The 4002 Series fasteners utilize a variety of grommets designated to reinforce the panel for added strength. Certain 4002 series 1/4-turn fasteners are qualified to MIL-F-5591* specifications for sizes 5 and 7.

Stud
Available in six head styles.

Grommet and Grommet Retaining Ring
Must be installed in top of panel (Plus Flush Version shown for Ring Retained Grommets). Flare Retained Grommets are also available which do not use a Retaining Ring.

Stud Retaining Ring
Used for long studs (-16 or greater). Shorter studs (-15 and under) are self-captivating and do not require retaining rings.

Receptacle
Available in six styles.

Specifications:
Ultimate tensile strength: 1050 lbs.
Working strength: 700 lbs.
Stud grip increments: .030 inch.
Contact factory for strengths for stainless steel stud assemblies.

To Order a Complete Fastening System:
1. Select receptacle to be used. Stud part numbers vary depending upon the specific receptacle used.

2. Select style of stud to be used, then combine thicknesses of panel and frame to determine total thickness, “G”. Find the specific stud part number adjacent to “G” Total Thickness column with respect to receptacle selected.

3. If you are ordering long studs (-16 or greater), you will need to order a Stud Retaining Ring. Shorter studs (-15 and under) are self-captivating and do not require retaining rings.

4. A Grommet is required for all 4002 studs except Part Number 40S128. A choice of Flared or Retaining Ring Retained styles are available.

*Meets the design, physical and performance requirements of MIL-F-5591. However, full mechanical properties testing may not be performed on each production lot.
4002 Series. Stud Assemblies and Receptacles

Note: Part numbers shown are basic part numbers only. See ordering information on Page A-62 for required dash numbers.

<table>
<thead>
<tr>
<th>Material</th>
<th>Part No.</th>
<th>Part No.</th>
<th>Part No.</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stainless Steel</td>
<td>4002-[ ]S</td>
<td>40S5-[ ]S</td>
<td>—</td>
<td>40S119-[ ]-3AA</td>
</tr>
<tr>
<td>Stainless Steel High Strength</td>
<td>40S41-[ ]S</td>
<td>—</td>
<td>40S80-[ ]B</td>
<td>—</td>
</tr>
<tr>
<td>Stainless Steel (Spring: Inconel &quot;X&quot;)</td>
<td>40S45-[ ]</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Steel (Cadmium Plated, Yellow Chromate)</td>
<td>4002-[ ]</td>
<td>40S5-[ ]</td>
<td>—</td>
<td>40S119-[ ]-3BB</td>
</tr>
<tr>
<td>Steel (Zinc Plated, Clear Chromate)</td>
<td>—</td>
<td>40S5-[ ]C</td>
<td>40S80-[ ]C</td>
<td>—</td>
</tr>
<tr>
<td>Steel (Nickel Plated)</td>
<td>40S79-[ ]</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Steel (Head: Chrome Plated)</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Steel (Zinc Plated, Yellow Chromate)</td>
<td>—</td>
<td>40S5-[ ]D</td>
<td>40S80-[ ]E</td>
<td>—</td>
</tr>
</tbody>
</table>

Maximum Service Temperature: Stainless Steel with inconel "X" Spring—700°F; Stainless Steel—550°F; Sealed Stud Assembly, P/N 40S37-[ ]—130°F; all others 450°F.

Note: 4002 Series stud assemblies seat nominally flush with mating grommet. For Wing, Bail Handle or Knurled Knob versions, top side protrusion is nominally equal to mating grommet "B" dimension plus the height of the wing, handle or knob.

Specifications:

This series utilizes a variety of grommets which must be installed into the top panel. They significantly enhance the system’s performance.

Ultimate tensile strength: 1050 lbs.
Working strength: 700 lbs.
Stud grip increments: .030 inch.
Contact factory for strengths for stainless steel stud assemblies.
For other styles, materials, or finishes, please contact Camloc Products Division.

Ultimate tensile strength for stainless steel: 735 lbs.
Working strength: 500 lbs.
Minimum Preload - 50 LBS

Grommetless Stud

*S=Protruding Slotted Head Part No. 40S128-[ ]-1AA*

40S128
Protruding Head

Note: This stud does not require a grommet, but must be used with retaining ring part number 40S142-1-1AA.

Retaining Ring

Part Number
40S142-1-1AA

CRES Spring
Steel (Passivated)
## QUICK OPERATING 1/4-TURN FASTENERS  4002 SERIES

<table>
<thead>
<tr>
<th>Hex Recess</th>
<th>Sealed</th>
<th>Fixed Wing</th>
<th>Folding Bail Handle</th>
<th>Knurled Knob</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>4mm Part No.</strong></td>
<td><strong>6mm Part No.</strong></td>
<td><strong>Part No.</strong></td>
<td><strong>Part No.</strong></td>
<td><strong>Part No.</strong></td>
</tr>
<tr>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>---</td>
<td>---</td>
<td>4002-[ ]SW</td>
<td>---</td>
<td>40S83-[ ]</td>
</tr>
<tr>
<td>---</td>
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<tr>
<td>---</td>
<td>---</td>
<td>40S77-[ ]</td>
<td>40S47-[ ]A</td>
<td>---</td>
</tr>
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<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>40S83-[ ]B</td>
</tr>
<tr>
<td>40S122-[ ]-1AA</td>
<td>40S122-[ ]-2AA</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
</tbody>
</table>

† Not available with dash numbers smaller than #4.
Refer to installation instructions on page A-59.
## Quick Operating 1/4-Turn Fasteners

### 4002 Series. Receptacles

#### Standard Mounting

| Material                      | Part No. | Rivet Holes | Weight (per 100 pcs.) lbs. | | Part No. | Rivet Holes | Weight (per 100 pcs.) lbs. | | Part No. | Rivet Holes | Weight (per 100 pcs.) lbs. |
|-------------------------------|----------|-------------|-----------------------------|---|-------------|-----------------------------|---|-------------|-----------------------------|
| Stainless Steel               |          |             |                             | |                   |                             | |                   |                             | |                   |                             |
| Stainless Steel (Red Dye)     | 214-16S  | Plain       | 1.76                        | | 214-16SD | C’Sunk       | 1.68                        | |              |              |                             | |                   |                             |
| Steel (Cadmium Plated)        |          |             |                             | |                   |                             | |                   |                             | |                   |                             |
| Silicon Bronze (Cadmium Plated)| 214-16   | Plain       | 1.85                        | | 214-16N | Plain       | 1.80                        | | 40R12-1 | Plain       | 2.45                        | |                   |                             |
| Zinc (Cadmium Plated)         | 214-16E  | Plain       | 1.44                        | |              |              |                             | |                   |                             |
| Steel (Cadmium Plated)        |          |             |                             | |                   |                             | |                   |                             | |                   |                             |
| Silicone Bronze (Cadmium Plated)| 214-16D | C’Sunk       | 1.77                        | | 214-16ND | C’Sunk       | 1.72                        | | 40R12-2 | C’Sunk       | 2.37                        | |                   |                             |

#### Standard Mounting Continued

| Material                      | Part No. | Rivet Holes | Weight (per 100 pcs.) lbs. | | Part No. | Rivet Holes | Weight (per 100 pcs.) lbs. | | Part No. | A Dim. | Rivet Holes | Weight (per 100 pcs.) lbs. |
|-------------------------------|----------|-------------|-----------------------------|---|-------------|-----------------------------|---|-------------|-----------------------------|
| Stainless Steel               | 244-22S  | Plain       | 2.77                        | |              |              |                             | |                   |                             |
| Steel (Cadmium Plated)        | 244-22   | Plain       | 2.99                        | | 244-22C | Plain       | 3.98                        | |              |              |                             | |                   |                             |
| Steel (Cadmium Plated)        | 244-22E  | Plain       | 2.61                        | | 244-22EC | Plain       | 3.60                        | |              |              |                             | |                   |                             |
| Aluminum                      |          |             |                             | |                   |                             | |                   |                             | |                   |                             |

### Notes:
1. Use to seal against leakage of air, dust or water. Install with suitable sealing compound such as 3M #EC-847 or adhesive silicon sealant.
2. Receptacles and Shims with countersunk holes are for use with dimpled panels.

### Maximum Service Temperatures for Standard Mounting Types:
- Stainless Steel—700°F
- Steel (Cadmium Plated) and Silicon Bronze (Cadmium Plated)—450°F
- Silicon Bronze with Brass Cap and Steel with Zinc Receptacle Element—300°F
- Aluminum—350°F
2-Piece Floating Receptacles/Spotweld Attachment

These receptacles are designed to be attached by spotwelding. Separate cage and receptacle element allow smaller envelopes and significant weight savings over conventional designs. Choose from versions within 1/16 inch or 1/8 inch total float.

Order receptacle element and cage separately.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Rivet Holes</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
<th>Part No.</th>
<th>Rivet Holes</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
<th>Part No.</th>
<th>Rivet Holes</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>40R17-1</td>
<td>Plain</td>
<td>1.20</td>
<td>244-16S</td>
<td>Plain</td>
<td>2.57</td>
<td>244-16SC</td>
<td>Plain</td>
<td>3.31</td>
</tr>
<tr>
<td>40R17-2</td>
<td>Dimpled</td>
<td>1.20</td>
<td>244-16SD</td>
<td>Dimpled</td>
<td>2.59</td>
<td>244-16SCD</td>
<td>Dimpled</td>
<td>3.33</td>
</tr>
<tr>
<td>40R17-5</td>
<td>Plain</td>
<td>1.19</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40R17-6</td>
<td>Dimpled</td>
<td>1.19</td>
<td></td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>244-16</td>
<td>Plain</td>
<td>2.60</td>
<td>244-16C</td>
<td>Plain</td>
<td>3.33</td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>244-16D</td>
<td>Dimpled</td>
<td>2.62</td>
<td>244-16CD</td>
<td>Dimpled</td>
<td>3.35</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>244-16E</td>
<td>Plain</td>
<td>2.24</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

2-Piece Floating Receptacles/Spotweld Attachment

These receptacles are designed to be attached by spotwelding. Separate cage and receptacle element allow smaller envelopes and significant weight savings over conventional designs. Choose from versions within 1/16 inch or 1/8 inch total float.

Order receptacle element and cage separately.

<table>
<thead>
<tr>
<th>Material</th>
<th>Receptacle Element</th>
<th>Weight*</th>
<th>Cages</th>
<th>Receptacle Element</th>
<th>Cage</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel (Cadmium Plated)</td>
<td>—</td>
<td>—</td>
<td>756W</td>
<td>0.51</td>
<td>—</td>
</tr>
<tr>
<td>Silicon Bronze (Cadmium Plated)</td>
<td>751</td>
<td>1.74</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Zinc (Zinc Plated)</td>
<td>751D</td>
<td>1.36</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
</tbody>
</table>

*Weights shown are in lbs. per 100 pcs.
4002 Series. Receptacles continued

Side Mounting

<table>
<thead>
<tr>
<th>Material</th>
<th>No.</th>
<th>Rivet Holes</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
<th>Part No.</th>
<th>Rivet Holes</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel (Cad. Plated) Receptacle Element: Silicon Bronze (Cad. Plated)</td>
<td>244-16B-R</td>
<td>Plain</td>
<td>4.80</td>
<td>244-16BC-R</td>
<td>Plain</td>
<td>5.84</td>
</tr>
<tr>
<td>Steel (Cad. Plated) Receptacle Element: Silicon Bronze (Cad. Plated)</td>
<td>244-16B</td>
<td>None (Weld Type)</td>
<td>4.84</td>
<td>244-16BC</td>
<td>None (Weld Type)</td>
<td>5.80</td>
</tr>
</tbody>
</table>

Notes:
1. Use to seal against leakage of air, dust or water. Install with suitable sealing compound such as 3M #EC-847 or adhesive silicon sealant.
2. Maximum Service Temperature: 450°F.

Clip-in

<table>
<thead>
<tr>
<th>Material</th>
<th>Part No.</th>
<th>Rivet Holes</th>
<th>Part No.</th>
<th>Rivet Holes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel &amp; Zinc Alloy (Zinc Plated)</td>
<td>40R39-1-1AA</td>
<td>None</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>Steel (Cad. Plated) Receptacle Element: Silicon Bronze (Cadmium Plated)</td>
<td>–</td>
<td>–</td>
<td>40R44-1-1AA</td>
<td>None</td>
</tr>
</tbody>
</table>

Maximum Service Temperature: 300°F.
QUICK OPERATING 1/4-TURN FASTENERS  4002 SERIES

4002 Series. Grommets

4002 Series stud assemblies must be used in conjunction with one of the grommets shown here.

Both flush mounting and plus flush grommets are available with either retailing ring or flare retention.

Retaining Ring Retained

Plus Flush Grommets

Ring retained grommets are easily installed without the need for extensive special tooling.

\[ P = C \text{ Min} - .042 \text{ Max (retaining ring thickness) - .008} \]

<table>
<thead>
<tr>
<th>Part No.</th>
<th>P Max. Thickness</th>
<th>Material</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>G Min. (Note 1)</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4002-N2S</td>
<td>.025</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.625</td>
<td>.201</td>
<td>.082</td>
<td>.069</td>
<td>.053</td>
<td>0.40</td>
</tr>
<tr>
<td>4002-N2</td>
<td>.065</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.201</td>
<td>.074</td>
<td>.063</td>
<td></td>
<td></td>
<td>0.39</td>
</tr>
<tr>
<td>4002-N2S</td>
<td>.065</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.201</td>
<td>.122</td>
<td>.029</td>
<td>.023</td>
<td>.091</td>
<td>0.30</td>
</tr>
<tr>
<td>4002-NS</td>
<td>.065</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.201</td>
<td>.114</td>
<td>.023</td>
<td></td>
<td></td>
<td>0.30</td>
</tr>
<tr>
<td>4002-NS</td>
<td>.065</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.201</td>
<td>.114</td>
<td>.023</td>
<td></td>
<td></td>
<td>0.30</td>
</tr>
<tr>
<td>4002-O</td>
<td>.094</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.202</td>
<td>.157</td>
<td>.029</td>
<td>.116</td>
<td>.116</td>
<td>0.33</td>
</tr>
<tr>
<td>4002-O</td>
<td>.094</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.202</td>
<td>.157</td>
<td>.029</td>
<td>.116</td>
<td>.116</td>
<td>0.33</td>
</tr>
<tr>
<td>4002-N3</td>
<td>.072</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.876</td>
<td>.201</td>
<td>.128</td>
<td>.054</td>
<td>.150</td>
<td>0.60</td>
</tr>
</tbody>
</table>

Retaining Ring Retained

Flush Mounting Grommets (Standard Series)

<table>
<thead>
<tr>
<th>Part No.</th>
<th>P Max. Thickness</th>
<th>Material</th>
<th>B</th>
<th>C</th>
<th>G Min. (Note 1)</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4002-GS</td>
<td>.074</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.191</td>
<td>.132</td>
<td>.090</td>
<td>0.31</td>
</tr>
<tr>
<td>4002-G</td>
<td>.074</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.191</td>
<td>.132</td>
<td>.090</td>
<td>0.31</td>
</tr>
<tr>
<td>40G5</td>
<td>.117</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.201</td>
<td>.173</td>
<td>.150</td>
<td>0.33</td>
</tr>
<tr>
<td>40G10</td>
<td>.117</td>
<td>Stainless Steel (Cadmium Plated)</td>
<td>.201</td>
<td>.173</td>
<td>.150</td>
<td>0.33</td>
</tr>
</tbody>
</table>

Notes: (Applies to both Plus Flush and Flush Mounting Versions above.)

1. Grommets will protrude from the back side of panel. Minimum total thickness “G” must be observed to prevent grommets from jamming against the receptacle. (Under certain conditions “G” minimum may be reduced. See Note 3 on Page A-62.)

2. Panels with thicknesses greater than “P” Max. may be back counterbored.

3. Maximum Service Temperatures: Stainless — 700°F; Steel — 450°F.
### 4002 Series. Grommets

Retaining Ring Retained
Flush Mounting Grommets.
(High Shear Series)

Maximum Service Temperature: — 450°F

**High Shear Flush Mounting**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Material</th>
<th>P Max.</th>
<th>G* Min.</th>
<th>Dimensions</th>
<th>Weight (per 100 pcs.)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>A</td>
<td>B</td>
<td>C</td>
<td>(lbs.)</td>
</tr>
<tr>
<td>40G1-5</td>
<td>Alloy Steel (Cadmium Plated)</td>
<td>.065</td>
<td>.120</td>
<td>.063-.066</td>
<td>.185-.189</td>
</tr>
<tr>
<td>40G1-8</td>
<td></td>
<td>.092</td>
<td>.150</td>
<td>.090-.093</td>
<td>.185-.189</td>
</tr>
<tr>
<td>40G1-10</td>
<td></td>
<td>.113</td>
<td>.175</td>
<td>.111-.114</td>
<td>.215-.218</td>
</tr>
<tr>
<td>40G1-11</td>
<td></td>
<td>.128</td>
<td>.175</td>
<td>.126-.129</td>
<td>.215-.218</td>
</tr>
</tbody>
</table>

**Important Notes:**

1. Grommets will protrude from the back side of panel. Minimum total thickness "G" must be observed to prevent grommets from jamming against the receptacle. (Under certain conditions "G" minimum may be reduced. See Note 3 on Page A-62.)

2. For maximum shear capability receptacle mounting hole in substructure may be reduced to .578 inch. This hole size provides no accommodation for misalignment.

### Flare Retained

**Flush and Plus Flush Grommets**

Flare retained grommets will accommodate relatively thick panels often eliminating the need for back counterboring. Flared grommets should also be specified when axial grommet to movement must be restricted. **Note:** Part numbers shown are basic part numbers only. See Date Table indicated below for "P" panel thickness, "L" dimension and required grommet length dash number.

### Data Tables

<table>
<thead>
<tr>
<th>Series</th>
<th>Part No.</th>
<th>Material</th>
<th>A, dia</th>
<th>D</th>
<th>Look up “P” and “L” dimensions, plus grommet length dash number, from the data table indicated below. (See next page)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Plus Flush, Standard</td>
<td>40G16-[]</td>
<td>Alloy Steel (Cadmium Plated)</td>
<td></td>
<td>.049</td>
<td>#1</td>
</tr>
<tr>
<td></td>
<td>40G16-[]S</td>
<td>Stainless Steel</td>
<td></td>
<td>.049</td>
<td>#1</td>
</tr>
<tr>
<td></td>
<td>4002-P3-[]</td>
<td>Steel (Cadmium Plated)</td>
<td></td>
<td>.032</td>
<td>#3</td>
</tr>
<tr>
<td></td>
<td>40G16-[]-1</td>
<td>Alloy Steel (Nickel Plated)</td>
<td></td>
<td>.049</td>
<td>#1</td>
</tr>
<tr>
<td></td>
<td>40G16-[]-2</td>
<td>Alloy Steel (Cadmium Plated, Clear Chromate)</td>
<td></td>
<td>.049</td>
<td>#1</td>
</tr>
<tr>
<td>Plus Flush, Large Bearing Area</td>
<td>4002-P4-[]A</td>
<td>Stainless Steel</td>
<td></td>
<td>.876</td>
<td>#3</td>
</tr>
<tr>
<td></td>
<td>4002-P4-[]</td>
<td>Steel (Cadmium Plated)</td>
<td></td>
<td>.061</td>
<td>#3</td>
</tr>
<tr>
<td></td>
<td>4002-P4-[]B</td>
<td>Steel (Nickel Plated)</td>
<td></td>
<td>.041</td>
<td>#3</td>
</tr>
<tr>
<td>Flush</td>
<td>40G15-[]S</td>
<td>Stainless Steel</td>
<td></td>
<td>.625</td>
<td>#2</td>
</tr>
<tr>
<td></td>
<td>4002-P2-[]</td>
<td>Steel (Cadmium Plated)</td>
<td></td>
<td>N/A</td>
<td>#3</td>
</tr>
<tr>
<td></td>
<td>40G15-[]</td>
<td>Alloy Steel (Cadmium Plated)</td>
<td></td>
<td>.625</td>
<td>#2</td>
</tr>
</tbody>
</table>

**Notes:**

1. Maximum Service Temperature: Stainless Steel — 700°F; Steel (Cadmium Plated) — 450°F; Steel (Nickel Plated) — 550°F
2. For weighs see Page A-63.
4002 Series. Grommets (continued)

Data Tables for Flared Retained Grommets.
("P", "L" and Grommet Dash Numbers)

To Select Grommet Dash Number
1. Determine “P” panel thickness.
2. Locate “P” thickness in the appropriate table below.
3. Find the corresponding dash number to the right.

<table>
<thead>
<tr>
<th>DATA TABLE 1</th>
<th>DATA TABLE 2</th>
<th>DATA TABLE 3</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>P</strong> Panel Thickness</td>
<td><strong>L</strong></td>
<td><strong>Grommet Length Dash Number</strong></td>
</tr>
<tr>
<td>.040-.069</td>
<td>.109-.116</td>
<td>-040</td>
</tr>
<tr>
<td>.070-.099</td>
<td>.142-.149</td>
<td>-070</td>
</tr>
<tr>
<td>.100-.129</td>
<td>.172-.179</td>
<td>-100</td>
</tr>
<tr>
<td>.130-.159</td>
<td>.202-.209</td>
<td>-130</td>
</tr>
<tr>
<td>.160-.189</td>
<td>.232-.239</td>
<td>-160</td>
</tr>
<tr>
<td>.190-.219</td>
<td>.262-.269</td>
<td>-190</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>DATA TABLE 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>P</strong> Panel Thickness</td>
</tr>
<tr>
<td>.040-.069</td>
</tr>
<tr>
<td>.070-.099</td>
</tr>
<tr>
<td>.100-.129</td>
</tr>
<tr>
<td>.130-.159</td>
</tr>
<tr>
<td>.160-.189</td>
</tr>
<tr>
<td>.190-.219</td>
</tr>
</tbody>
</table>

Notes:
1. For longer lengths contact Camloc Products Division.
2. Data tables are applicable to specific part numbers. Select the correct table as indicated on Page A-52.

See Grommet Weights on Page A-63.

How to Order:
Example:
"P" thickness = .125 inch.
Grommet selected: 40G15-[ ]S
From data above, Table #2 applies.
Grommet Dash Number selected from Table #2: -100.
Complete part number: 40G15-100S.
4002 Series. Panel Preparation and Installation Data
(For Ring Retained Grommets)

Plus Flush Grommets

Drill #30 (.1285) pilot hole. Enlarge pilot hole to .478-.473 diameter with hole saw HS-471. “P” maximum panel thickness varies with grommet selected. Please see Page A-51 for tabulation.

Panels with thicknesses greater than “P” maximum must be back counterbored to a concentric .688 inch diameter with a remaining material thickness not exceeding “P” maximum.

Note: Hole saws and counterboring tools are available as a convenience in selected sizes. Please see Page A-55.

Flush Mounting Grommets

Dimpled Panel Preparation for panel thicknesses “P” up to .086 inch. Drill #30 (.1285) pilot hole. Enlarge hole using hole saw specified below to diameter. C’Sink using tool specified. Insert grommet and push panel back using closing tool specified. Panel must be securely engaged behind shoulder of grommet for positive retention.

* See Next Page for dimpling tool ordering information.

Alternate Dimpling Method.

“For thin” panels constructed from ductile materials allow use of an alternative method which eliminates the need for grommet retaining rings.

Drill #30 (.1285) pilot hole. Enlarge hole using hole saw P/N HS-418. Then dimple using tools tabulated above. Insert grommet and push panel back using closing tool specified. Panel must be securely engaged behind shoulder of grommet for positive retention.

* See Next Page for dimpling tool ordering information.

Installing Grommet

Insert grommet into mounting hole and captivate with retaining ring. Please see Page A-56 for more information.

Typical Installations

<table>
<thead>
<tr>
<th>P Max.</th>
<th>B Max.</th>
<th>Hole Saw</th>
<th>Dimpling Tool Set* (order both P/Ns)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.064</td>
<td>.074</td>
<td>HS-471</td>
<td>4G200M-[ ]</td>
</tr>
<tr>
<td>.086</td>
<td>.117</td>
<td></td>
<td>4G200F-[ ]</td>
</tr>
</tbody>
</table>

* See Next page for dimpling tool ordering information.

For panel thickness “P” large than .086 inch, drill #30 pilot hole. Enlarge pilot hole using hole saw specified below to X diameter. C’Sink using tool specified.

Alternate Dimpling Tool Set

<table>
<thead>
<tr>
<th>P Max.</th>
<th>Hole Saw</th>
<th>Dimpling Tool Set* (order both P/Ns)</th>
<th>Closing Tools* (order both P/Ns)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.086</td>
<td>HS-418</td>
<td>4-G100M-[ ]</td>
<td>4-GM-[ ]</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4-G100F-[ ]</td>
<td>4-GF-[ ]</td>
</tr>
</tbody>
</table>

* See Next Page for dimpling tool ordering information.

Note: Hole saws, counterboring tools and countersinks are available as a convenience in selected sizes (see alternative dimple method).
4002 Series. Panel Preparation and Installation Data (continued)

Installation Tools for Ring Retained Grommets.

**Hole Saws**
Accurately sizes grommet mounting holes.

**Part No.** | **Application**
--- | ---
HS-418 | Alternate dimple method only
HS-471 | All mounting holes except alternate dimple method

**Dimpling and Closing Tools**
(Part number for dimpling and closing tools are listed with the installation instructions on preceding page.)

**Dimpling tools for dimpling thin panels.**
**Closing tools must be used with alternative dimpling method to push back panel.**

**Counterboring Tool 4G2C**
For back counterboring thick panels to .688 concentric diameter.

**Countersinking Tool (4GC)**
Forms C'Sink required for flush mounting grommets.

**Adaptors**
May be used to adapt any C'Sinking or C'Boring tool for use in a drill chuck.

### Dash Nos. for Shank Diameters and Lengths Used On Dimpling and Closing Tools

<table>
<thead>
<tr>
<th>Dash Number</th>
<th>Shank Dia.</th>
<th>Shank Length</th>
</tr>
</thead>
<tbody>
<tr>
<td>-1</td>
<td>1/4</td>
<td>9/16</td>
</tr>
<tr>
<td>-2</td>
<td>5/16</td>
<td>5/8</td>
</tr>
<tr>
<td>-3</td>
<td>5/16</td>
<td>7/8</td>
</tr>
<tr>
<td>-4</td>
<td>3/8</td>
<td>7/8</td>
</tr>
</tbody>
</table>

**Note:**
It is recommended that tools be ordered in sets.
However, punch and dies may be ordered separately.

**Tooling Part Number Structure**

Example: 4G200M-2

2 = 5/16" Dia. x 5/8" Long Shank
M = Punch
F = Die

**Part Number** | **Thread** | **Pilot Hole**
--- | --- | ---
4GC | 5/16-32 | .470
4GC-500 | 5/16-32 | .500
4GC-1-470 | 1/4-28 | .470
4GC-1-500 | 1/4-28 | .500

**C'Sink Tool Thread** | **Adaptor Part No.**
--- | ---
5/16-32 NEF-2B | T19
1/4-28 UNF-2B | T19-1

A-55
Retaining Rings for Ring Retained Grommets.

Standard Retaining Ring

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Material</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
<th>Application</th>
<th>Tool</th>
</tr>
</thead>
<tbody>
<tr>
<td>R4G</td>
<td>Steel (Cadmium Plated)</td>
<td>0.06</td>
<td>For use with all ring retained grommets except 40G1 Series</td>
<td>T26</td>
</tr>
<tr>
<td>40G26-1</td>
<td>Eligiloy (Non-Magnetic, Corrosion-Resistant)</td>
<td>0.07</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

High Shear Retaining Ring

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Material</th>
<th>Weight (per 100 pcs.) (lbs.)</th>
<th>Application</th>
<th>Tool</th>
</tr>
</thead>
<tbody>
<tr>
<td>R4T</td>
<td>Alloy Steel (Cadmium Plated)</td>
<td>0.15</td>
<td>For use with 40G1 Series High Shear Grommets only</td>
<td>T39-1</td>
</tr>
</tbody>
</table>

Retaining Ring Installation

1. Place grommet in prepared hole.
2. Place mandrel into grommet.
3. Place retaining ring over mandrel as shown.
4. Push handle over mandrel until sharp ring is fully seated behind shoulder of grommet.

Retaining Ring Installation Tool and Replacement Components.

<table>
<thead>
<tr>
<th>Description</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Complete Installation Tool</td>
<td>T-26</td>
</tr>
<tr>
<td>Rubber Tip</td>
<td>T-26-1</td>
</tr>
<tr>
<td>Mandrel</td>
<td>T-26-2</td>
</tr>
</tbody>
</table>
4002 Series. Panel Preparation and Installation Data (continued)  
For Flare Retained Grommets

Plus Flush Grommets

Form .515-505 mounting hole. Insert grommet into panel and flare using appropriate flaring tools from table at right.

Flush Mounting Grommets

Form .515-505 mounting hole. Countersink with C’Sink tool P/N 4-GC-500. Insert grommet into panel and flare using appropriate flaring tool set from table at right.

Installation Tools

Flaring Tools
Used to flare grommets in place.

<table>
<thead>
<tr>
<th>Tool Part Numbers</th>
</tr>
</thead>
<tbody>
<tr>
<td>Grommet Part No.</td>
</tr>
<tr>
<td>4002-</td>
</tr>
<tr>
<td>4-PF-1</td>
</tr>
<tr>
<td>4-PF-3</td>
</tr>
<tr>
<td>40G15</td>
</tr>
<tr>
<td>40g16</td>
</tr>
</tbody>
</table>

Determine basic part number from table above. Flaring tools are available in a number of shank diameters and shank lengths. Select from table below and list corresponding dash number as a suffix to basic part number.

<table>
<thead>
<tr>
<th>Shank Diameters and Lengths</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dash Number</td>
</tr>
<tr>
<td>-1</td>
</tr>
<tr>
<td>-2</td>
</tr>
<tr>
<td>-3</td>
</tr>
<tr>
<td>-4</td>
</tr>
</tbody>
</table>

Example: To specify Flaring Die P/N 4-PF-1[?], with 5/16" shank diameter and 7/8" shank length, complete the part number with a-3. Completed part number: 4-PF-3.

Countersinking Tool 4GC-500
Forms C’Sink required for Flush Mounting Grommets.

Adaptors for Countersinking Tools
May be used to adapt any C’Sinking tool for use in drill chuck.

<table>
<thead>
<tr>
<th>C’Sink Tool Thread</th>
<th>Adaptor Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>5/16-32NEF-2B</td>
<td>T19</td>
</tr>
<tr>
<td>1/4-28UNF-2B</td>
<td>T19-1</td>
</tr>
</tbody>
</table>
4002 Series. Stud Assembly Installation

Installing Stud Into Panel
4002 Series studs must be used in conjunction with a grommet. (See Page A-51 for grommet selection.) Compress stud assembly spring using Camloc pliers P/N 4P43 as shown. Insert stud through grommet and release when cross pin clears. Studs with dash numbers greater than -15 require retaining rings. These longer studs may be installed without compressing the stud assembly spring (pliers not required).

Retaining Rings

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Material</th>
<th>Maximum Service Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>4002-SW</td>
<td>Spring Steel (Cadmium Plated)</td>
<td>450°F.</td>
</tr>
<tr>
<td>4002-SW-SS</td>
<td>Stainless Steel</td>
<td>700°F.</td>
</tr>
</tbody>
</table>

Retaining Ring Installation
1. To install, place retaining ring on stud with slot aligned over left side of cross pin as shown on figure 1.
2. Snap retaining ring under cross pin using needle nose pliers, then rotate retaining ring 180° until ring is over right side of cross pin as shown on figures 2 and 3.
3. To complete installation, snap retaining ring over the right side of cross pin.
4. Completed installation is shown in figure 4.

Stud Ejector Spring (Optional)
Provides full retraction of stud assembly to allow opening and closing of equipment without the possibility of jamming or damage.

Notes:
1. Thru hole in Ejector Spring Part Numbers 4002SN, SND and SNF is formed to allow grommet to seat flush to top surface of Ejector Spring.
2. When using Stud Ejector Springs, Retaining Ring/Retained style grommets must be used.
3. Maximum Service Temperature: 450°F.
4. Add .021 to total material thickness “G” when using these parts. See Page A-61.
5. Weight per 100 pieces:
   Ejector Spring used with Flush Grommet: 1.64 lbs.
   Ejector Spring used with Plus Flush Grommet: 1.86 lbs.

*Ejector P/N 4002 SNF is flat; i.e. no 4° radius bend.
4002 Series. Sealed Stud and Grommet Installation

40S37 Series stud assembly contains an integral seal which is usually sufficient where only splash-proof installation is required. For more complete sealing the following procedure should be followed.

Grommet Installation
1. Select grommet from the table below.
2. Prepare panel according to standard procedures.
   See table below for page reference.
3. Install gasket onto grommet.
4. Place grommet in prepared hole and complete installation following standard procedure.

<table>
<thead>
<tr>
<th>Grommet/Gasket Selection</th>
<th>Gasket Part Number</th>
<th>A Dia.</th>
<th>Gasket Material</th>
<th>Installation Instructions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flare Retained: 4002-P2-P3</td>
<td>40G11-4</td>
<td>.501</td>
<td>Gasket Material per Fed. Spec. HH-P-96</td>
<td></td>
</tr>
<tr>
<td>40G15, 40G16</td>
<td></td>
<td>.489</td>
<td></td>
<td>See Page A-57</td>
</tr>
</tbody>
</table>

Stud Installation
1. Install gasket P/N 40S39 over stud spring cup.
2. Using 4P3 pliers, install stud into grommet following standard procedures. (See Page A-58.)
3. For studs with dash numbers greater than -15, install retaining ring. For procedures see Page A-58.

Notes:
1. Applications using this assembly are limited by the gasket material to 130°F maximum temperature.
2. Add .045 inch to “G” thickness to compensate for gasket thickness. (See Page A-61.)
3. 40S37 Stud Assemblies are not available with dash numbers smaller than -4.
4002 Series. Receptacle Installation Data

**Standard Mounting Receptacles**
1. Drill #30 (.1285) diameter pilot hole.
2. Drill holes for .125 rivets using drill jig specified.
3. Enlarge pilot hole to X diameter.
4. Rivet receptacle in place.

**Side Mounting Receptacle**

**Snap-in Receptacle (P/N 40R39-1-1AA)**

**Two piece floating receptacles**

**Spot weld attachment**
1. Form through hole to X diameter.
2. Place receptacle element into cage.
3. Locate receptacle assembly on center and spot weld in place.

**Optional Installation Tools**

**Drill Jigs**
Provide convenient means for accurately locating rivet holes relative to receptacle mounting hole.

<table>
<thead>
<tr>
<th>Drill Jig</th>
<th>A</th>
</tr>
</thead>
<tbody>
<tr>
<td>T16</td>
<td>1.00</td>
</tr>
<tr>
<td>T22</td>
<td>1.375</td>
</tr>
</tbody>
</table>

**Hole Saws**
Accurately size mounting holes.

<table>
<thead>
<tr>
<th>Hole Saw</th>
<th>Forms Hole Dia.</th>
</tr>
</thead>
<tbody>
<tr>
<td>HS-687</td>
<td>.687</td>
</tr>
<tr>
<td>HS-812</td>
<td>.812</td>
</tr>
</tbody>
</table>

When using hole saw, first drill #30 (.1285) pilot hole.
4002 Series. Ordering Information/
Stud Dash Number Selection

To Select Stud Dash Number

1. Stud dash number varies with receptacle used.
   This information must be known before proceeding.
   Select receptacle from Pages A-48 through A-50.

2. Determine “G” thickness.

   **Notes:**
   (a) Increase “G” to allow for thickness of paint or
       other finishes and for the compressed thickness
       of any gasket.
   (b) When selecting stud dash number, “G” must be
       increased for the following “Special” conditions.

<table>
<thead>
<tr>
<th>“Special” Conditions</th>
<th>Increase “G” Thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>4002 Series Ejector Spring installed</td>
<td>Add .021 inch</td>
</tr>
<tr>
<td>Snap-in Receptacle (P/N 40R 39-1-1AA)</td>
<td>Allow .020 inch for receptacle top side protrusion.</td>
</tr>
<tr>
<td>40R8 Series Receptacle Shims installed</td>
<td>For each shim used, add an amount equal to “A” max. shim thickness. (See Page a-48)</td>
</tr>
<tr>
<td>Plus Flush Grommets installed</td>
<td>For purposes of selecting stud dash number only, add “D” max. protrusion of grommet. (See Pages A-51 and A-52)</td>
</tr>
<tr>
<td>40S37 Stud Assembly installed with sealing gaskets</td>
<td>Add .045 inch</td>
</tr>
</tbody>
</table>

3. Locate “G” total thickness in the stud dash number table on the following page.
4. Then find the corresponding stud dash number in the column designated for the receptacle selected.

How To Order

Example 1.

Stud Assembly Used: 4002-[?]S
“G” Total Thickness: .220 inch
Grommet Used: 4002-0S (Plus Flush Style)
Receptacle Used: 40R17-1
Required Calculation*: G + .029 = .220 + .029 = .249
Stud Dash Number Selected From Table: -7
Completed Part Number: 4002-7S

*(Plus Flush grommets require that “D” max. dimension from Pages A-51 and A-52 be added to “G” total thickness when determining Stud Dash Number).

Example 2.

Stud Assembly Used: 40S5-[?]
“G” Total Thickness: 1.520 inch
Grommet Used: 4002-P2-625 (Flush Style)
Receptacle Used: 244-16E
Stud Dash Number Selected From Table: -51 (See Note 2, Page A-62)
Completed Part Number: 40S5-51
**Stud Dash Number Selection Table**

**Quick Operating 1/4-Turn Fasteners - 4002 Series**

**Stud Dash Number Selection Table**

<table>
<thead>
<tr>
<th>G Total Thickness</th>
<th>Grommeted Studs</th>
<th>Grommetless Studs</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>All rec. not tab. at right</td>
<td>All 244-16 ex-16B &amp; 16BR</td>
</tr>
<tr>
<td>0.020-050</td>
<td>-</td>
<td>-2</td>
</tr>
<tr>
<td>0.050-090</td>
<td>-</td>
<td>-2</td>
</tr>
<tr>
<td>0.080-110</td>
<td>-</td>
<td>-3</td>
</tr>
<tr>
<td>0.110-140</td>
<td>-</td>
<td>-4</td>
</tr>
<tr>
<td>0.140-170</td>
<td>-</td>
<td>-5</td>
</tr>
<tr>
<td>0.170-200</td>
<td>-</td>
<td>-6</td>
</tr>
<tr>
<td>0.200-230</td>
<td>-</td>
<td>-7</td>
</tr>
<tr>
<td>0.230-260</td>
<td>-</td>
<td>-8</td>
</tr>
<tr>
<td>0.260-290</td>
<td>-</td>
<td>-9</td>
</tr>
<tr>
<td>0.290-320</td>
<td>-</td>
<td>-10</td>
</tr>
<tr>
<td>0.320-350</td>
<td>-</td>
<td>-11</td>
</tr>
<tr>
<td>0.350-380</td>
<td>-</td>
<td>-12</td>
</tr>
<tr>
<td>0.380-410</td>
<td>-</td>
<td>-13</td>
</tr>
<tr>
<td>0.410-440</td>
<td>-</td>
<td>-14</td>
</tr>
<tr>
<td>0.440-470</td>
<td>-</td>
<td>-15</td>
</tr>
<tr>
<td>0.470-500</td>
<td>-</td>
<td>-16</td>
</tr>
<tr>
<td>0.500-530</td>
<td>-</td>
<td>-17</td>
</tr>
<tr>
<td>0.530-560</td>
<td>-</td>
<td>-18</td>
</tr>
<tr>
<td>0.560-590</td>
<td>-</td>
<td>-19</td>
</tr>
<tr>
<td>0.590-620</td>
<td>-</td>
<td>-20</td>
</tr>
<tr>
<td>0.620-650</td>
<td>-</td>
<td>-21</td>
</tr>
<tr>
<td>0.650-680</td>
<td>-</td>
<td>-22</td>
</tr>
<tr>
<td>0.680-710</td>
<td>-</td>
<td>-23</td>
</tr>
<tr>
<td>0.710-740</td>
<td>-</td>
<td>-24</td>
</tr>
<tr>
<td>0.740-770</td>
<td>-</td>
<td>-25</td>
</tr>
<tr>
<td>0.770-800</td>
<td>-</td>
<td>-26</td>
</tr>
<tr>
<td>0.800-830</td>
<td>-</td>
<td>-27</td>
</tr>
<tr>
<td>0.830-860</td>
<td>-</td>
<td>-28</td>
</tr>
<tr>
<td>0.860-890</td>
<td>-</td>
<td>-29</td>
</tr>
<tr>
<td>0.890-920</td>
<td>-</td>
<td>-30</td>
</tr>
<tr>
<td>0.920-950</td>
<td>-</td>
<td>-31</td>
</tr>
<tr>
<td>0.950-980</td>
<td>-</td>
<td>-32</td>
</tr>
<tr>
<td>0.980-1010</td>
<td>-</td>
<td>-33</td>
</tr>
<tr>
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**Important Notes:**
1. 40S37 stud assemblies are not available with dash numbers smaller than -4. 2. If the total thickness “G” is very near the top of the thickness range, selection of the next greater dash number is recommended. For “G” thicknesses longer than those tabulated, contact Camloc Products Division. 3. “G” min. thickness specified on Pages A-51 and A-52 may be reduced .030 inch when column 3 dash numbers apply and .060 inch when column 4 dash numbers apply.
# 4002 Series.
## Weights for Flare Retained Grommets
(Pounds per 100 pieces. All weights are approximate.)

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* Data Table Numbers Correspond to those listed on Page A-53.