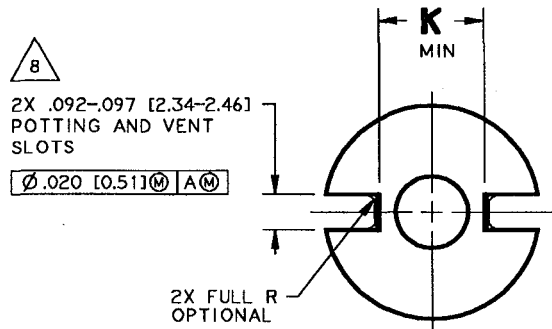
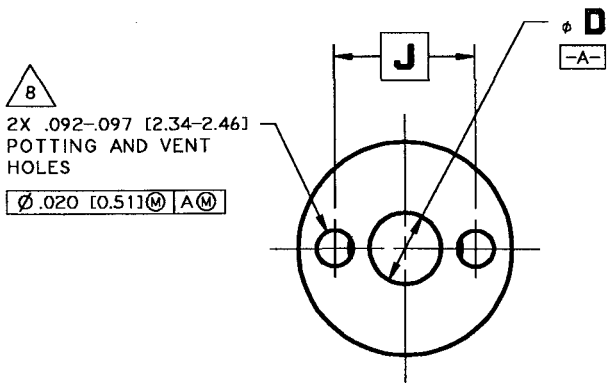
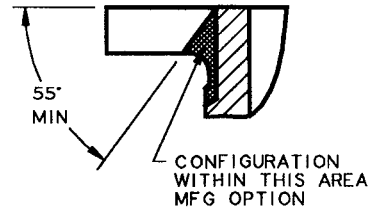
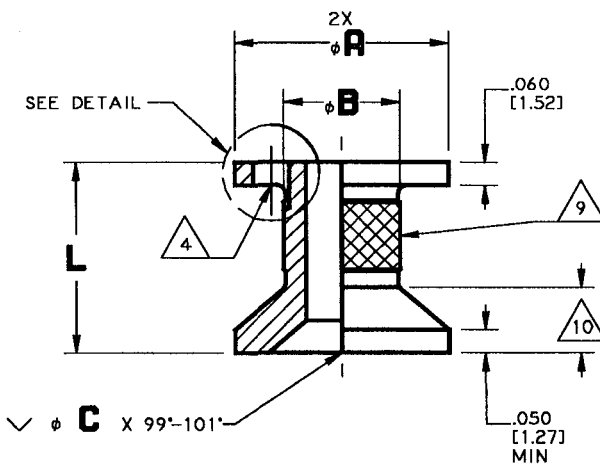




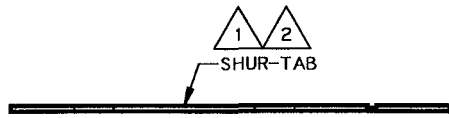
# INSERTS FOR ALL TYPE SANDWICH PANELS



OPTIONAL SLOTS

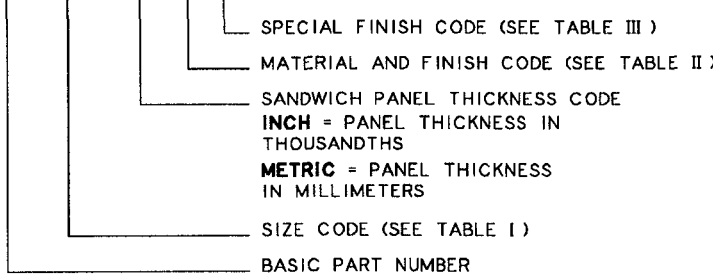


DETAIL - OPTIONAL SLOTS  
TYPICAL ALL STYLES



**EXAMPLE OF PART CODING:**

SL604 -3 - 500 C S (INCH)  
SL604 M5 - 12.7 C S (METRIC)



**APPLICATION:**

AN EPOXY POTTED-IN INSERT SIMILAR TO SL603 BUT WITH PROVISION TO RECEIVE FLUSH HEAD SCREW.

**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 PROCEDURE.
- △ 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 MEETS THE REQUIREMENTS OF NAS1834 (INCH PARTS ONLY) EXCEPT FOR SPECIAL FINISH (SEE TABLE III).
- 7. ALL DIAMETERS ∅.010 [0.25] A
- △ 8 POTTING AND VENT HOLES OR SLOTS MANUFACTURER'S OPTION.
- △ 9 STRAIGHT OR DIAMOND ANTIROTATIONAL KNURL MANUFACTURER'S OPTION.
- △ 10 EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375.

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

.XX	.XXX	ANGLES	[X.X]	[X.X X]
±.03	±.010	±2°	±[0.8]	±[0.25]

ALL SURFACES

DIMENSIONS IN [ ] ARE MILLIMETERS

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**SHUR-LOK**

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**SL604**

**INSERT,  
COUNTERSUNK CLEARANCE HOLE**


SHEET 1 OF 2

REVISION F 06 OCTOBER 1999



# INSERTS FOR ALL TYPE SANDWICH PANELS

**TABLE I**

SIZE CODE	φ A +.000 -.010 [0.00] [0.25]	φ B	φ C	φ D CLEARANCE HOLE	J BASIC	K MIN	L MIN 	INSTALLATION HOLE SIZE
<b>06</b>	.560 [14.22]	.300 [7.62]	.280 [7.11]	.139-.145 [3.53-3.68]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
<b>M3</b>			.236 [5.99]	.122-.127 [3.10-3.23]				
<b>08</b>	.560 [14.22]	.300 [7.62]	.332 [8.43]	.168-.174 [4.27-4.42]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
<b>M4</b>			.315 [8.00]	.160-.168 [4.06-4.22]				
<b>3</b>	.560 [14.22]	.300 [7.62]	.385 [9.78]	.195-.201 [4.95-5.11]	.367 [9.32]	.260 [6.60]	.250 [6.35]	.561-.566 [14.25-14.38]
<b>M5</b>			.394 [10.01]	.204-.210 [5.18-5.33]				
<b>4</b>	.685 [17.40]	.375 [9.52]	.507 [12.88]	.256-.263 [6.50-6.68]	.467 [11.86]	.360 [9.14]	.312 [7.92]	.686-.691 [17.42-17.55]
<b>M6</b>			.472 [11.99]	.243-.249 [6.17-6.32]				
<b>5</b>	.685 [17.40]	.475 [12.06]	.625 [15.88]	.315-.322 [8.00-8.18]	.467 [11.86]	.360 [9.14]	.312 [7.92]	.686-.691 [17.42-17.55]
<b>M8</b>			.630 [16.00]	.322-.329 [8.18-8.36]				
<b>6</b>	.841 [21.36]	.500 [12.70]	.750 [19.05]	.376-.383 [9.55-9.73]	.591 [15.01]	.484 [12.29]	.375 [9.52]	.842-.847 [21.39-21.51]
<b>M10</b>			.787 [19.99]	.405-.412 [10.29-10.46]				

**TABLE II**

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

**TABLE III**

FINISH CODE	SPECIAL FINISH
<b>S</b>	SILVER PLATE PER AMS2410 OR AMS2411
<b>C</b>	CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2 (CRES INSERT 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,  
COUNTERSUNK CLEARANCE HOLE**

**SL604**

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

REVISION (F) 06 OCTOBER 1999