- 1	Г
Southor	l
	ı

PROPRIETARY ITEM - EXCEPT FOR USES EXPRESSLY GRANTED IN WRITING INFORMATION DISCLOSED HEREON IS CONFIDENTIAL AND ALL RIGHTS PATENT AND OTHERWISE ARE RESERVED BY SOUTHCO. INC.

MODIFIED No. 52 CAPTIVE FASTENER ASSEMBLY M4 THREAD - FLARE-IN STYLE

DATE DRAWN CHKD SCALE DRAWING NUMBER 27MAR2007 DAW MDY 2:1

J - 52 - 99 - 399

REV	DATE	DRAWN/CHKD	DESCRIPTION	ITEM	PART NUMBER	MATERIAL	FINISH
				ASSEMBLY	52-99-399-006	ı	_
				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.



## NOTES:

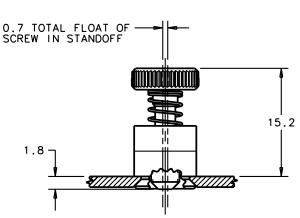
A. SAME AS 52-49-21-4 EXCEPT HEAD IS POWDER COATED IBM BLURPLE.

## 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.



D. COSMETIC APPEARANCE PER SOUTHCO CAPTIVE SCREW SPECIFICATION S-115.

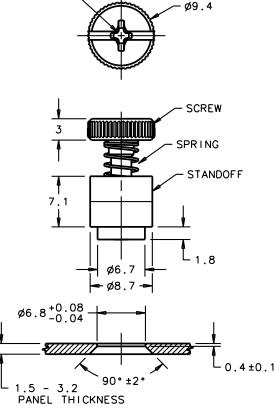






SMOOTH FACE PUNCH (DIAMETER GREATER THAN SCREW HEAD) 10.1 6.8  $\phi 4.3^{+0.2}_{-0.1}$ ∠ INSTALLATION TOOL

**FASTENED** 



No. 2 PHILLIPS/SLOT RECESS

PANEL PREPARATION