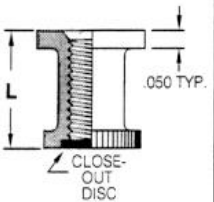
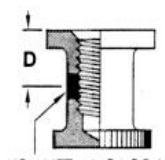
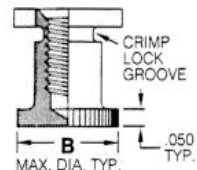
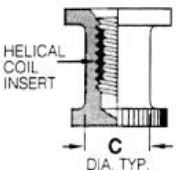
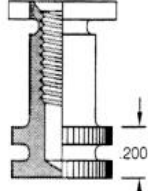
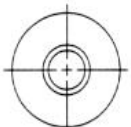
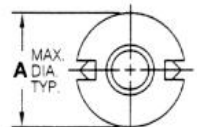


Delron Inserts 400 H, HE Series - Blind Thread

Style Selection

Thread Type	Threaded Only	Non-Metallic Lock	Crimp Lock per MIL-N-25027	Helical Coil Lock per MS21209	
					
Material*	0, 5, 6 or 9	0, 5, 6 or 9	5, 6 or 9	0, 5, 6 or 9	Double Flange on -07 length and up typical - all styles.

*See "Part Number Selection", below, for description of numerical references.

Head Style	H - Standard Flush	HE - Flush with Potting Slots
		

Notes:

1. Burrs permissible at knurled areas and underside of head around potting slots.
2. Adhesive backed installation tabs are furnished with each slotted part. See Table 3.
3. Plated or lubed bolts are recommended for use with self-locking cres inserts.
4. Tolerances, unless otherwise specified: .xxx ± .010; Angles ± 2°.

Table 1

Size	Thread Size Per MIL-S-8879	A Head Dia.	B Flange Dia.	C Body Dia.	D
440	.1120-40 UNJC-3B	.374	.322	.195	.100
632	.1380-32 UNJC-3B	.436	.385	.230	.120
832	.1640-32 UNJC-3B	.499	.447	.290	.120
1032	.1900-32 UNJF-3B	.499	.447	.290	.120
428	.2500-28 UNJF-3B	.561	.510	.353	.140
524	.3125-24 UNJF-3B	.686	.635	.460	.150
624	.3750-24 UNJF-3B	.811	.697	.550	.150

Part Number Selection

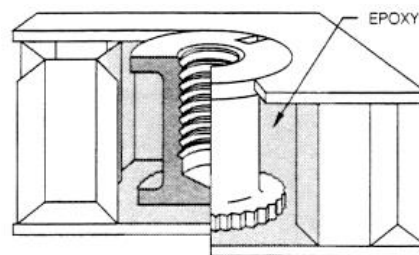
Consult Rosán for availability of optional materials, finishes and sizes.

Example:

4 6 5 HE 428-12

- Length Dash Number: See Tables 2
- Size: See Table 1
- Head Style: H = Standard Flush
HE = Flush With Potting Slots
- Thread Type: 3 = Threaded Only
4 = Non-Metallic Lock
5 = Crimp Lock per MIL-N-25027 (Material 5, 6 or 9 Only)
6 = Self-Locking Helical Coil Insert per MS21209
- Material: 0 = 2024-T4 or T351 Aluminum per QQ-A-225/6, Alodine per MIL-C-5541
5 = A286 CRES per AMS 5731, Passivate per QQ-P-35
6 = 303 CRES per ASTM-A-581/ASTM-A-582, AMS5640, Passivate per QQ-P-35.
9 = Carbon Steel per ASTM-A-108/FED-STD-66 Cadmium Plate per QQ-P-416, Type II, Class 2
- Series 400: Potted-In Type Panel Insert

Typical Assembly



Typical Series 400 HE, Blind Threaded Insert; installed in honeycomb sandwich panel. Insert is held in place by a cured epoxy compound.

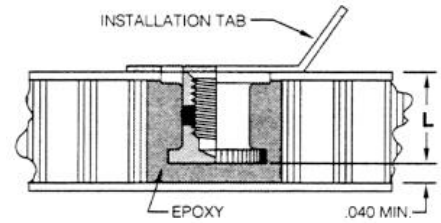
Note: For installation and tooling information, see pages 44 and 45.

400 H, HE Series - continued

Length Dash Number Selection

Select Length Dash Number from Tables 2 based on the minimum full thread length required by the application. Insert length "L" must be a minimum of .040" less than depth of panel core (See Fig. 1).


Fig. 1



Example: 1. Requirements: 832 size, Non-Metallic Lock Thread, 303 CRES, Slotted Head with a Minimum Full Thread Length of .295, and an overall panel thickness of .520.
From table select:
-08 P/N = 464HE832-08

2. Requirements: 440 Size Helical Coil Lock, Carbon Steel, Flush Head, with a Minimum Full Thread Length of .150, and an overall panel thickness of .455.
From table select:
-07 P/N = 496H440-07

Minimum clearance is required between bottom of insert and inside panel skin for proper epoxy bonding around bottom of insert.

 = Minimum Full Thread Length

Tables 2
All Thread Types Except Helical Coil Lock

Length Dash Number	L	Thread Size						
		440	632	832	1032	428	524	624
-04*	.220	.170	.170	.170	.170	-	-	-
-05*	.285	.190	.190	.190	.190	.235	-	-
-06*	.335	.225	.235	.235	.235	.250	-	-
-07	.395	.250	.280	.280	.280	.250	-	-
-08	.455	.250	.280	.330	.330	.330	.320	-
-10	.565	.250	.280	.330	.380	.420	.430	.425
-12	.690	.250	.280	.330	.380	.500	.550	.550
-14	.815	.250	.280	.330	.380	.500	.625	.625
-16	.935	.250	.280	.330	.380	.500	.625	.750

*Close out disc required to provide minimum full thread.

Helical Coil Lock Types

Length Dash Number	L	Thread Size						
		440	632	832	1032	428	524	624
-06	.335	.112	-	-	-	-	-	-
-07	.395	.168	.138	-	-	-	-	-
-08	.455	.224	.207	.164	.190	-	-	-
-10	.565	.224	.276	.246	.285	.250	-	-
-12	.690	.224	.276	.328	.380	.375	.312	-
-14	.815	.224	.276	.328	.380	.500	.469	.375
-16	.935	.224	.276	.328	.380	.500	.469	.562

Installation Tabs

Adhesive backed installation tabs are supplied with all 400 HE Series Inserts, unless otherwise specified. The tabs are coded by insert thread size as listed in Table 3.

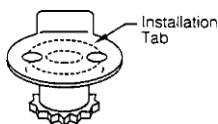


Table 3

Thread Size	Installation Tab Number
440	T16
632	T21
832	T4
1032	T4
428	T6
524	T9
624	T11

