Color-Coated Screws and Fasteners

Stake Fastener Company

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Introduction

Stake Fastener Co., an operating division of Dupree, Inc., specializes in the design and manufacture of unique and novel special application fasteners. Our first products, introduced over forty years ago, were originally designed for aerospace applications. Since then our products have spread into several other industries, including transportation, agricultural equipment, computers, medical equipment, instrumentation and climate control equipment, to name a few.

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This catalog covers our most popular standard items. All products are proprietary in nature. The designs are conceived, engineered, tooled, manufactured, assembled and shipped from our Chino, California, facility. This enables our staff, using documented procedures, to maintain close control over the entire manufacturing process.

How To Order: Orders may be placed by telephone, fax, mail, or E-mail. Call (909) 597-4889, 8:30 a.m.- 4:30 p.m. Pacific Time, Monday through Friday or fax us at (909) 597-3043. To E-mail an order, send it to sales@stakefastener.com.

Courtesy of The Boeing Company

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We offer many specialized items that were designed for very specific applications. These specialized items, as well as all of our products, are documented on individual engineering drawings. We welcome all inquiries for similar items not shown in this catalog and enjoy working with designers and engineers to propose recommendations for their particular application needs.

All procedures are documented by our Engineering Department. Our Quality Assurance Department uses state of the art equipment and follows precise calibration and inspection procedures to insure a consistent and high quality product is delivered to our customers. Our sales and engineering associates stand ready to give assistance in all matters related to the development, use and purchase of our products.

Thank you for considering Stake Fastener Co. as your supplier.

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Stock Colors

Our total line of products represents a variety of materials, all of which may be coated in the colors listed below. The coating materials have a thermosetting base for maximum resistance to wear, abrasion, and volatile solvents.

This list represents colors in stock at the time this catalog was printed. Customer requirements for new colors will be coded and added to our master color list when placed in stock. Copies of the latest master color list are available upon request.

Fed. Std. 595 colors are preferred due to broad usage; however, we do match suitable color chips in any color. For surface finish, precede the color (shown as [ ] brackets) with G (gloss), S (semi-gloss), or L (lusterless). Fed. Std. 595 lists the 10,000 series as gloss (G), 20,000 series as semi-gloss (S), and 30,000 series as lusterless (L).

STOCK COLOR LIST (SCL870115) Sheet 1 of 2

COLOR CODE	DESCRIPTION
BEIGE	
[ ]01BG	1049 BEIGE
[ ]02BG	( )3578 FED. STD. 595
[ ]04BG	870 BEIGE
[ ]05BG	7500 SAND
[ ]06BG	6009-0026 SHELL WHITE
[ ]07BG	( )2563 FED. STD. 595
[ ]08BG	( )3617 FED. STD. 595
[ ]09BG	( )3522 FED. STD. 595
[ ]11BG	8925 BEIGE
[ ]12BG	A.T.L. WHITE
[ ]13BG	7409 OFF WHITE
[ ]14BG	8813 BEIGE
[ ]15BG	( )7722 FED. STD. 595
S16BG	C.B.X. BEIGE
S17BG	23690 FED. STD. 595
[ ]18BG	7801 PEPPER DUST
S19BG	COVERT BEIGE
S20BG	LIGHT FAWN
S21BG	C.O. WHITE
[ ]22BG	A.T.T. WHITE
S23BG	7363 BEIGE
S25BG	1225 BEIGE
S26BG	HYBEIGE
G28BG	810-670 BEIGE TINT
G29BG	SAN MATEO WHEAT
S30BG	MINK TAUPE
G31BG	LIGHT IVORY
G32BG	SANDALWOOD TAN
BLACK	
[ ]01BK	( )7038 FED. STD. 595
BLUE	
[ ]01BL	( )5177 FED. STD. 595
S02BL	AF 3320 TURQUOISE
[ ]03BL	( )5526 FED. STD. 595
S04BL	25414 FED. STD. 595
S07BL	25109 FED. STD. 595
[ ]08BL	BLUE VIOLET
S10BL	25622 FED. STD. 595
S11BL	132 DARK BLUE
S12BL	25193 FED. STD. 595
S13BL	LIGHT BLUE
S14BL	MEDIUM BLUE
S15BL	25053 FED. STD. 595
S16BL	131 MEDIUM BLUE
[ ]17BL	( )5488 FED. STD. 595
S19BL	DARK BLUE VIOLET
S20BL	T-111 BLUE
S21BL	E.L. BLUE
[ ]22BL	( )115-T BLUE
S23BL	T.K. BLUE
S24BL	SKY BLUE
S25BL	7923 BLUE BLACK
S26BL	BAC50537
G27BL	15080 FED. STD. 595
L28BL	ASN-A3600-5316 LT BL
S29BL	C.O. SOFT BLUE
S30BL	CARDINAL NO. E311-BL18
G31BL	ARISTO BLUE
S32BL	367-4 LT BLUE
G33BL	COLONIAL BLUE
G34BL	MARLIN BLUE NO. A07092
S35BL	206 GRAPHITE BLUE P443991
G36BL	A00244 ROYAL BLUE
BROWN	
[ ]01BN	( )6521 FED. STD. 595
S02BN	COPPER BROWN
[ ]03BN	896 BROWN
S04BN	T.L. BROWN
[ ]05BN	( )0372 FED. STD. 595
[ ]06BN	( )0117 FED. STD. 595
S07BN	CHESTNUT BROWN
S08BN	24091 FED. STD. 595
[ ]09BN	( )0219 FED. STD. 595
S10BN	160 LIGHT BROWN
[ ]11BN	( )0140 FED. STD. 595
L12BN	8328 BROWN
S13BN	( )0122 FED. STD. 595
[ ]14BN	CARDINAL NO. 5003-1856
S15BN	PANTONE NO. 412
[ ]16BN	CHOCOLATE BROWN
[ ]17BN	( )0059 FED. STD. 595
L18BN	B/C (REF. ONLY FED. STD. 595a NO. 30140)
S19BN	NTLS. TANSHELL 2000
S20BN	20450 FED. STD. 595
L21BN	8924 DARK BROWN
S22BN	CARAMEL BROWN
[ ]23BN	( )0324 FED. STD. 595
S25BN	20206 FED. STD. 595
S26BN	80491 DEEP COPPER

STOCK COLOR LIST (SCL870115)

COLOR CODE	DESCRIPTION
GOLD	CLOVE BROWN
[ ]03GD	
GRAY	
[ ]01GY	( )6307 FED. STD. 595 (ALSO MIL-E-15090)
[ ]02GY	( )6173 FED. STD. 595
[ ]03GY	LIGHT NEUTRAL GRAY
[ ]04GY	1032 GRAY
[ ]05GY	2695069 DARK GRAY
[ ]06GY	( )6492 FED. STD. 595
[ ]07GY	( )6118 FED. STD. 595
[ ]08GY	( )6373 FED. STD. 595
[ ]09GY	( )6440 FED. STD. 595
[ ]10GY	703 GRAY
[ ]11GY	( )6559 FED. STD. 595
[ ]13GY	( )6231 FED. STD. 595
[ ]14GY	( )6357 FED. STD. 595
S15GY	26496 FED. STD. 595
[ ]16GY	705 GRAY
S17GY	26132 FED. STD. 595
[ ]18GY	14796 GLIDDEN
S19GY	26329 FED. STD. 595
[ ]20GY	( )7778 FED. STD. 595
[ ]21GY	13539 MAAS & WALDSTEIN
G24GY	( )6376 FED. STD. 595
[ ]25GY	CLOUD GRAY
[ ]26GY	704 GRAY
[ ]27GY	( )6314 FED. STD. 595
[ ]28GY	6009-0015 OLIVE BEIGE
S29GY	MOSS GRAY
[ ]30GY	LIGHT GRAY
[ ]31GY	( )6081 FED. STD. 595
S32GY	Z99AC417 SHERWIN-WILLIAMS
S33GY	T.E.I. GRAY
[ ]34GY	SEAFOAM GRAY
[ ]35GY	LONDON GRAY
[ ]36GY	FMC GRAY
[ ]37GY	CHARCOAL GRAY
[ ]38GY	SMOKE TAN
S40GY	26134 FED. STD. 595
[ ]42GY	( )6622 FED. STD. 595
S44GY	6009-0132 FRENCH GRAY
[ ]45GY	7802 GRAY
[ ]46GY	( )6270 FED. STD. 595
S47GY	6009-0131 DOVE GRAY
S48GY	FLK NO. 3
S49GY	7800 GRAY
S50GY	MEDICAL GRAY
S51GY	BROOMFIELD GRAY
[ ]52GY	COBBLESTONE GRAY
S53GY	8.25 MUNSELL GRAY
S54GY	F63TXA67 PLATINUM WHITE
S55GY	26293 FED. STD. 595
S56GY	METALLIC GRAY
S57GY	MTD03649
[ ]58GY	6009-0130 PARCHMENT WHITE
S59GY	4.2 MUNSELL GRAY
S60GY	70094 GRAY
[ ]61GY	721 GRAY
S63GY	6009-0187 GLACIER GRAY
S64GY	COOL GRAY NO. 8
[ ]65GY	7666 GRAY
S66GY	70262 GRAY
L67GY	36628 FED. STD. 595
S68GY	VREELAND GRAY
S69GY	6009-0242 QUARTZ GRAY
G72GY	AO 7403 GRAY
L73GY	290 SILVER GRAY MET.
G74GY	LT. KINGSTON GRAY
S75GY	26152 FED. STD. 595
G76GY	A00964 CHARCOAL
GREEN	
S01GN	299221 NASA BLUE
S02GN	24558 FED. STD. 595
S03GN	24664 FED. STD. 595
S04GN	24300 FED. STD. 595
[ ]07GN	121 GREEN
S08GN	24233 FED. STD. 595
S09GN	CARDINAL NO. 5042-8122
S10GN	PENINSULA GREEN
G14GN	DYNAMIC GREEN
OLIVE DRAB	
L01OD	34088 FED. STD. 595
ORANGE	
[ ]01OR	RUSSET
RED	
[ ]01RD	SWIFT RED
[ ]03RD	( )1105 FED. STD. 595
S04RD	142 RED
S08RD	T.T. RED
WHITE	
[ ]01WH	( )7875 FED. STD. 595
G02WH	TRANSLUCENT WHITE
[ ]05WH	7362 WHITE
[ ]06WH	COOL WHITE
[ ]07WH	SKY WHITE
G08WH	570-527 OFF WHITE
G09WH	570-535 MATTERHORN WHITE
G11WH	570-521 BLUESTONE WHITE
G12WH	7372 WHITE
G13WH	810-002 SNOW WHITE
G14WH	WHITE 7067
YELLOW	
[ ]01YE	( )6555 FED. STD. 595
[ ]02YE	( )3531 FED. STD. 595
[ ]03YE	( )3538 FED. STD. 595
S04YE	27855 FED. STD. 595
S05YE	23448 FED. STD. 595
S06YE	23594 FED. STD. 595

Screw / Washer Assemblies

This catalog section covers screw-washer assemblies of various configurations and materials. Stake Fastener Co. products are designed around our specialization in cold heading, screw machine work, threading, injection molding, environment-resistant and decorative coating processes.

PAN-L-SCREWS (Pages 9-16)

PAN-L-SCREWS are pan head screws with a colored head and captive nylon washer molded in matching color. High tensile steel screws are used to provide maximum resistance to screw driver damage. Colored coating material on the screw head withstands normal abrasion, chipping and solvent action. The combination of a hardened base surface and the adhesive qualities of the coating material assure retention of quality appearance after repeated use. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment. PAN-L-SCREWS, color matched to the equipment, blend with the background to eliminate distraction from the information being displayed on the panels.

A seal for moisture, low pressure gases and vapors is affected between the screw head and panel surface by compression of the nylon washer. PAN-L-SCREWS are approved for use on existing military equipment, having met moisture-proof specifications. Additionally, the compression effect of the nylon washer between the screw head and panel provides a self-locking feature to prevent vibration from loosening the screw. Additional effect is obtained by cold flow conforming to the minute surface irregularities of the screw head and the panel.

The PAN-L-SCREWS listed in this catalog printing are described with Head Type Code "PS", replacing the "SFSW" code, which was listed in earlier catalogs. Both styles offer a captive assembly. The earlier "SFSW" style washer has the captive feature located on the bottom surface, while the "PS" style has this feature located inside the washer, leaving the bottom surface of the washer free of protrusion.

"SCFW" Series Screws (Pages 17 & 18)

These are similar to PAN-L-SCREWS except that the nylon washer has a smaller diameter, similar to a flat washer. This provides the same benefits as the PAN-L-SCREW (colored head and washer, seal, and self-locking feature) but in a smaller package. A typical application for this product is attaching instruments to cockpit panels.

Flat Head Or Oval Head Screws With Captive Washers (Pages 19-23)

This series of screws offers many of the same features as PAN-L-SCREWS and is intended for applications requiring both flush mounted hardware and a low profile washer. Such applications include attaching hollow-core honeycomb colored panels in the crew station and interior of aircraft, or, attaching fabric-covered interior panels, such as those found in aircraft interiors, special-purpose vehicles, and similar applications.

Technical Notes

Screwdrivers

Our fasteners are manufactured using high quality materials with emphasis on the forming of the drive recess to meet design specifications. We urge customers to exercise care to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material. We also suggest slightly de-burring the driver tools to remove extreme sharp edges to minimize cutting of the coating materials. This can be achieved by dressing the tool bit with a wire brush as a locksmith does to a newly cut key.

PAN-L-SCREW Tightening Torque

Care must be exercised during installation of PAN-L-SCREWS to prevent over-tightening due to the nature of the nylon washer material. Over-tightening is possible and results in deformed washers. Several factors are involved with determining the proper installation torque, including PAN-L-SCREW size, clearance hole size and thread fit. In most applications we recommend tightening until snug and then tightening an additional 1/4 to 1/2 turn. The compression effect of the nylon washer between the screw head and panel will provide a self-locking feature to prevent vibration from loosening the screw in most applications.

All products are subjected to our documented quality assurance procedures and are lot-traceable.

Material Handling

Parts are carefully packaged before shipment to customers. Parts are bagged, tightly wrapped, and properly boxed to protect the color coating during shipment. Package quantities are determined by fastener size to provide proper protection. We recommend that parts remain in their original packing material until just before use. If it is necessary to re-package, then necessary care must be exercised to minimize damage from threads rubbing against color coated surfaces. The color coating material is very durable but it is a coated surface and can be damaged if proper care is not exercised.

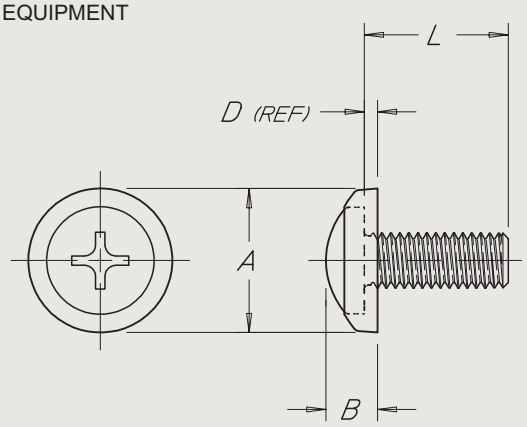
Nominal Thread Sizes

To conform to accepted industry standard practices, the nominal thread sizes for machine threads which are specified in this catalog (for non-metric items) are called out in decimal inches, instead of using the screw number or fractional diameter as was customary in the past. The following table gives the equivalent of the screw number / fractional size to the decimal size:

SCREW NUMBER or FRACTIONAL SIZE	DECIMAL SIZE
2	0.0860
4	0.1120
6	0.1380
8	0.1640
10	0.1900
12	0.2160
1/4	0.2500
5/16	0.3125
3/8	0.3750

All products are documented on specification control drawings created using two and three dimensional CAD software.

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



PART NO. EXAMPLE: **PS 10F 8 D S03YE** = PAN-L-SCREW .190-32 X 1/2 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS YELLOW PER FED. STD. 595 NO. 23538

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03												+.00 -.06		MATERIAL	COLOR CODE	DIM DATA ±.020		
	CODE	SIZE	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	7/8	1	1 1/8	1 1/4			A	B	D
PS	2C	.086-56 UNJC-3A	3	4	5	6	7	8									D STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.250	.096	.034
	4C	.112-40 UNJC-3A	3	4	5	6	7	8	9	10	11	12	14	16					.312	.117	.037
	6C	.138-32 UNJC-3A	3	4	5	6	7	8	9	10	11	12	14	16					.375	.137	.040
	8C	.164-32 UNJC-3A	3	4	5	6	7	8	9	10	11	12	14	16					.438	.158	.043
	10F	.190-32 UNJF-3A		4	5	6	7	8	9	10	11	12	14	16	18	20			.500	.179	.046
	12C	.216-24 UNJC-3A					7	8	9	10	11	12	14	16	18	20			.562	.201	.050
	14F	.250-28 UNJF-3A						8	9	10	11	12	14	16	18	20			.625	.232	.057

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and stock colors listed in the forward section of this catalog are carried in stock to assure short lead times. Lengths not listed are also available on order.
4. For color coated screw less washer, omit the letter **P** from the head type code.

SPECIFICATIONS:

1. Screws meet all requirements of NAS 600 series, including thread size .086-56 and .216-24 which are not listed as part of the NAS specification.
2. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2.
3. Threads are in conformance with MIL-S-8879 and H-28 Federal Handbook for threads.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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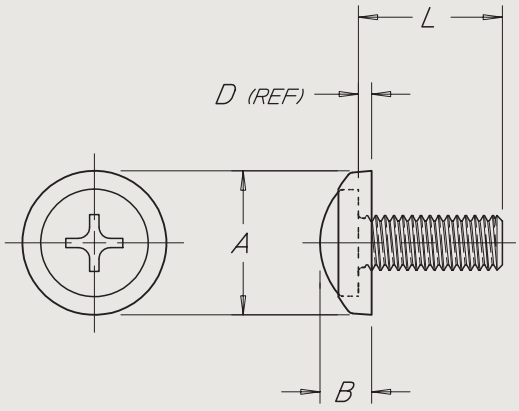
SF® DUPREE®

PAN-L-SCREW
COLORED HEAD, MACHINE THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



PART NO. EXAMPLE: **PS 10F 8 CP S06YE** = PAN-L-SCREW, .190-32 X 1/2 LONG, CORROSION RESISTANT STEEL, PHILLIPS DRIVE, SEMI-GLOSS YELLOW PER FED. STD. 595 NO. 23594

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03										+.00 -.06	MATERIAL	COLOR CODE	DIM DATA ±.020		
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	7/8	1	1 1/4			A	B	D
PS	2C	.086-56 UNC-2A	4	5	6	7	8							CP CRES PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE * POLISHED SCREW WITH NATURAL WASHER = G02NA	.250	.096	.034
	4C	.112-40 UNC-2A	4	5	6	7	8	9	10	12	14	16				.312	.117	.037
	6C	.138-32 UNC-2A	4	5	6	7	8	9	10	12	14	16				.375	.137	.040
	8C	.164-32 UNC-2A		5	6	7	8	9	10	12	14	16				.438	.158	.043
	10C	.190-24 UNC-2A			6	7	8	9	10	12	14	16	20			.500	.179	.046
	10F	.190-32 UNF-2A			6	7	8	9	10	12	14	16	20			.500	.179	.046
	14C	.250-20 UNC-2A					8	9	10	12	14	16	20			.625	.232	.057

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, which increases the basic tensile strength of the corrosion resistant steel by 25%. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and stock colors listed in the forward section of this catalog are carried in stock to assure short lead times. Lengths not listed are also available on order.
4. For color coated screw less washer, omit the letter **P** from the head type code.

SPECIFICATIONS:

1. Screws meet all requirements of MS51957 (UNC-2A) and MS51958 (UNF-2A).
2. Screws are stocked passivated per QQ-P-35.
3. Threads are in conformance with H-28 Federal Handbook for threads.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90. Natural (translucent) washer is furnished with polished head screw.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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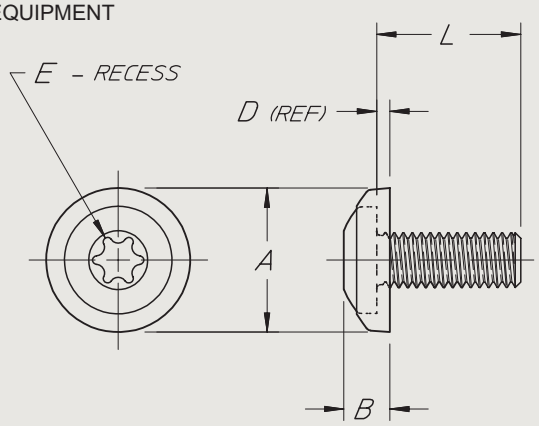
SF® DUPREE®

PAN-L-SCREW
COLORED HEAD, MACHINE THREAD, CORROSION RESISTANT STEEL

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



PART NO. EXAMPLE: **PS 10F 10 DT S11BL =** PAN-L-SCREW .190-32 X 5/8 LONG, STEEL, TORX® RECESS, SEMI-GLOSS 132 DARK BLUE

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03												+.00 -.06		MATERIAL	COLOR CODE	DIM DATA ±.020			
	CODE	SIZE	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	7/8	1	1 1/8	1 1/4			A	B	D	E
PS	2C	.086-56 UNC-2A	3	4	5	6	7	8									DT ALLOY STEEL TORX® RECESS	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.250	.096	.034	T8
	4C	.112-40 UNC-2A	3	4	5	6	7	8	9	10	11	12	14	16					.312	.117	.037	T10
	6C	.138-32 UNC-2A	3	4	5	6	7	8	9	10	11	12	14	16					.375	.137	.040	T15
	8C	.164-32 UNC-2A	3	4	5	6	7	8	9	10	11	12	14	16					.438	.158	.043	T20
	10F	.190-32 UNF-2A		4	5	6	7	8	9	10	11	12	14	16	18	20			.500	.179	.046	T25
	12C	.216-24 UNC-2A					7	8	9	10	11	12	14	16	18	20			.562	.201	.050	T27
	14C	.250-20 UNC-2A						8	9	10	11	12	14	16	18	20			.625	.232	.057	T30

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
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7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. TORX® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.
3. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. For color coated screw less washer, omit the letter **P** from the head type code.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.3, Recessed Head Machine Screws.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Threads are in conformance with H-28 Federal Handbook for threads.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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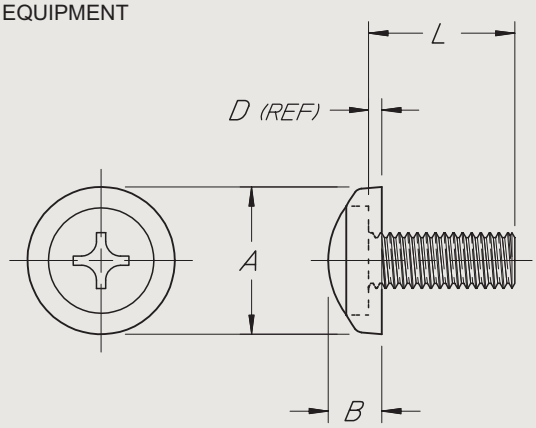
SF® DUPREE®

PAN-L-SCREW
COLORED HEAD, MACHINE THREAD, ALLOY STEEL, TORX® RECESS

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



DIMENSIONS ARE IN mm

PART NO. EXAMPLE: **MPS 5M 10 D S03GD** = METRIC PAN-L-SCREW, M5 X 0,8 X 10,0 STEEL, PHILLIPS DRIVE, SEMI-GLOSS CLOVE BROWN

HEAD TYPE	THREAD			L LENGTH						MATERIAL	COLOR CODE	DIM DATA ±0,50		
	CODE	NOMINAL DIAMETER	PITCH	TOL. ±0,3		TOL. ±0,4		TOL. ±0,5				A	B	D
				8	10	13	16	20	25					
MPS	**25M**	2,5	0,45	**8**	**10**	**13**	**16**			**CP** CRES PHILLIPS DRIVE **D** STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	7,0	2,96	0,86
	3M	3,0	0,5	**8**	**10**	**13**	**16**					8,0	3,34	0,94
	35M	3,5	0,6	**8**	**10**	**13**	**16**	**20**				9,5	3,62	1,02
	4M	4,0	0,7	**8**	**10**	**13**	**16**	**20**	**25**			11,0	4,19	1,09
	5M	5,0	0,8		**10**	**13**	**16**	**20**	**25**			13,0	4,86	1,16
	6M	6,0	1,0			**13**	**16**	**20**	**25**			15,8	6,05	1,45

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
4. For color coated screw less washer, order head type code "**MSP**".

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.7M.
2. Screws with Material Code CP are 300 series corrosion resistant steel and are stocked passivated per QQ-P-35.
3. Screws with Material Code D are alloy steel and are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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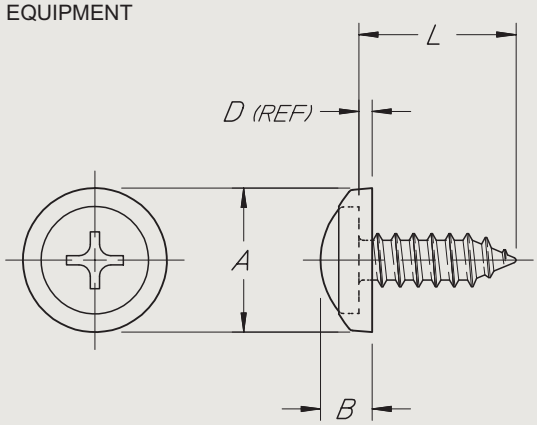
SF® DUPREE®

METRIC PAN-L-SCREW
COLORED HEAD, MACHINE THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



PART NO. EXAMPLE: **PS 10SM 10 D S10GN =** PAN-L-SCREW, SHEET METAL, 10-16 X 5/8 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS PENINSULA GREEN

HEAD TYPE	THREAD			RECOMMENDED INSTALLATION HOLE SIZE	L LENGTH TOL. ±.03							MATERIAL	COLOR CODE	DIM DATA ±.020		
	CODE	NOMINAL DIAMETER	PITCH		1/4	3/8	1/2	5/8	3/4	7/8	1			A	B	D
PS	4SM	4	24	.094	4	6	8	10	12			D STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.312	.117	.037
	6SM	6	20	.106	4	6	8	10	12	14	16			.375	.137	.040
	8SM	8	18	.125		6	8	10	12	14	16			.438	.158	.043
	10SM	10	16	.144		6	8	10	12	14	16			.500	.179	.046

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the Pan-L-Screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thicknesses. Refer to ANSI B18.6.4, Appendix VI.
4. These Pan-L-Screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
5. These Pan-L-Screws are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
6. Inventory of all sizes listed in the table and colors listed in the forward section of this catalog are carried in stock to assure prompt deliveries. Lengths not listed are also available on order.
7. For color coated screw less washer, omit the letter **P** from the head type code.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.4, Recessed Head Tapping Screws, Type AB.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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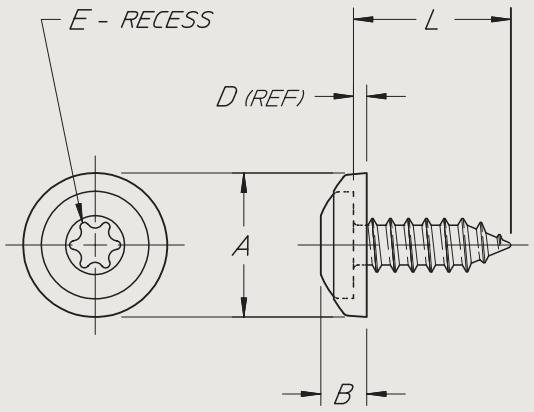
SF® DUPREE®

PAN-L-SCREW
COLORED HEAD, SHEET METAL THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



PART NO. EXAMPLE: **PS 8SM 8 DT S15BG =** PAN-L-SCREW, SHEET METAL, 8-18 X 1/2 LONG, STEEL, TORX ® RECESS, SEMI-GLOSS BEIGE PER FED. STD. 595 NO. 27722

HEAD TYPE	THREAD			RECOMMENDED INSTALLATION HOLE SIZE	L LENGTH TOL. ±.03							MATERIAL	COLOR CODE	DIM DATA ±.020			
	CODE	NOMINAL DIAMETER	PITCH		1/4	3/8	1/2	5/8	3/4	7/8	1			A	B	D	E
PS	4SM	4	24	.094	4	6	8	10	12			DT ALLOY STEEL TORX ® RECESS	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.312	.117	.037	T10
	6SM	6	20	.106	4	6	8	10	12	14	16			.375	.137	.040	T15
	8SM	8	18	.125		6	8	10	12	14	16			.438	.158	.043	T20
	10SM	10	16	.144		6	8	10	12	14	16			.500	.179	.046	T25

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the Pan-L-Screw where hole misalignment could cause problems.

NOTES:

1. TORX ® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX ® recess to meet design specification.
3. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
4. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thiskness. Refer to ANSI B18.6.4, Appendix VI.
5. These Pan-L-Screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
6. These Pan-L-Screws are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
7. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
8. For color coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.4, Recessed Head Tapping Screws, Type AB.
2. Screws are stocked zinc plated per ASTM B633, Class SC1,Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
4. Screw head coating and washer color are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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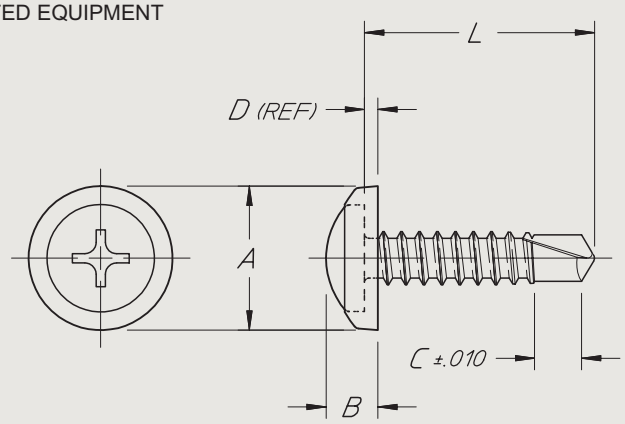
SF® DUPREE®

PAN-L-SCREW
COLORED HEAD, SHEET METAL THREAD, ALLOY STEEL, TORX ® RECESS

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT



PART NO. EXAMPLE: **DPSW 10SMB 10 D S07GN =** PAN-L-SCREW, SHEET METAL, DRILL POINT 10-16 X 5/8 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS 121 GREEN

HEAD TYPE	THREAD			L LENGTH TOL. ±.016						MATERIAL	COLOR CODE	DIM DATA ±.020			
	CODE	NOMINAL DIAMETER	PITCH	3/8	1/2	5/8	3/4	7/8	1			A	B	C	D
DPSW	**6SMB**	6	20	**6**	**8**	**10**	**12**	**14**	**16**	**D** STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.375	.137	.125	.040
	8SMB	8	18	**6**	**8**	**10**	**12**	**14**	**16**			.438	.158	.125	.043
	10SMB	10	16		**8**	**10**	**12**	**14**	**16**			.500	.179	.156	.046

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. The drill point Pan-L-Screw drills a hole, taps, and fastens in steel up to 7/32" thick in one operation. In addition, better thread engagement and a tighter fit to the workpiece is realized since the screw produces the optimum hole size.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These Pan-L-Screws are primarily intended for application in steel up to 7/32" thick or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. For color coated screw less washer, omit the letter **W** from the head type code.

SPECIFICATIONS:

1. Screws are in accordance with SAE Standard J78-1979, Self-Drilling Tapping Screws, Type BSD with Style 2 Point.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
4. Screw head coating and washer color are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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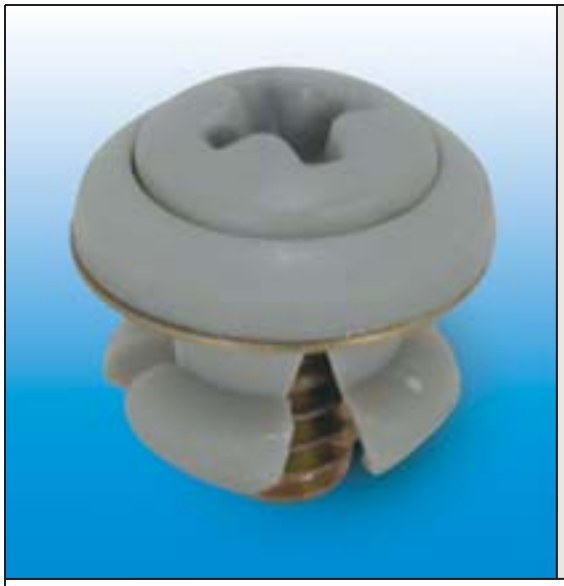
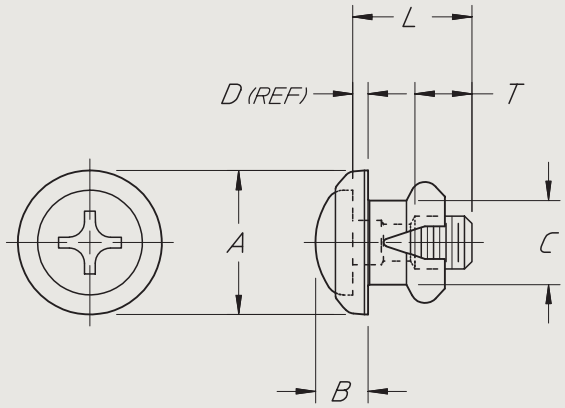
SF® DUPREE®

PAN-L-SCREW
COLORED HEAD, SHEET METAL, DRILL POINT

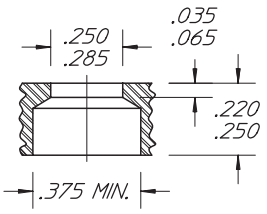


TYPICAL APPLICATION:
SECURING EDGE-LIGHTED PANELS

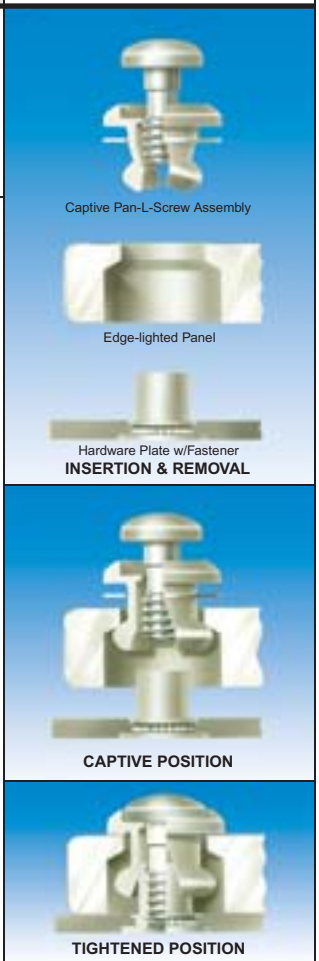


PART NO. EXAMPLE: **CPS 6C 5 D L16GY =** CAPTIVE PAN-L-SCREW, .138-32 X 5/16 LONG, STEEL, PHILLIPS DRIVE, LUSTERLESS 705 GRAY

HEAD TYPE	THREAD			L LENGTH					MATERIAL	COLOR CODE	DIM DATA ±.020			
	CODE	SIZE	T	5/16	3/8	1/2	9/16	5/8			A	B	C	D
CPS	**6C**	.138-32 UNJC-3A	.140	**5**	**6**	**8**	**9**	**10**	**D** STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.375	.130	.220	.040



MIL-P-7788 PLASTIC PANEL MOUNTING HOLE



FEATURES:

1. CPS remains captive to the panel when the panel is removed.
2. CPS is color matched with the mounting surface which eliminates distraction from the information display by blending with the background.
3. Allows up to .06 inch circular mismatch of panel clearance hole alignment with fixed threads in hardware plate.
4. The one piece screw and washer simplifies handling, installation and removal of attachment hardware.
5. May be installed and removed without use of special tools, or damage to either the host panel or the CPS.
6. Screw head is finished with a durable color coating that is resistant to abrasion and screw driver damage. This feature virtually eliminate the need for touch up painting after assembly.
7. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
8. CPS is recommended for use with Type BA or BB pressure displacement STAKE FASTENERS.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

SPECIFICATIONS:

1. Except for threaded end, screw is in accordance with NAS 600 series (material, head dimensions, and Phillips recess).
2. Screws and captive metal washer are cadmium plated per QQ-P-416, Type II (yellow), Class 2 or zinc plated per ASTM B633, Type II (yellow) Class SC2
3. Threads are in conformance with MIL-S-8879 and H-28 Federal Handbook for threads.
4. CPS is suitable for applications with temperatures up to 250˚F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.
7. Captivated metal washer is plated steel.

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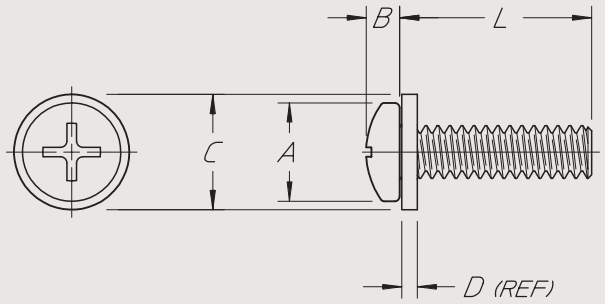
SF® DUPREE®

CAPTIVE PAN-L-SCREW
COLORED HEAD, MACHINE THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING INSTRUMENTS WITH
LIMITED SPACE TO DASH PANELS



PART NO. EXAMPLE: **SCFW 6C 12 D S04BL =** PAN HEAD SCREW w/CAPTIVE NYLON FLAT WASHER, .138-32 X 3/4 LONG, STEEL, PHILLIPS DRIVE, BLUE PER FED. STD. 595 NO. 25414

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03								+.00 -.06	MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	3/8	7/16	1/2	9/16	5/8	3/4	7/8	1	1 1/4			A	B	C	D
SCFW	2C	.086-56 UNJC-3A	6	7	8							D STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.167 .155	.062 .053	.198 .168	.039 .029
	4C	.112-40 UNJC-3A	6	7	8	9	10	12	14	16				.219 .205	.080 .070	.250 .220	.042 .032
	6C	.138-32 UNJC-3A	6	7	8	9	10	12	14	16	20			.270 .256	.097 .087	.300 .270	.045 .035

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
5. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
6. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and colors listed in the forward section of this catalog are carried in stock to assure prompt deliveries. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws meet all requirements of NAS 600 series, including thread size .086-56 which is not listed as part of the NAS specification.
2. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2.
3. Threads are in conformance with MIL-S-8879 and H-28 Federal Handbook for threads.
4. These screw/washer assemblies are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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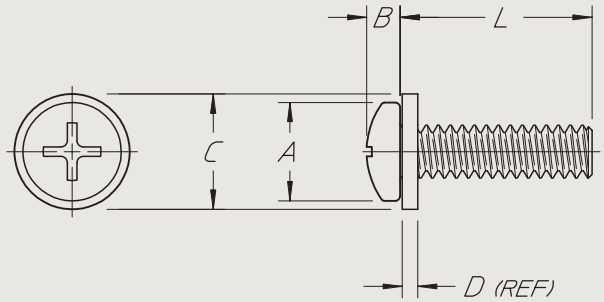
SF® DUPREE®

SCREW/FLAT WASHER ASSEMBLY
COLORED PAN HEAD w/CAPTIVE NYLON FLAT WASHER, MACHINE THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING INSTRUMENTS WITH
LIMITED SPACE TO DASH PANELS



PART NO. EXAMPLE: **SCFW 6C 12 CP S05BN =**

PAN HEAD SCREW w/CAPTIVE NYLON WASHER,
.138-32 X 3/4 LONG, COR. RES. STEEL, PHILLIPS DRIVE,
SEMI-GLOSS BROWN PER FED. STD. 595 NO. 20372

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03										MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	7/8	1			A	B	C	D
SCFW	**2C**	.086-56 UNC-2A	**4**	**5**	**6**	**7**	**8**						**CP** CRES PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.167 .155	.062 .053	.198 .168	.039 .029
	4C	.112-40 UNC-2A	**4**	**5**	**6**	**7**	**8**	**9**	**10**	**12**	**14**	**16**			.219 .205	.080 .070	.250 .220	.042 .032
	6C	.138-32 UNC-2A	**4**	**5**	**6**	**7**	**8**	**9**	**10**	**12**	**14**	**16**			.270 .256	.097 .087	.300 .270	.045 .035

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the corrosion resistant steel by 25%. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
5. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
6. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and colors listed in the forward section of this catalog are carried in stock to assure prompt deliveries. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws meet all requirements of MS51957.
2. Screws are stocked passivated per QQ-P-35.
3. Threads are in conformance with H-28 Federal Handbook for threads.
4. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90. Natural (translucent) washer is furnished with polished head screw.
5. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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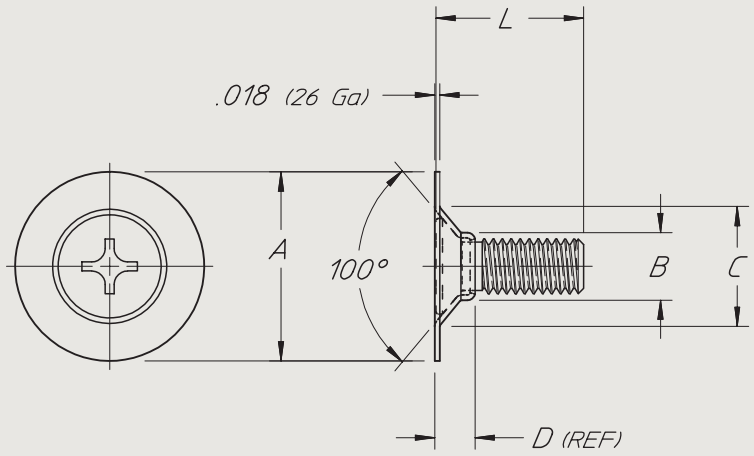
SF® DUPREE®

SCREW/FLAT WASHER ASSEMBLY
COLORED PAN HEAD w/CAPTIVE NYLON FLAT WASHER, MACHINE THREAD, CORROSION RESISTANT STEEL

TYPICAL APPLICATION:
SECURING COMPOSITE PANELS



PART NO. EXAMPLE: **FCM 10F 10 D S01RD =** 100° FLAT HEAD SCREW w/CAPTIVE METAL WASHER, .190-32 X 5/8 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS SWIFT RED

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIM DATA ±.02			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A	B	C	D
FCM	6C	.138-32 UNC-3A	4	5	6	7	8	10	12	14	16	D STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.50	.18	.30	.13
	8C	.164-32 UNC-3A	4	5	6	7	8	10	12	14	16			.56	.21	.36	.14
	10F	.190-32 UNF-3A	4	5	6	7	8	10	12	14	16			.66	.23	.41	.15

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The metal washer provides a low profile bearing surface to protect the finished surface of panels and equipment.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screw material is heat treated alloy steel. Washer material is low carbon steel.
2. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2.
3. Threads are in conformance with MIL-S-7742 and H-28 Federal Handbook for threads.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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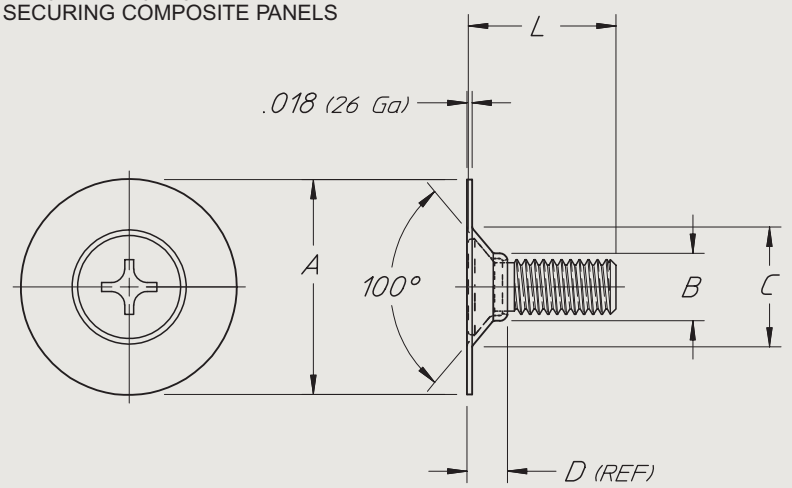
SF® DUPREE®

SCREW
COLORED 100° FLAT HEAD
w/ CAPTIVE METAL WASHER,
MACHINE THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING COMPOSITE PANELS



PART NO. EXAMPLE: **FCM 10F 14 CP S13BN =**

100° FLAT HEAD SCREW w/CAPTIVE METAL WASHER, .190-32 X 7/8 LONG, COR. RES. STEEL, PHILLIPS DRIVE, SEMI-GLOSS BROWN PER FED. STD. 595 NO. 20122

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIM DATA ±.02			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A	B	C	D
FCM	**10F**	.190-32 UNF-2A	**4**	**5**	**6**	**7**	**8**	**10**	**12**	**14**	**16**	**CP** CRES PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.75	.23	.41	.15

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The metal washer provides a low profile bearing surface to protect the finished surface of panels and equipment.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screw and washer material is 300 series corrosion resistant steel (Cres).
2. Screws and washers are passivated per QQ-P-35.
3. Threads are in conformance with H-28 Federal Handbook for threads.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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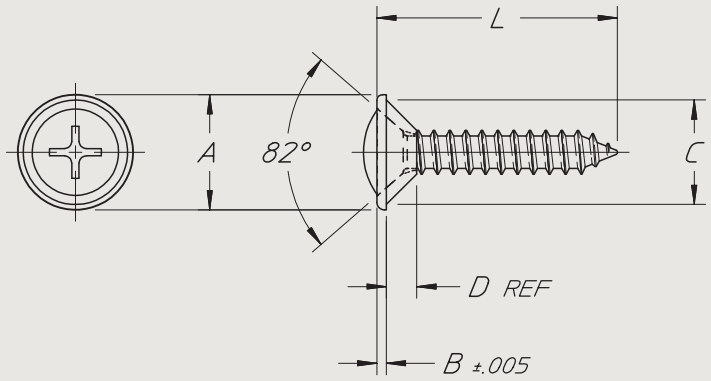
SCREW
COLORED 100° FLAT HEAD
w/CAPTIVE LARGE O.D. METAL WASHER,
MACHINE THREAD, CRES

TYPICAL APPLICATION:
SECURING UPHOLSTERY-COVERED PANELS



PART NO. EXAMPLE: **OHCW 4SM 10 D S01YE** = 82° OVAL HEAD SCREW w/CAPTIVE NYLON WASHER, SHEET METAL, 4-24 X 5/8 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS YELLOW PER FED. STD. 595 NO. 26555

HEAD TYPE	THREAD			L LENGTH TOL.±.03						MATERIAL	COLOR CODE	DIM DATA ±.020			
	CODE	NOMINAL DIAMETER	PITCH	1/4	3/8	1/2	5/8	3/4	1			A	B	C	D
OHCW	**4SM**	4	24	**4**	**6**	**8**	**10**	**12**	**16**	**D** STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.300	.025	.272	.089

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These screw assemblies are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
4. These screw assemblies are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
5. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.4, Recessed Head Tapping Screws, Type AB.
2. Screws are stocked zinc plated per ASTM B633-85, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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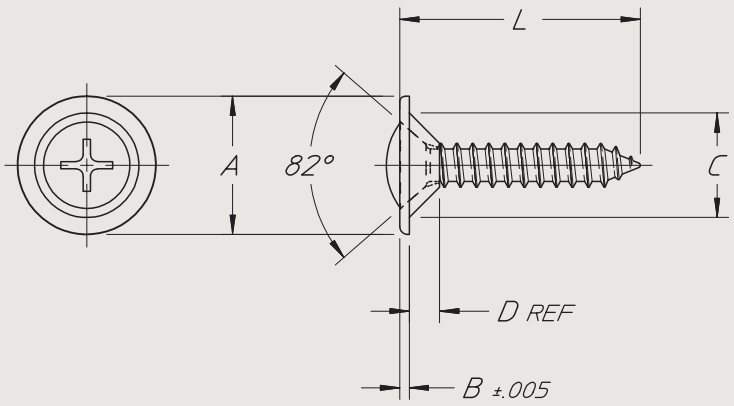
SF® DUPREE®

UPHOLSTERY SCREW
COLORED 82° OVAL HEAD
w/CAPTIVE NYLON WASHER,
SHEET METAL THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING UPHOLSTERY-COVERED PANELS



PART NO. EXAMPLE: **OHCWL 4SM 6 D S04GY =** 82° OVAL HEAD SCREW w/CAPTIVE LARGE O.D. NYLON WASHER, SHEET METAL, 4-24 X 3/8 LONG, STEEL, PHILLIPS DRIVE,

HEAD TYPE	THREAD			L LENGTH TOL.±.03						MATERIAL	COLOR CODE	DIM DATA ±.020			
	CODE	NOMINAL DIAMETER	PITCH	1/4	3/8	1/2	5/8	3/4	1			A	B	C	D
OHCWL	**4SM**	4	24	**4**	**6**	**8**	**10**	**12**	**16**	**D** STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.360	.025	.272	.089

FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These screw assemblies are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
4. These screw assemblies are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
5. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.4, Recessed Head Tapping Screws, Type AB.
2. Screws are stocked zinc plated per ASTM B633-85, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D 4066-90.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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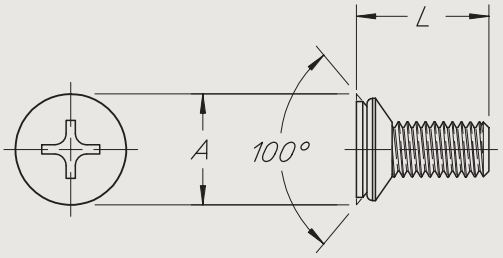
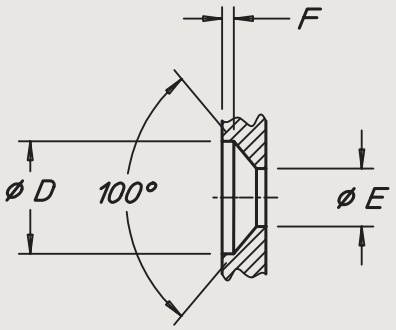
UPHOLSTERY SCREW
COLORED 82° OVAL HEAD
w/CAPTIVE LARGE O.D. NYLON WASHER,
SHEET METAL THREAD, ALLOY STEEL

TYPICAL APPLICATION:
SECURING PANELS WHERE A LIQUID-TIGHT SEAL IS DESIRED.



RECOMMENDED CLEARANCE HOLE



PART NO. EXAMPLE: **FHW 10F 7 D S34GY** = 100° FLAT HEAD SCREW w/CAPTIVE NYLON SEALING WASHER, .190-32 X 7/16 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS SEAFOAM GRAY

HEAD TYPE	THREAD (SEE SPECIFICATION FOR CLASS OF THREAD FIT)		L LENGTH TOLERANCE +.00 -.03							MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	3/8	7/16	1/2	5/8	3/4	7/8	1			A SHARP	D	E	F
FHW	**10F**	.190-32 UNF	**6**	**7**	**8**	**10**	**12**	**14**	**16**	**CP** CRES PHILLIPS DRIVE **D** STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.385	.391	.201	.040

FEATURES:

1. Screws are furnished with captive nylon sealing washer and when installed in recommended clearance hole this assembly provides a liquid-tight seal.
2. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
3. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.
4. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws with material code **CP** meet all requirements of MS24693. Material is 300 series corrosion resistant steel. Screws are passivated per QQ-P-35. Screws of this material have a class 2A thread fit per FED-STD-H28/2.
2. Screws with material code **D** meet all requirements of NAS514. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2. Screws of this material have a class 3A thread fit per MIL-S-8879.
3. Washer color matches screw head color and is achieved by molding with pigmented nylon per ASTM D4066.
4. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.
5. For an assembly with uncoated screw and natural colored sealing washer, order color code **N02NA**.

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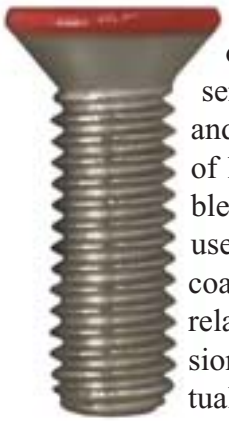
SEALING SCREW
COLORED 100° FLAT HEAD,
w/CAPTIVE NYLON WASHER
MACHINE THREAD, ALLOY STEEL

Color-Coated Screws



This catalog section covers industry standard fasteners with color-coated heads. This series of screws, including flat head, oval head and button head, combine the same features of high tensile strength material with the durable thermosetting coating material and colors as used for PAN-L-SCREWS. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.

Photo courtesy of Luis Rosa

Photo courtesy of Justin Cederholm

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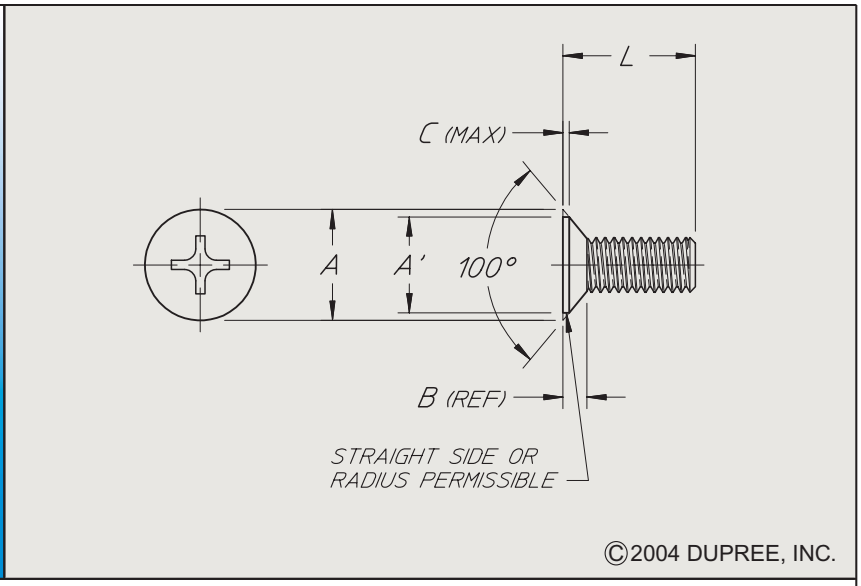

PART NO. EXAMPLE: **FH 10F 10 D S03GN** = 100° FLAT HEAD SCREW, .190-32 X 5/8 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS GREEN PER FED. STD. 595 NO. 24664

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A SHARP	A' ABS. MIN.	B	C
FH	4C	.112-40 UNJC-3A	4	5	6	7	8	10	12	14	16	D STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.225	.183	.045	.012
	6C	.138-32 UNJC-3A	4	5	6	7	8	10	12	14	16			.279	.233	.057	.014
	8C	.164-32 UNJC-3A	4	5	6	7	8	10	12	14	16			.332	.282	.068	.015
	10F	.190-32 UNJF-3A	4	5	6	7	8	10	12	14	16			.385	.332	.080	.016

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws meet all requirements of NAS514. Screws are stocked cadmium plated per QQ-P-416, Type II. Class 2.
2. Threads are in conformance with MIL-S-8879 and H28 Federal Handbook for threads.
3. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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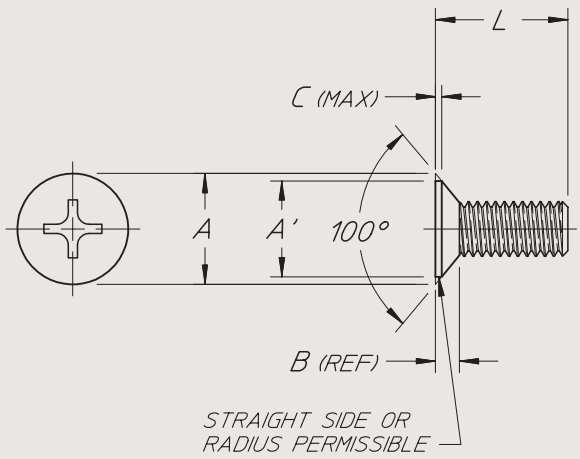
SF® DUPREE®

SCREW
COLORED 100° FLAT HEAD,
MACHINE THREAD, ALLOY STEEL



PART NO. EXAMPLE: **FH 10F 10 CP G27BL** = 100° FLAT HEAD SCREW .190-32 X 5/8 LONG, CORROSION RESISTANT STEEL, PHILLIPS DRIVE, GLOSS BLUE PER FED. STD. 595 NO. 15080

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A SHARP	A' ABS. MIN.	B	C
FH	4C	.112-40 UNC-2A	4	5	6	7	8	10	12	14	16	CP CRES PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.225	.191	.045	.012
	6C	.138-32 UNC-2A	4	5	6	7	8	10	12	14	16			.279	.238	.057	.014
	8C	.164-32 UNC-2A	4	5	6	7	8	10	12	14	16			.332	.285	.068	.015
	10F	.190-32 UNF-2A	4	5	6	7	8	10	12	14	16			.385	.333	.080	.016

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws meet all requirements of MS24693. Material is 300 series corrosion resistant steel. Screws are passivated per QQ-P-35.
2. Threads are in conformance with H28 Federal Handbook for threads.
3. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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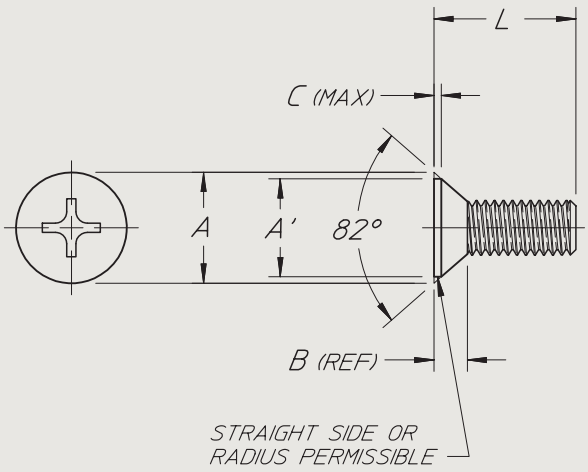
SF® DUPREE®

SCREW
COLORED 100° FLAT HEAD,
MACHINE THREAD,
CORROSION RESISTANT STEEL



PART NO. EXAMPLE: **FHC 10F 8 CP S01RD =** 82° FLAT HEAD SCREW .190-32 X 1/2 LONG, CORROSION RESISTANT STEEL, PHILLIPS DRIVE, SEMI-GLOSS SWIFT RED

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A SHARP	A' ABS. MIN.	B	C
FHC	4C	.112-40 UNC-2A	4	5	6	7	8	10	12	14	16	CP CRES PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.225	.195	.067	.017
	6C	.138-32 UNC-2A	4	5	6	7	8	10	12	14	16			.279	.244	.083	.021
	8C	.164-32 UNC-2A	4	5	6	7	8	10	12	14	16			.332	.292	.100	.024
	10F	.190-32 UNF-2A	4	5	6	7	8	10	12	14	16			.385	.340	.116	.028

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws meet all requirements of MS51959 (UNC-2A) and MS51960 (UNF-2A). Screws are passivated per QQ-P-35.
2. Threads are in conformance with H28 Federal Handbook for threads.
3. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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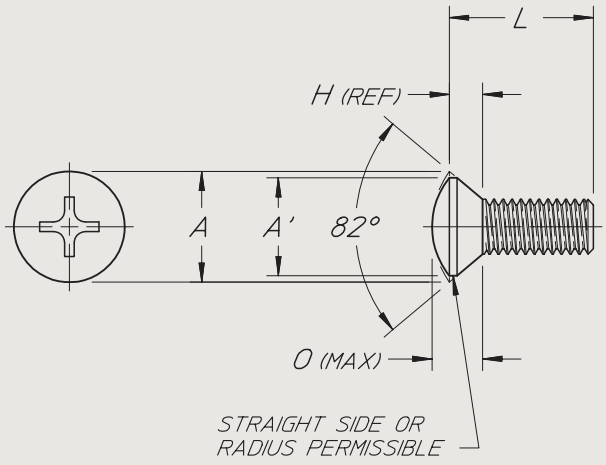
SCREW
COLORED 82° FLAT HEAD,
MACHINE THREAD,
CORROSION RESISTANT STEEL



PART NO. EXAMPLE: **OHC 8C 10 CP S13BL** = 82° OVAL HEAD SCREW .164-32 X 5/8 LONG, CORROSION RESISTANT STEEL, PHILLIPS DRIVE, SEMI-GLOSS LIGHT BLUE

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIMENSIONAL DATA			
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A SHARP	A' ABS. MIN.	H REF.	O MAX.
OHC	4C	.112-40 UNC-2A	4	5	6	7	8	10	12	14	16	CP CRES PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.225	.195	.067	.104
	6C	.138-32 UNC-2A	4	5	6	7	8	10	12	14	16			.279	.244	.083	.128
	8C	.164-32 UNC-2A		5	6	7	8	10	12	14	16	D STEEL PHILLIPS DRIVE		.332	.292	.100	.152
	10F	.190-32 UNF-2A			6	7	8	10	12	14	16			.385	.340	.116	.176

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.3, Recessed Head Machine Screws.
2. Screws with Material Code CP are 300 series corrosion resistant steel and are stocked passivated per QQ-P-35.
3. Screws with Material Code D are alloy steel and are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.
4. Threads are in conformance with H28 Federal Handbook for threads.
5. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer

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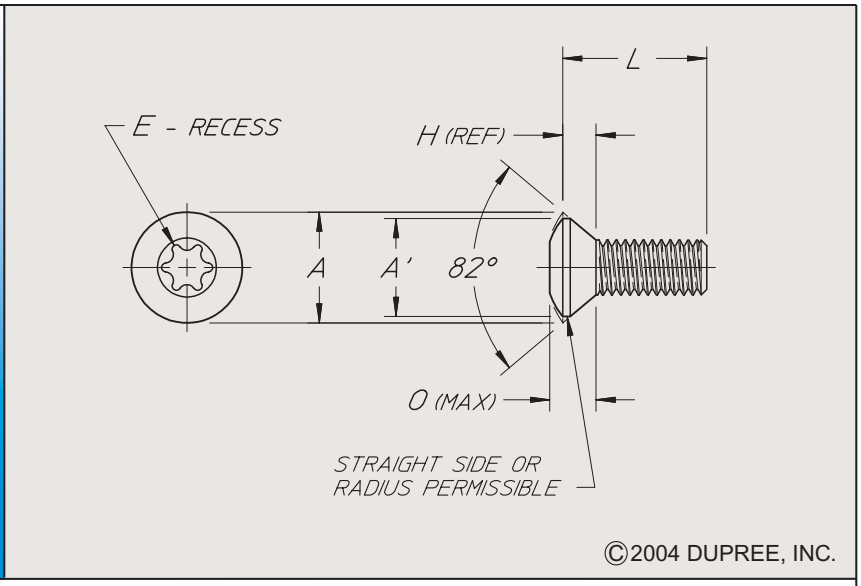
SCREW
COLORED 82° OVAL HEAD, MACHINE THREAD, ALLOY STEEL, CORROSION RESISTANT STEEL



PART NO. EXAMPLE: **OHC 6C 8 DT S68GY =** 82° OVAL HEAD SCREW .138-32 X 1/2 LONG, STEEL, TORX® RECESS, SEMI-GLOSS VREELAND GRAY

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03									MATERIAL	COLOR CODE	DIMENSIONAL DATA				
	CODE	SIZE	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1			A SHARP	A' ABS. MIN.	E REF.	H	O MAX.
OHC	6C	.138-32 UNC-2A	4	5	6	7	8	10	12	14	16	DT ALLOY STEEL TORX® RECESS	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.279	.244	T15	.083	.128
	8C	.164-32 UNC-2A	4	5	6	7	8	10	12	14	16			.332	.292	T20	.100	.152
	10F	.190-32 UNF-2A		5	6	7	8	10	12	14	16			.385	.340	T25	.116	.176
	14C	.250-20 UNF-2A			6	7	8	10	12	14	16			.507	.452	T30	.153	.232

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. TORX® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.
3. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.3, Recessed Head Machine Screws.
2. Screws are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.
3. Threads are in conformance with H28 Federal Handbook for threads.
4. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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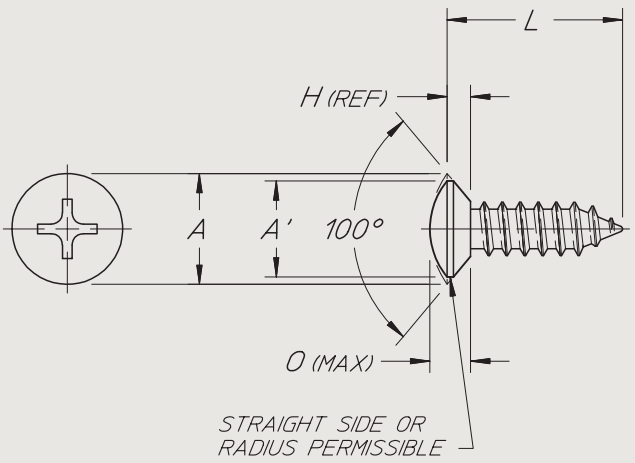
SF® DUPREE®

SCREW
COLORED 82° OVAL HEAD,
TORX® RECESS, MACHINE THREAD,
ALLOY STEEL



PART NO. EXAMPLE: **OH 6SM 12 D S04RD =**

100° OVAL HEAD SHEET METAL SCREW, 6-20 X 3/4 LONG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS 142 RED

HEAD TYPE	THREAD			RECOMMENDED INSTALLATION HOLE SIZE	L LENGTH TOL. ±.03							MATERIAL	COLOR CODE	HEAD DATA			
	CODE	NOMINAL DIAMETER	PITCH		1/4	3/8	1/2	5/8	3/4	7/8	1			A SHARP	A' ABS. MIN.	H REF.	O MAX.
OH	6SM	6	20	.104	4	6	8	10	12	14	16	D STEEL PHILLIPS DRIVE	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.279	.238	.060	.105
	8SM	8	18	.125		6	8	10	12	14	16			.332	.285	.072	.124
	10SM	10	16	.136		6	8	10	12	14	16			.385	.333	.083	.143

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. Screw heads are formed by cold forging followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thicknesses. Refer to ANSI B18.6.4, Appendix VI.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. These screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.4, Recessed Head Tapping Screws, Type AB thread.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer

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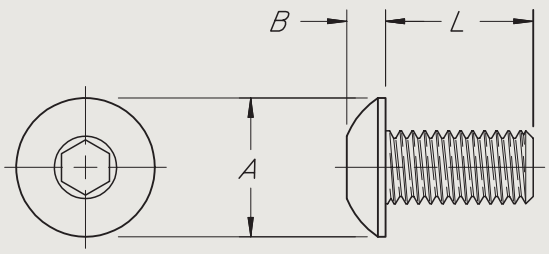
SCREW
COLORED 100° OVAL HEAD,
SHEET METAL THREAD, ALLOY STEEL



PART NO. EXAMPLE: **BHCS 10F 10 D S32BL =** BUTTON HEAD SCREW, 10-32 X 5/8 LONG, STEEL, HEXAGON SOCKET, SEMI-GLOSS 367-4 LIGHT BLUE

HEAD TYPE	THREAD		L LENGTH TOLERANCE +.00 -.03								MATERIAL	COLOR CODE	HEAD DATA	
	CODE	SIZE	3/16	1/4	3/8	1/2	5/8	3/4	7/8	1			A MAX.	B MAX.
BHCS	2C	.086-56 UNRC-3A	3	4	6	8					C CRES HEXAGON SOCKET D STEEL HEXAGON SOCKET	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.164	.046
	4C	.112-40 UNRC-3A	3	4	6	8							.213	.059
	6C	.138-32 UNRC-3A	3	4	6	8	10						.262	.073
	8C	.164-32 UNRC-3A	3	4	6	8	10	12					.312	.087
	10F	.190-32 UNRF-3A		4	6	8	10	12	14	16			.361	.101
	14C	.250-20 UNRC-3A			6	8	10	12	14	16			.437	.132
	38C	.375-16 UNRC-3A			6	8	10	12	14	16			.656	.199

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the hexagon socket to meet design specification.
2. Care should be exercised to assure that the screw driver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.3, Socket Button Head Cap Screws.
2. Screws with Material Code C are 300 series corrosion resistant steel and are stocked passivated per QQ-P-35.
3. Screws with Material Code D are alloy steel and are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.
4. Threads are in conformance with H-28 Federal Handbook for threads.
5. Coating colors are matched to customer requirements. We recommend selection from Fed. Std. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

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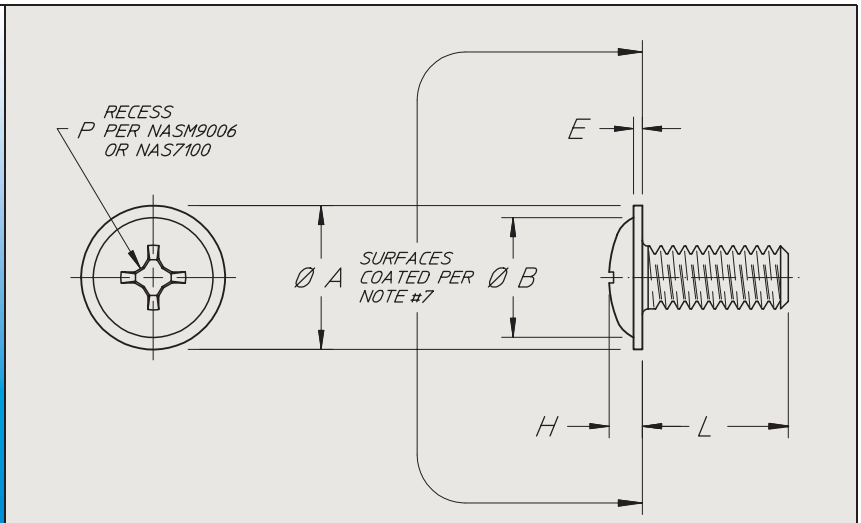
SCREW
COLORED BUTTON HEAD,
MACHINE THREAD,
CORROSION RESISTANT & ALLOY STEEL



PART NO. EXAMPLE: **WHS 10F 14 TPK L11BG** = WASHER HEAD SCREW, .190-32 X 7/8 LONG, TITANIUM, CROSS RECESS, ALUMINUM COATED, LUSTERLESS 8925 BEIGE

HEAD TYPE	THREAD		L LENGTH	MATERIAL	COLOR CODE	DIMENSIONAL DATA				
	CODE	SIZE				A ±.010	B ±.010	E +.005 -.000	H ±.005	P RECESS SIZE
WHS	8C	.164-32 UNJC-3A	SEE NOTE NO. 2 Length tolerance is: +.00/-.03 for 3 < L ≤ 16 +.00/-.06 for 16 < L ≤ 32 +.00/-.09 for 32 < L	TPK TITANIUM CROSS RECESS ALUMINUM COATED	SEE FORWARD SECTION FOR STOCK COLOR & CODE	.375	.312	.023	.087	2
	10F	.190-32 UNJF-3A				.438	.375	.025	.094	2
	14F	.250-28 UNJF-3A				.500	.428	.028	.125	3

FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
2. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.

NOTES:

1. Screws are in accordance with Boeing Part Standard BACS12FA; refer to that standard for details not listed herein.
2. Length code designates nominal length ”L“ in .0625-inch Increments.
3. Threads per AS8879 or MIL-S-8879 except major diameter per ”TD“. Incomplete threads adjacent to grip and chamfer shall conform to BPS-F-69. Incomplete threads shall not touch the radius. Screws over 2 inches in length shall have 1.75 Minimum thread length. Threads with a major diameter per ”D“ may be furnished from suppliers stock until 01-MAR-01. Boeing and Boeing subcontractor stocks with diameter ”D“ may be used until depleted.
4. End shall be flat and chamfered per BPS-F-69.
5. Material is 6AL-4V titanium alloy per AMS 4928 or AMS 4967.
6. Preliminary finish: material/finish code ”TPK“ designates screws have aluminum pigmented coating per BMS10-85, type I. Parts with this finish were previously marked with black dye or paint on the thread end; requirement was removed from BACS12FA at rev ‘AF’ 16-OCT-2003. Parts marked with black dye or paint on thread end, manufactured before 01-JAN-04, may be procured and used until inventory is depleted.
7. Head surfaces indicated are color coated with a thermosetting epoxy material, color as specified in color code (last five characters of part no.) No color code denotes parts without color coating. Part dimensions apply prior to color coating.

Rev March 2004

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WASHER HEAD SCREW
COLORED HEAD, MACHINE THREAD, TITANIUM

Pressure Displacement Stake Fasteners

This catalog section covers pressure displacement STAKE FASTENERS. These fasteners are designed for use in applications where relatively strong threads are needed in a relatively soft mounting material. These pressure displacement fasteners must be installed into sheet material that is ductile and capable of forming into the knurled recess of the fastener without stress cracking, such as 2024-T3 or 6061-T6 aluminum. The principle which makes this product unique is the method of installation. The large flange is coined, or pressed, into the sheet until it is flush with the surface. The volume of displaced material is calculated to flow into and fill the void area around the knurled fastener undercut as the fastener is driven into the sheet. The effect of this principle is that deformation or rivet action occurs to the sheet, not to the fastener. Thus, the "Basic" fastener series listed in this catalog may be installed into a relatively soft metal, providing a relatively hard threaded hole, which is flush with the sheet on both surfaces.

The type "BA" and "BB" series fasteners also provide the grip area flush with both surfaces of the sheet after installation. However, in order to provide a self-locking thread feature, a thin-walled appendage is added which includes a spring action deformed thread. The "BA" series is used in the same manner of a conventional clinch nut with the screw entering through the grip area.

The "BB" series is intended for housing the appendage in a thick sheet, such as an edge lighted panel, with the screw entering through the appendage. In both instances the self-locking feature is located on the appendage near the grip area, eliminating the need for the screw length to extend through and out of the fastener. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

Installation Guidelines

The type “Basic”, “BA”, and “BB” fasteners are designed to be installed using standard presses (mechanical, hydraulic, or impact) commonly found in a shop environment. The tooling required is simply a punch and an anvil which can be installed in the press to be used. For the type “Basic” fastener, both the punch and anvil are flat. For the type “BA” and “BB” fasteners, a clearance hole (F & G dimensions) is required in the punch for the appendage. See Table 1 below for recommended punch clearance hole size. Due to the wide variety of press equipment available and the simplicity of the punch and anvil required, it is intended that customers fabricate their own punch and anvil to fit their particular equipment and applications.

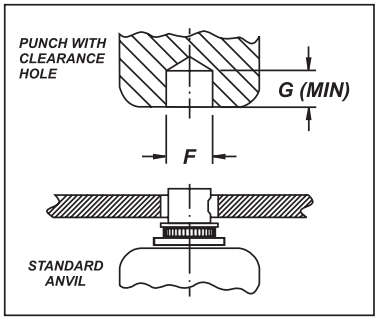


Table 1- RECCOMENDED ANVIL CLEARANCE HOLES FOR TYPE ‘BA’ AND TYPE ‘BB’ FASTENERS

THREAD		APP DIA	TOOLING CLEARANCE HOLE		
CODE	SIZE	⌀D	⌀F		G
2C	.086-56UNC-3B	.110	.1200	#31	.20
4C	.112-40UNC-3B	.139	.1470	#26	.23
6C	.138-32UNC-3B	.165	.1719	11/64	.26
8C	.164-32UNC-3B	.204	.2090	#4	.26
10F	.190-32UNF-3B	.229	.2344	15/64	.29
14F	.250-28UNF-3B	.300	.3125	5/16	.29

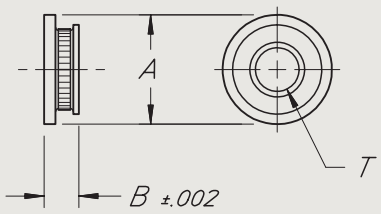
To install the fastener, a mounting hole must be punched or machined into the sheet per dimension ‘E’, shown on the part specifications. It is not necessary nor reccomended that the mounting hole be deburred prior to installation Place the sheet material with the mounting hole centered over the flat anvil. Locate the fastener with the small flange diameter towards the sheet (see Figure, INSERT) and centered over the mounting hole. Lower the punch over the fastener and locate the fastener appendage into the clearance hole for type ‘BA’ and ‘BB’ fasteners (see Figure, STAKE). Apply pressure between the punch and anvil to force the fastener into the sheet until the grip areas are flush with both surfaces of the sheet (see Figure, INSTALLED). This staking process should be performed in one continuous motion for best results. The amount of pressure to be applied will vary with fastener size, sheet thickness, and type of material used.

Installation of a type “BA” fastener

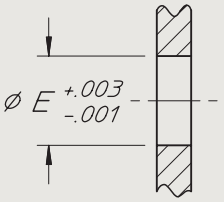
INSERT

STAKE

INSTALLED



PANEL MOUNTING HOLE



PART NO. EXAMPLE: **SF 6G 6C D**

HEAD TYPE	B THICKNESS									T THREAD		A	E	MATERIAL
	.04	.05	.06	.08	.09	.10	.12	.15	.18	CODE	SIZE	MAJ. DIA.	MTG. HOLE DIA.	
SF	**4E**	**5E**	**6E**							**2C**	.086-56 UNC-3B	.219	.156	**D** HIGH CARBON STEEL (SEE NOTE 1)
	4F	**5F**	**6F**	**8F**	**9F**	**10F**	**12F**			**4C**	.112-40 UNC-3B	.250	.188	
			6G	**8G**	**9G**	**10G**	**12G**			**6C**	.138-32 UNC-3B	.281	.219	
			6H	**8H**	**9H**	**10H**	**12H**	**15H**		**8C**	.164-32 UNC-3B	.312	.250	
			6J	**8J**	**9J**	**10J**	**12J**	**15J**	**18J**	**10F**	.190-32 UNF-3B	.375	.312	
				8L	**9L**	**10L**	**12L**	**15L**	**18L**	**14F**	.250-28 UNF-3B	.438	.375	


INSERT


STAKE


INSTALLED

FEATURES:

1. The pressure displacement principle provides a fastener made of a relatively strong material installed into a relatively soft mounting material.
2. The basic fastener provides a steel threaded hole in a relatively soft material, flush with both surfaces of the mounting sheet.

NOTES:

1. High carbon steel (Material Code **D**) parts are stock items. Parts made of type 303 corrosion resistant steel (MIL-S-7720) are available, on order, by using Material Code **C**.
2. Parts are installed by pressure displacement principle as illustrated by figures. Pressure is applied between two anvils which may be installed in any suitable equipment, such as hydraulic or impact punch presses. Pressure to be applied will vary with fastener size, sheet thickness and type of material used.
3. Sheet material must be ductile and capable of forming into knurled recess of fastener without stress cracking.
4. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

SPECIFICATIONS:

1. Steel fasteners (Material Code **D**) are made of chrome molybdenum alloy per AISI4140 (or equal).
2. Steel fasteners (Material Code **D**) are cadmium plated per QQ-P-416, Type II, Class 2.
3. Corrosion resistant steel fasteners (Material Code **C**) are passivated per QQ-P-35.

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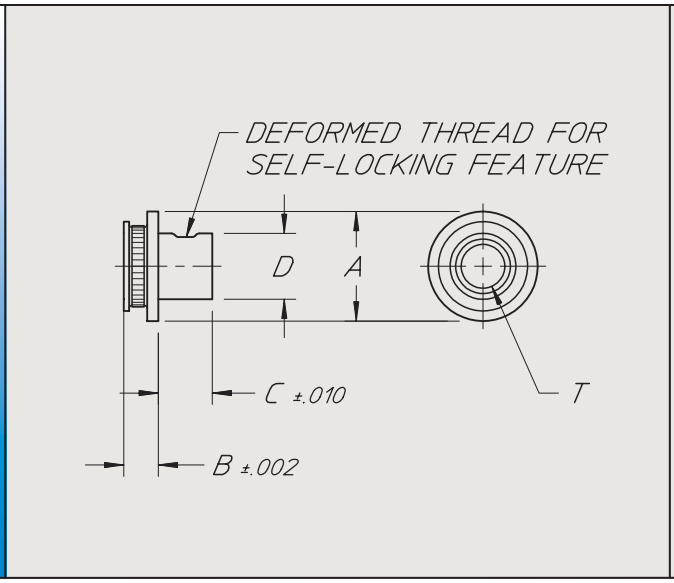
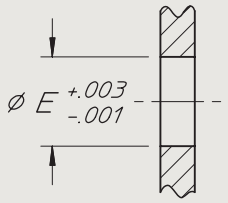
SF® DUPREE®

FASTENER
TYPE BASIC
PRESSURE DISPLACEMENT



PANEL MOUNTING HOLE



PART NO. EXAMPLE: **SF 6G 6C BA5 D**

HEAD TYPE	B THICKNESS									T THREAD		C APPENDAGE TYPE & LENGTH				A	D	E	MATERIAL
	.04	.05	.06	.08	.09	.10	.12	.15	.18	CODE	SIZE	3/32	1/8	5/32	3/16	MAJ. DIA.	APP. DIA.	MTG. HOLE DIA.	
SF	4E	5E	6E							2C	.086-56 UNC-3B	BA3				.219	.110	.156	D HIGH CARBON STEEL (SEE NOTE 1)
	4F	5F	6F	8F	9F	10F	12F			4C	.112-40 UNC-3B		BA4			.250	.139	.188	
	4G	5G	6G	8G	9G	10G	12G			6C	.138-32 UNC-3B			BA5		.281	.165	.219	
			6H	8H	9H	10H	12H	15H		8C	.164-32 UNC-3B			BA5		.312	.204	.250	
			6J	8J	9J	10J	12J	15J	18J	10F	.190-32 UNF-3B				BA6	.375	.229	.312	
				8L	9L	10L	12L	15L	18L	14F	.250-28 UNF-3B				BA6	.438	.300	.375	


INSERT


STAKE


INSTALLED

FEATURES:

1. The pressure displacement principle provides a fastener made of a relatively strong material installed into a relatively soft mounting material.
2. The BA fastener provides a steel threaded hole in a relatively soft material, flush with both surfaces of the mounting sheet, except for the protruding self-locking appendage.

NOTES:

1. High carbon steel (Material Code **D**) parts are stock items. Parts made of type 303 corrosion resistant steel (MIL-S-7720) are available, on order, by using Material Code **C**.
2. Parts are installed by pressure displacement principle as illustrated by figures. Pressure is applied between a punch and an anvil which may be installed in any suitable equipment, such as hydraulic or impact punch presses. A clearance hole is shown in the punch to accommodate the self-locking appendage. Pressure to be applied will vary with fastener size, sheet thickness and type of material used.
3. Sheet material must be ductile and capable of forming into knurled recess of fastener without stress cracking.
4. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

SPECIFICATIONS:

1. Steel fasteners (Material Code **D**) are made of chrome molybdenum alloy per AISI4140 (or equal).
2. Steel fasteners (Material Code **D**) are cadmium plated per QQ-P-416, Type II, Class 2.
3. Corrosion resistant steel fasteners (Material Code **C**) are passivated per QQ-P-35.

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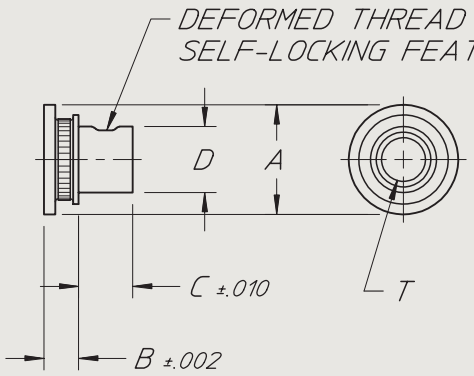
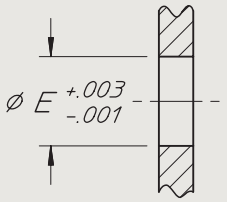
FASTENER
TYPE BA
PRESSURE DISPLACEMENT



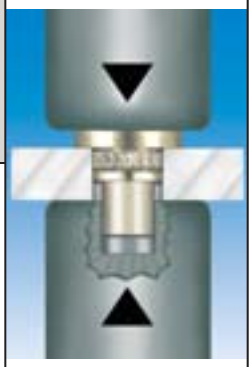
PANEL MOUNTING HOLE



PART NO. EXAMPLE: **SF 6G 6C BB5 D**

HEAD TYPE	B THICKNESS									T THREAD		C APPENDAGE TYPE & LENGTH				A	D	E	MATERIAL
	.04	.05	.06	.08	.09	.10	.12	.15	.18	CODE	SIZE	3/32	1/8	5/32	3/16		APP. DIA.	MTG. HOLE DIA.	
SF	4E	5E	6E							2C	.086-56 UNC-3B	BB3				.219	.110	.156	D HIGH CARBON STEEL (SEE NOTE 1)
	4F	5F	6F	8F	9F	10F	12F			4C	.112-40 UNC-3B		BB4			.250	.139	.188	
	4G	5G	6G	8G	9G	10G	12G			6C	.138-32 UNC-3B			BB5		.281	.165	.219	
			6H	8H	9H	10H	12H	15H		8C	.164-32 UNC-3B			BB5		.312	.204	.250	
			6J	8J	9J	10J	12J	15J	18J	10F	.190-32 UNF-3B				BB6	.375	.229	.312	
				8L	9L	10L	12L	15L	18L	14F	.250-28 UNF-3B				BB6	.438	.300	.375	

INSERT



STAKE

INSTALLED

FEATURES:

1. The pressure displacement principle provides a fastener made of a relatively strong material installed into a relatively soft mounting material.
2. The BB fastener provides a steel threaded hole in a relatively soft material, flush with both surfaces of the mounting sheet, except for the protruding self-locking appendage.

NOTES:

1. High carbon steel (Material Code **D**) parts are stock items. Parts made of type 303 corrosion resistant steel (MIL-S-7720) are available, on order, by using Material Code **C**.
2. Parts are installed by pressure displacement principle as illustrated by figures. Pressure is applied between a punch and an anvil which may be installed in any suitable equipment, such as hydraulic or impact punch presses. A clearance hole is shown in the punch to accommodate the self-locking appendage. Pressure to be applied will vary with fastener size, sheet thickness and type of material used.
3. Sheet material must be ductile and capable of forming into knurled recess of fastener without stress cracking.
4. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

SPECIFICATIONS:

1. Steel fasteners (Material Code **D**) are made of chrome molybdenum alloy per AISI4140 (or equal).
2. Steel fasteners (Material Code **D**) are cadmium plated per QQ-P-416, Type II, Class 2.
3. Corrosion resistant steel fasteners (Material Code **C**) are passivated per QQ-P-35.

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FASTENER
TYPE BB
PRESSURE DISPACEMENT

Special Fasteners

This catalog section covers a sample of some special products which Stake Fastener Co. routinely supplies.

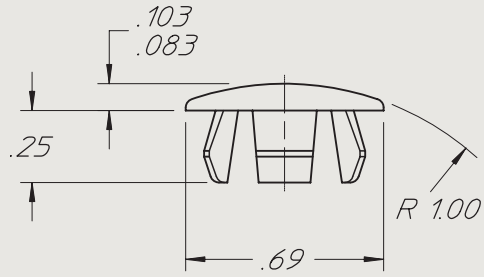
Colored Hole Plug

This versatile product is molded of pigmented durable nylon to match the color of mounting surfaces and offers a simple cover for unneeded holes. The hole plug snaps firmly in place to fill holes permanently or temporarily. It is available in all Stake Fastener Stock Colors in gloss, semi-gloss, or lusterless finish and virtually any color can be matched on order. Additional sizes will be added as required.

COLORED HOLE PLUG

PART NO. **SFHP 5006 COLOR**

SEE FOREWORD SECTION FOR STOCK COLOR AND CODE



FEATURES:

1. Hole Plugs are color matched to blend with the mounting surface of panels and equipment.
2. Designed to snap in and hold firmly in place. Hole Plugs offer a simple cover for unneeded holes.
3. The durable nylon material allows the product to be snapped out and reused, or left permanently in place for the life of the equipment.

NOTES:

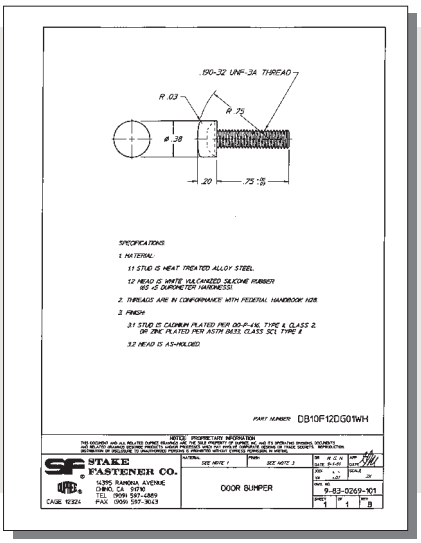
1. The Hole Plug fits holes .495 to .505 inch diameter in panels .050 to .100 inch thick.
2. Hole Plugs are available in all stock colors listed in the foreward section of this catalog. Additional colors will be added on request.
3. The single size listed is the first size of a series planned for release. Additional sizes will be added as required.

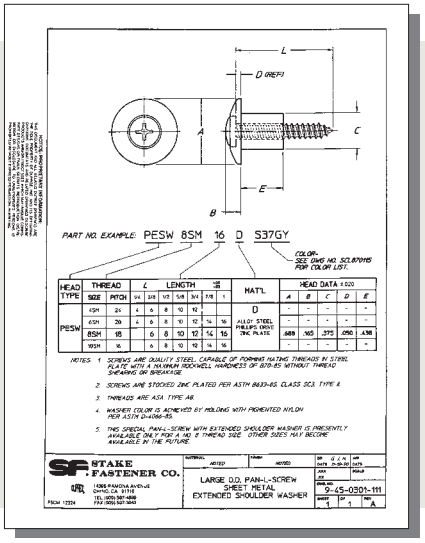
SPECIFICATIONS:

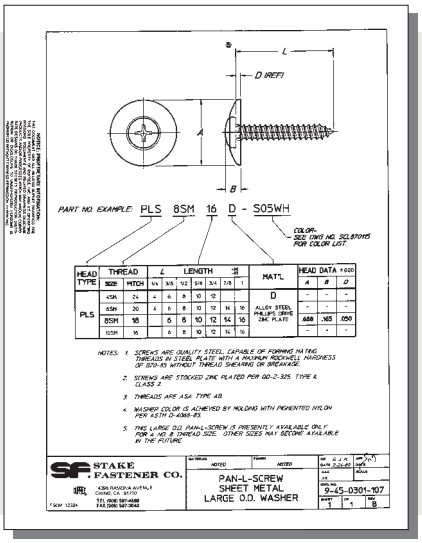
1. Hole Plug color is achieved by molding with pigmented nylon per ASTM D-4066-90.
2. Colors are matched to customer requirements. We reccomend selection from FED. STD. 595 whenever possible but we are also prepared to match customer furnished color chips or samples.

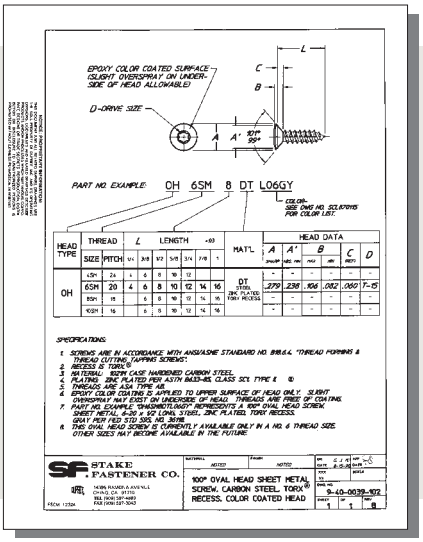
Special Fasteners

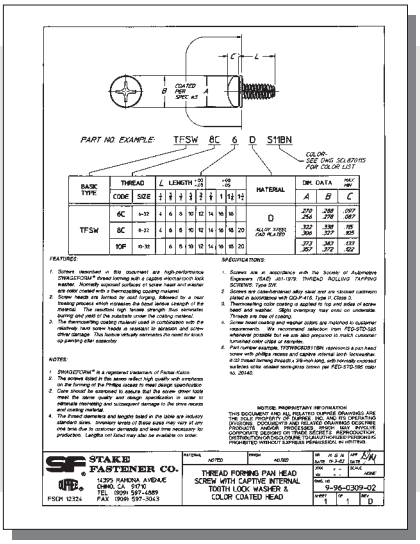
Screws with head styles, special washers, drive shapes and thread forms, standard in the industry but not listed in this catalog, can be provided with pre-coated colored heads on order. Additionally, we often employ our expertise in cold heading, screw machine work, threading, injection and transfer molding, and coating processes to develop special items to meet our customer requirements. A few samples of these special items are shown below. We invite inquiries for such special items and look forward to working with our customers to provide products that will fulfill the needs of their special fastener application requirements.



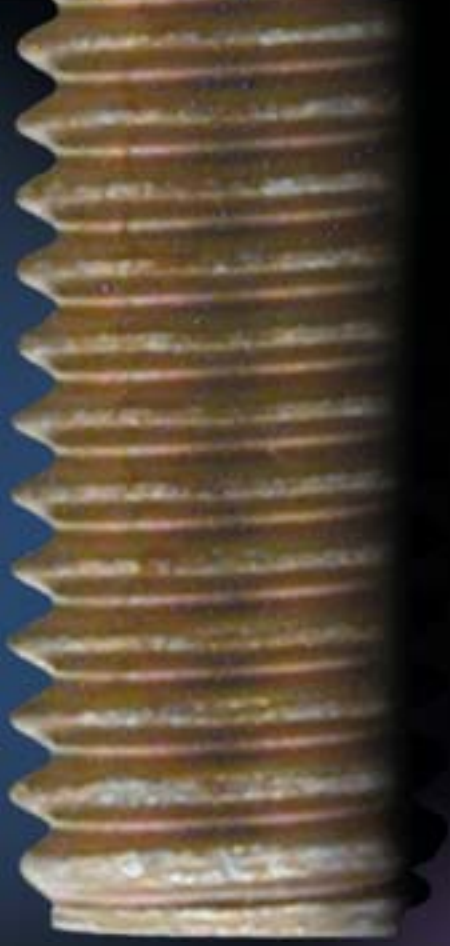


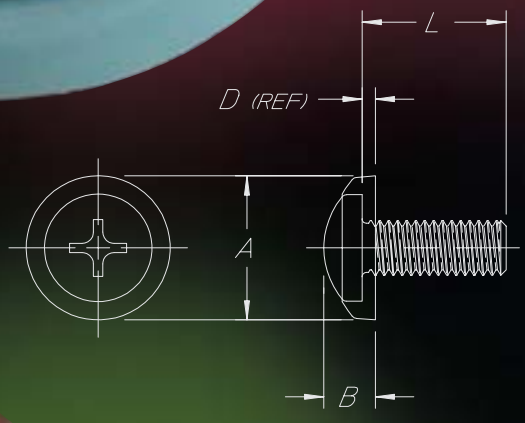


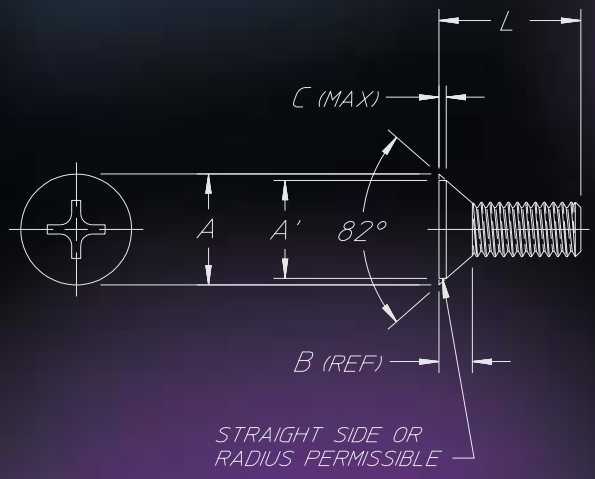




We like to solve problems! Contact us with your application details.







Stake Fastener Company has been the industry standard for color-coated screws and fasteners for over forty years. Our products are suitable for most applications where a decorative, color-matched fastener is required.

Stake Fastener Company

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