

REV.	DATE	BY-CHKD	REVISIONS	I		II	III	SCREW ASS'Y PART NUMBER
				MIN.	MAX.	MAX. OUTER PANEL THICKNESS	MINIMUM DISTANCE INNER SURFACE OF PANEL TO INNER SURFACE OF FRAME FOR FULL SCREW RETRACTION	
G	04MAY2005	BRP/RLR	PRN: 2005-0410					
H	09OCT2007	GDW/JSS	PRN: 2007-1265					09-XX-302-XX

TO SELECT A SCREW ASSEMBLY:

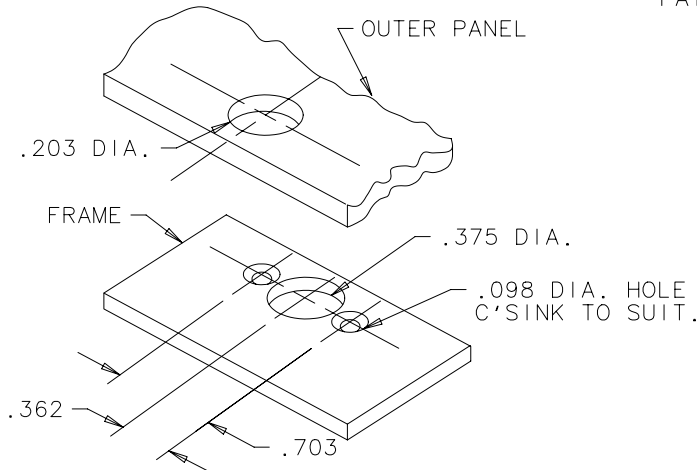
- MEASURE YOUR TOTAL GRIP (OR GRIP RANGE, IF THE SAME SIZE SCREW IS TO BE USED IN SEVERAL APPLICATIONS). TOTAL GRIP IS THE DISTANCE FROM THE OUTER SURFACE OF THE PANEL TO THE INNER SURFACE OF THE FRAME (PANEL PLUS FRAME PLUS SPACE CREATED BY GASKETS, FLANGES, ETC.).
- SELECT FROM COLUMN I THAT GRIP RANGE WHICH MOST CLOSELY BRACKETS YOUR GRIP REQUIREMENT.
- CHECK COLUMN II TO MAKE SURE THAT YOUR OUTER PANEL THICKNESS DOES NOT EXCEED THE MAXIMUM LISTED.
- IF FULL SCREW RETRACTION (COMPLETE DISENGAGEMENT OF THE SCREW FROM THE RECEPTACLE WITHOUT LIFTING OF THE OUTER PANEL) IS DESIRED, CHECK COLUMN III. THE DISTANCE FROM THE INNER SURFACE OF THE PANEL TO THE INNER SURFACE OF THE FRAME, DIMENSION "A", MUST NOT BE LESS THAN THE MINIMUM LISTED.

TO CAPTIVATE SCREW ASSEMBLY IN OUTER PANEL:

- PLACE SCREW ASSEMBLY INTO PANEL AND THREAD RETAINING WASHER TO THE POSITION BEHIND THE THREAD OF THE SCREW.
- PLACE SOUTHCO SET TOOL (PART NO.09-50-101-11) OVER SCREW. BACK -UP BEHIND SCREW HEAD FOR SOLIDNESS. STRIKE SET TOOL A SHARP BLOW TO FLATTEN WASHER. WASHER MAY BE FLATTENED BY HOLDING SET TOOL AGAINST WASHER AND STRIKING HEAD OF SCREW WITH RAWHIDE OR LEAD MALLET.

PAT. 3,892,031

COLUMN III IN ABOVE TABLE IS BASED ON THE FOLLOWING FORMULA:
SCREW WILL RETRACT FULLY IF DISTANCE FROM INNER SURFACE OF PANEL TO INNER SURFACE OF FRAME PLUS .202 IS EQUAL TO OR GREATER THAN THE THREAD LENGTH OF THE SCREW (DIMENSION "B" ON SCREW DRAWING).



HOLE PREPARATION

