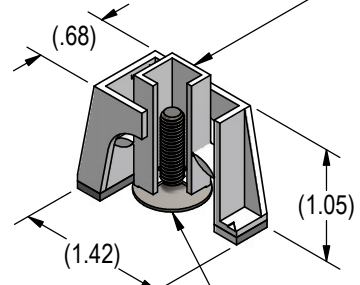


DISPOSABLE PRESSURE SENSITIVE ADHESIVE FIXTURE HOLDS STUD WHILE ADHESIVE CURES.



STUD ATTACHED BY ADHESIVE APPLIED TO THIS SURFACE.



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°.

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

CODE	4	6	8	10	12	14	16	18	20	22	24
L	.250	.375	.500	.625	.750	.875	1.000	1.125	1.250	1.375	1.500

MATERIAL AND FINISH DATA

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	Ø TD
04	.1120-40 UNJC-3A	.1065 - .1085
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

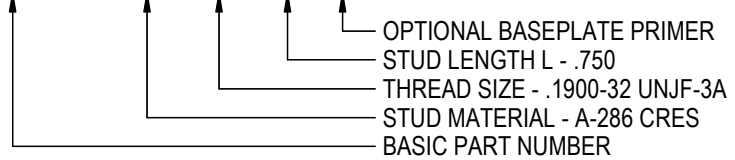
OPTIONAL BASEPLATE PRIMER

CODE	MATERIAL SPEC.
P	MIL-PRF-85582 EPOXY PRIMER
W	CBPS-211 FILM PRIMER

MANUFACTURER'S OPTION: REDUCED MAJOR DIA TD

EXAMPLE PART NUMBER

CB5000 CRA 3 - 12 P



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

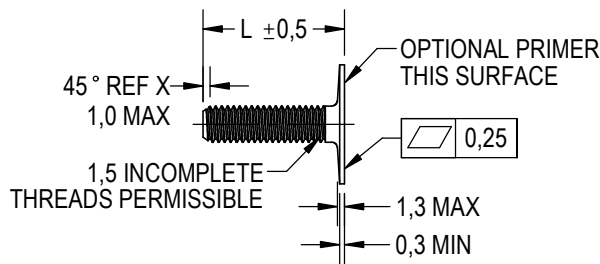
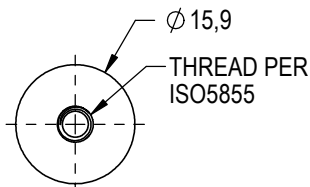
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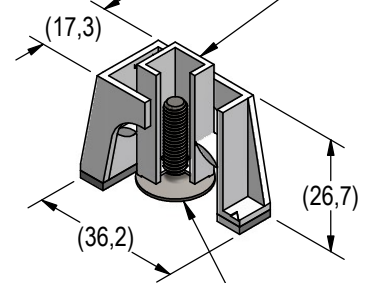
2151 LOCKHEED WAY
CARSON CITY, NEVADA 89706

		APPROVALS	DATE
ANGLES	±1°	DRAWN GTP	3AUG20
.XX	±.03	CHECKED <i>DO Carter</i>	3AUG20
.XXX	±.010	RELEASED JLH	3AUG20
.XXXX	±.001	REVISED GTP	3AUG20

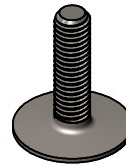
TITLE			
STUD, SMALL BASE, ADHESIVE BONDED			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB5000	20
SCALE: 1:1		3AUG20	SHEET 1 OF 2



DISPOSABLE PRESSURE SENSITIVE ADHESIVE FIXTURE HOLDS STUD WHILE ADHESIVE CURES.



STUD ATTACHED BY ADHESIVE APPLIED TO THIS SURFACE.



SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 0,8 Ra MAX MICROMETERS. OTHER SURFACES 3,2 Ra MAX MICROMETERS. ABRASIVE BLAST 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°.

LENGTH L DATA (LENGTH CODE IN MILLIMETERS)

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

MATERIAL AND FINISH DATA

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

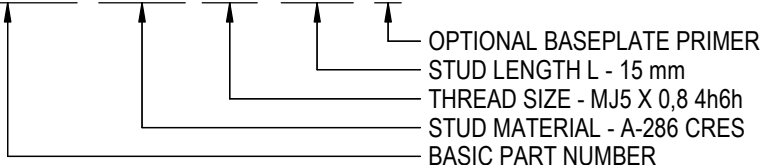
CODE	THREAD SIZE
3M	MJ3 X 0,5 4h6h
4M	MJ4 X 0,7 4h6h
5M	MJ5 X 0,8 4h6h
6M	MJ6 X 1,0 4h6h

OPTIONAL BASEPLATE PRIMER

CODE	MATERIAL SPEC.
P	MIL-PRF-85582 EPOXY PRIMER
W	CBPS-211 FILM PRIMER

EXAMPLE PART NUMBER

CB5000 CRA 5M 15M P



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

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METRIC DIMENSIONS		APPROVALS	DATE	TITLE		
ANGLES	±1°	DRAWN GTP	3AUG20	STUD, SMALL BASE, ADHESIVE BONDED		
.X	±0,8	CHECKED <i>JD Carter</i>	3AUG20	SIZE	CAGE CODE	DWG. NO.
.XX	±0,25	RELEASED JLH	3AUG20	A	66530	CB5000 (METRIC)
		REVISED GTP	3AUG20	SCALE: 1:1	3AUG20	REV. 20
						SHEET 2 OF 2