

REV	DATE	DRAWN/CHKD	DESCRIPTION	ITEM	PART NUMBER	MATERIAL	FINISH
				ASSEMBLY	52-99-399-006	-	-
				SCREW	-	HARDENED STEEL	ZINC PLATE CHROMATE PLUS SEALER WITH HEAD POWDER COATED IBM BLURPLE
				STANDOFF	-	6000 SERIES ALUMINUM	NATURAL
				SPRING	-	302 STAINLESS STEEL	PASSIVATED

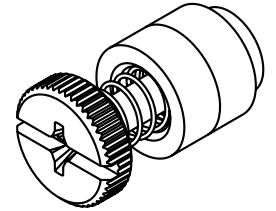
**MILLIMETERS**

ALL DIMENSIONS WITHOUT TOLERANCES ARE FOR REFERENCE ONLY.

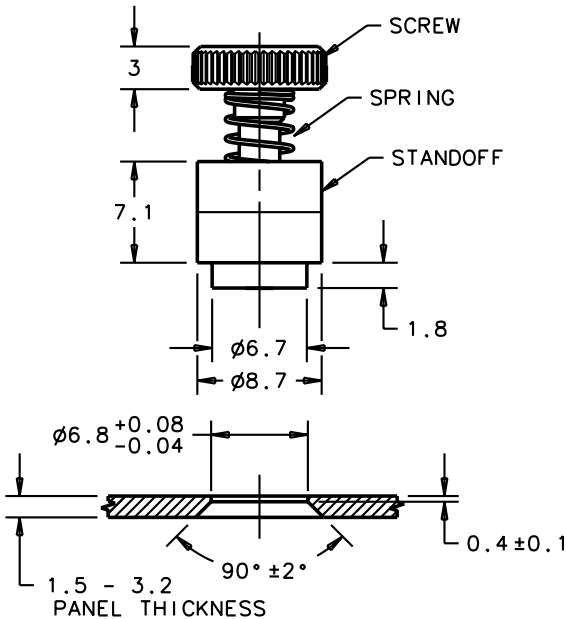
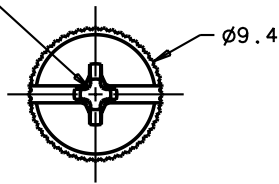
THIRD ANGLE PROJECTION  A4 PAPER SIZE

**NOTES:**

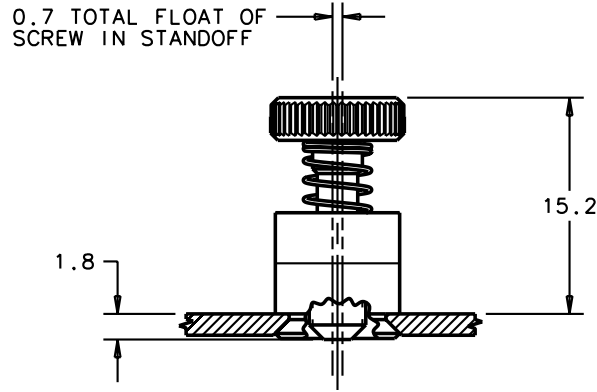
- A. SAME AS 52-49-21-4 EXCEPT HEAD IS POWDER COATED IBM BLURPLE.
- B. INSTALLATION INSTRUCTIONS:
  1. PREPARE THE HOLE IN THE PANEL, COUNTERSINK UNDERSIDE OF THE PANEL AS SHOWN.
  2. PUNCH SURFACE AND INSTALLATION TOOL MUST REMAIN PARALLEL DURING FLARING OF STANDOFF. ONLY USE LIGHT PRESSURE TO FLARE STANDOFF. RECOMMENDED LOAD OF 3,000N.
  3. USE SOUTHCO INSTALLATION TOOL, PART NUMBER 47-108, TO FLARE THIS ASSEMBLY.
- C. RECOMMENDED MAXIMUM TORQUE OF 220 N·cm.
- D. COSMETIC APPEARANCE PER SOUTHCO CAPTIVE SCREW SPECIFICATION S-115.



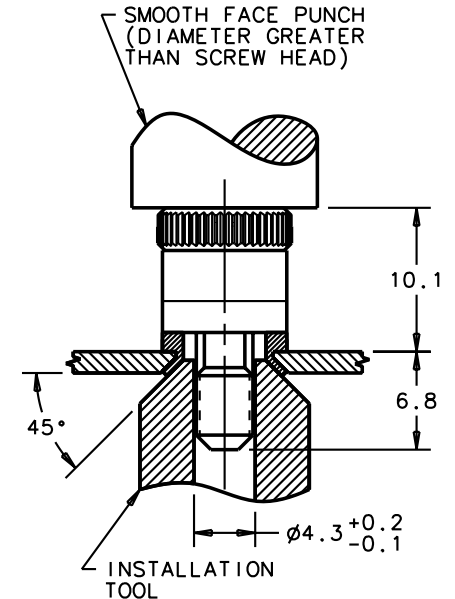
No. 2 PHILLIPS/SLOT RECESS



**PANEL PREPARATION**



**UNFASTENED**



**FASTENED**