICH PANEL WITH BOLT AND NUT. INSERT PREVENTS SANDWICH COLLAPSE OR CRIPPLING OF CORE AT FASTENER POINT.

NOTES:

- 1 SHUR-TAB FURNISHED WITH EACH INSERT.
- 2 REFER TO SLT600 DATA SHEET FOR SHUR-TAB AND GUIDE TOOL.
- 3. REFER TO SLD600 DATA SHEET FOR INSTALLATION PROCEDURES.
- 4 BURRS PERMISSIBLE UNDER POTTING HOLES OR SLOTS AS LONG AS HOLES OR SLOTS ARE NOT RESTRICTED.
- 5 MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- 6. THIS PART SERIES MEETS THE REQUIREMENTS OF NAS 1834 (INCH PARTS ONLY). EXCEPT FOR SPECIAL FINISH (SEE TABLE III).
- 7. ALL DIAMETERS $\phi .010$ [0.25] (A)
- 8 POTTING AND VENT HOLES OR SLOTS MANUFACTURER'S OPTION.
- 9 STRAIGHT OR DIAMOND ANTIROTATIONAL KNURL MANUFACTURER'S OPTION.

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]
 TOLERANCES ALL SURFACES
 .XX .XXX ANGLES [X.X] [X.X.X]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSIONS IN [] ARE MILLIMETERS

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SL603

**INSERT,
THRU CLEARANCE HOLE**

SHEET 1 OF 2

REVISION J 08 OCTOBER 1999



INSERTS FOR ALL TYPE SANDWICH PANELS

TABLE I


SIZE CODE	φ A +.000 -.010 [0.00] [0.25]	φ B	φ D CLEARANCE HOLE	J BASIC	K MIN	L MIN 	INSTALLATION HOLE SIZE
06	.560 [14.22]	.30 [7.6]	.139-.145 [3.53-3.68]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
M3			.122-.127 [3.10-3.23]				
08	.560 [14.22]	.30 [7.6]	.168-.174 [4.27-4.42]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
M4			.160-.166 [4.06-4.22]				
3	.560 [14.22]	.30 [7.6]	.195-.201 [4.95-5.11]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
M5			.204-.210 [5.18-5.33]				
4	.685 [17.40]	.37 [9.4]	.256-.263 [6.50-6.68]	.467 [11.86]	.360 [9.14]	.312 [7.92]	.686-.691 [17.42-17.55]
M6			.243-.249 [6.17-6.32]				
5	.685 [17.40]	.47 [11.9]	.315-.322 [8.00-8.18]	.467 [11.86]	.360 [9.14]	.312 [7.92]	.686-.691 [17.42-17.55]
M8			.322-.329 [8.18-8.36]				
6	.841 [21.36]	.50 [12.7]	.376-.383 [9.55-9.73]	.591 [15.01]	.484 [12.29]	.375 [9.52]	.842-.847 [21.39-21.51]
M10			.405-.412 [10.29-10.46]				

TABLE II

MATL CODE	MATERIAL	STANDARD FINISH
A	AL ALLOY 2024-T4 OR T351 PER AMS-QQ-A-225/6	ANODIZE PER MIL-A-8625 TYPE I, CLASS OPTIONAL
C	CRES 303 PER ASTM A582	PASSIVATE PER QQ-P-35
S	CARBON STEEL PER ASTM A108, ULTIMATE TENSILE STRENGTH 85 KSI MINIMUM	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2
T	6AL-4V TITANIUM PER AMS 4965	CLEAN PER SHUR-LOK MPS0012

TABLE III

FINISH CODE	SPECIAL FINISH
S	SILVER PLATE PER AMS2410 OR AMS2411
C	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2. (CRES INSERTS ONLY)

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,
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SHEET **2** OF **2**

REVISION (J) 06 OCTOBER 1999