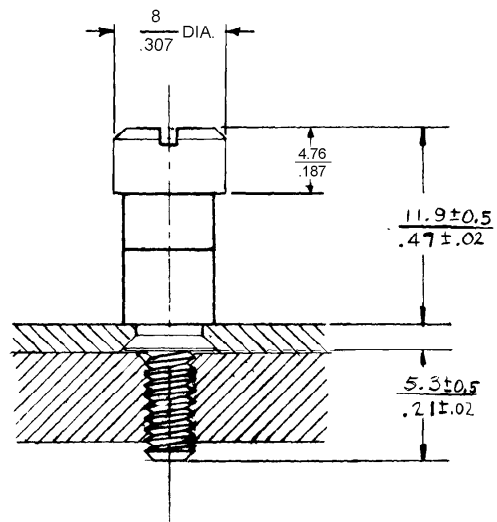
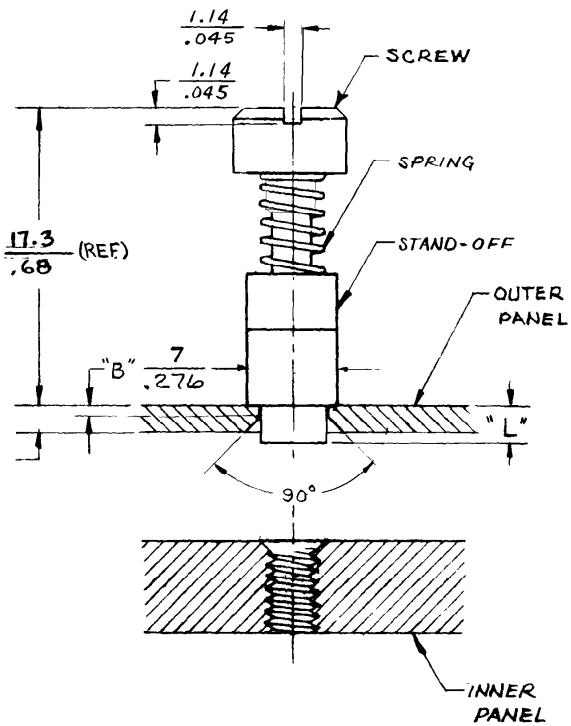




No. 52 ASSEMBLY - INSTALLATION INSTRUCTIONS
No. 6-32 THREAD - FLARE INSALLATION - SLOTTED SCREW

DATE	DRAWN	CHKD	SCALE	DRAWING NUMBER
5-2-84	ACZ		N.T.S.	J-52-10-40-24

REV. LET.	DATE	BY-CHKD	REVISIONS	GRIP RANGE	ASSEMBLY PART NUMBER	"L"	"B" $\pm .010$ $-.000$
H	04 Aug 1993	JGK	PRN: 52-26; $\phi .276$ was $\phi .281$	2.28 - 4.92 0.38 - .125	52-10-402-24	1.78 / .070	0.40 / .016
I	13 APR 95	KGS	PRN: 58-98	4.36 - 7.36 .126 - .187	52-10-404-24	3.43 / .135	1.59 / .063
J	06 AUG 96	SWVD	PRN: 52-56				



- INSTALLATION INSTRUCTIONS
1. PREPARE A $5.14 \pm 0.08 / .213 \pm .003$ DIA. HOLE IN OUTER PANEL. COUNTERSINK BACK SIDE OF HOLE 90° TO "B" DIM. AS SHOWN.
 2. INSERT ASSEMBLY AS SHOWN AND FLARE FERRULE INTO COUNTERSINK TO CAPTURE ASSEMBLY IN PANEL.
 3. USE SOUTHCO INSTALLATION TOOL PART NO 47-106 TO FLARE ASS'Y INTO PANEL

GRIP RANGE (SEE TABLE)

SCREW PROJECTION BEYOND MINIMUM OUTER PANEL THICKNESS

SCREW FASTENER ASSEMBLY CONSISTS OF ONE EACH OF THE FOLLOWING: SCREW, SPRING AND STAND-OFF. ALL COMPONENTS ARE STAINLESS STEEL, PASSIVATED. SPRING IS TYPE 302, SCREW IS TYPE 303 AND STANDOFF IS TYPE 304.

MILLIMETER/INCH
MILLIMETER
INCH

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TOLERANCE UNLESS OTHERWISE NOTED
METRIC (mm) - TWO PLACE (.XX) ± 0.25 ONE PLACE (.X) ± 0.3
INCH DECIMALS $\pm .010$

DRAWING NUMBER
J-52-10-40-24