

SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 32 Ra MAX MICROINCHES. OTHER SURFACES 125 Ra MAX MICROINCHES. ABRASIVE BLASTED SURFACES 60 TO 250 Ra MICROINCHES. STUD STRAIGHT WITHIN .004 INCH PER INCH OF LENGTH. PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN .020 FIM. PITCH DIA PERPENDICULAR TO BASE WITHIN ±1°.

FOR OPTIONAL ROUND FIXTURE ADD R SUFFIX TO PART NUMBER

LENGTH L DATA (LENGTH CODE IN SIXTEENTHS OF AN INCH)

CODE	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32
L	.250	.375	.500	.625	.750	.875	1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000

STUD MATERIAL AND FINISH DATA (NOTE: 304 CRES TRIM WASHER ON C, E, AND G CODE STUDS)

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075 ALUMINUM	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA	2024 OR 7075 ALUMINUM	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	ANODIZE	MIL-A-8625 TYPE I, CLASS 1, NO SEAL
CR	302, 303, 304 OR A-286 CRES	AMS 5513, 5516, 5636, 5637, 5638, 5639, 5640, 5641, 5647 AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700 METHOD 1, TYPE 8
CRA	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700 METHOD 1, TYPE 8
T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, 4967	NONE	

THREAD DATA

CODE	THREAD SIZE	φ TD
06	.1380-32 UNJC-3A	.1315 - .1340
08	.1640-32 UNJC-3A	.1570 - .1595
3	.1900-32 UNJF-3A	.1810 - .1840
4	.2500-28 UNJF-3A	.2410 - .2440
5	.3125-24 UNJF-3A	.3020 - .3060

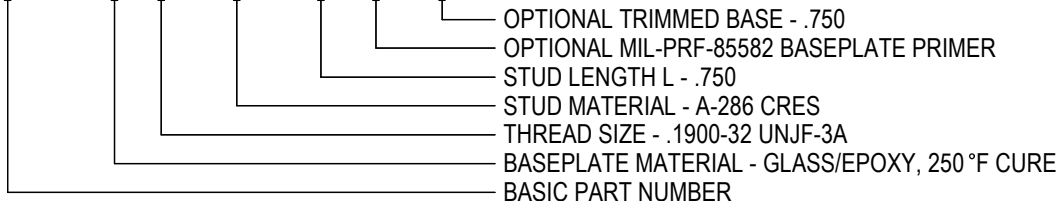
BASEPLATE MATERIAL

CODE	MATERIAL	SPEC.	T MAX
C	CARBON/EPOXY, 350 °F CURE	CBMS-105	
E	GLASS/EPOXY, 350 °F CURE	CBMS-106	.100
G	GLASS/EPOXY, 250 °F CURE	CBMS-107	
P	GLASS/PEEK	CBMS-103	
U	30% GLASS/PEI	CBMS-102	
UC	30% CARBON/PEI	CBMS-109	.110
V	40% GLASS/PEI	CBMS-101	
VC	40% CARBON/PEI	CBMS-108	

MANUFACTURER'S OPTION:
REDUCED MAJOR DIA TD

EXAMPLE PART NUMBER

CB4000 G 3 CRA 12 P 750



UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

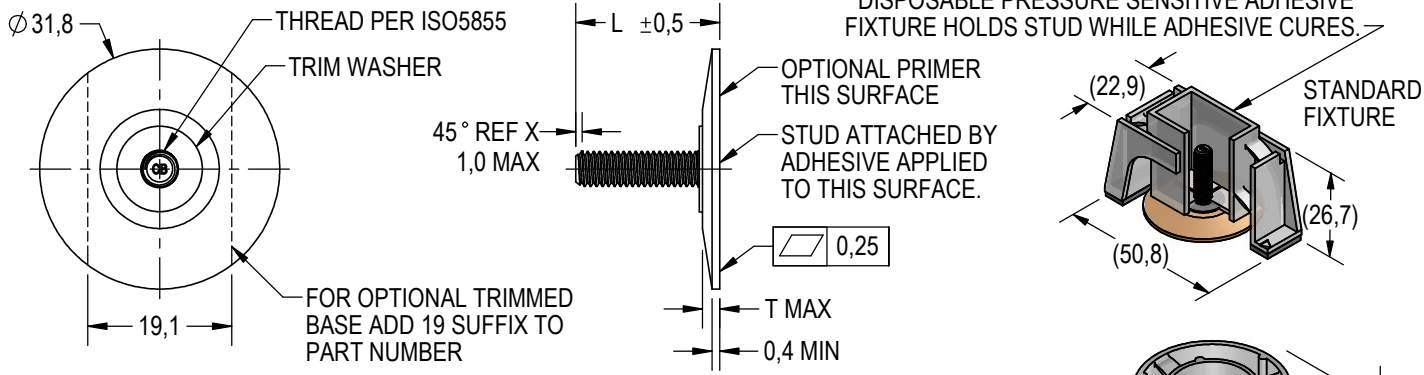
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2151 LOCKHEED WAY
CARSON CITY, NEVADA 89706

		APPROVALS	DATE
ANGLES	±1°	DRAWN GTP	12FEB21
.XX	±.03	CHECKED <i>DO Carter</i>	12FEB21
.XXX	±.010	RELEASED JLH	13FEB21
.XXXX	±.001	REVISED GTP	12FEB21

TITLE			
STUD, COMPOSITE BASE, ADHESIVE BONDED			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB4000	24
SCALE: 1:1		12FEB21	SHEET 1 OF 2



SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 0,8 Ra MAX MICROMETERS. OTHER SURFACES 3,2 Ra MAX MICROMETERS. ABRASIVE BLASTED SURFACES 1,5 TO 6,3 Ra MICROMETERS. STUD STRAIGHT WITHIN 0,004 mm PER mm OF LENGTH. PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN 0,5 FIM. PITCH DIA PERPENDICULAR TO BASE WITHIN ±1°.

FOR OPTIONAL ROUND FIXTURE ADD R SUFFIX TO PART NUMBER

LENGTH L DATA (LENGTH CODE IN MILLIMETERS)

CODE	6M	8M	10M	12M	15M	20M	25M	30M	35M	38M
L	6	8	10	12	15	20	25	30	35	38

STUD MATERIAL AND FINISH DATA (NOTE: 304 CRES TRIM WASHER ON C, E, AND G CODE STUDS)

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075 ALUMINUM	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA			ANODIZE	MIL-A-8625 TYPE I, CLASS 1, NO SEAL
CR	302, 303, 304 OR A-286 CRES	AMS 5513, 5516, 5636, 5637, 5638, 5639, 5640, 5641, 5647 AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700 METHOD 1, TYPE 8
CRA	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700 METHOD 1, TYPE 8
T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, 4967	NONE	

THREAD DATA

CODE	THREAD SIZE
3M	MJ3 X 0,5 4h6h
4M	MJ4 X 0,7 4h6h
5M	MJ5 X 0,8 4h6h
6M	MJ6 X 1,0 4h6h
8M	MJ8 X 1,0 4h6h

BASEPLATE MATERIAL

CODE	MATERIAL	SPEC.	T MAX
C	CARBON/EPOXY, 177 °C CURE	CBMS-105	2,54
E	GLASS/EPOXY, 177 °C CURE	CBMS-106	
G	GLASS/EPOXY, 121 °C CURE	CBMS-107	2,8
P	GLASS/PEEK	CBMS-103	
U	30% GLASS/PEI	CBMS-102	
UC	30% CARBON/PEI	CBMS-109	
V	40% GLASS/PEI	CBMS-101	
VC	40% CARBON/PEI	CBMS-108	

EXAMPLE PART NUMBER

CB4000 G 5M CRA 15M P 19

- ↑ BASIC PART NUMBER
- ↑ BASEPLATE MATERIAL - GLASS/EPOXY, 121 °C CURE
- ↑ THREAD SIZE - MJ5 X 0,8 4h6h
- ↑ STUD MATERIAL - A-286 CRES
- ↑ STUD LENGTH L - 15 mm
- ↑ OPTIONAL MIL-PRF-85582 BASEPLATE PRIMER
- ↑ OPTIONAL TRIMMED BASE - 19,1 mm

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METRIC DIMENSIONS		APPROVALS	DATE	TITLE		
DRAWN		GTP	12FEB21	STUD, COMPOSITE BASE, ADHESIVE BONDED		
ANGLES	±1°	CHECKED	12FEB21	SIZE	CAGE CODE	DWG. NO.
.X	±0,8	RELEASED	13FEB21	A	66530	CB4000 (METRIC)
.XX	±0,25	REVISED	12FEB21	SCALE: 1:1	12FEB21	REV. 24
						SHEET 2 OF 2