

NT-136

TABLE I								REF: TABLE II SHANK CODE
TMC CODE FOR THD SIZE	THREAD SIZE	RECOMMENDED HOLE SIZES		A MAX.	B MIN.	C MAX.	D MIN.	DASH NUMBERS AVAILABLE AS STANDARD
		MAX.	MIN.					
256	2-56NC-2B	.135	.133	.190	.068	.132	.025	1 - 2 - 3 - 4
440	4-40NC-2B	.167	.165	.252	.087	.164	.030	1 - 2 - 3 - 4
632	6-32NC-2B	.220	.217	.315	.107	.216	.035	1 - 2 - 3 - 4
832	8-32NC-2B	.271	.268	.344	.126	.267	.041	1 - 2 - 3 - 4
1024	10-24NC-2B	.271	.268	.344	.146	.267	.050	2 - 3 - 4
1032	10-32NF-2B							
420	1/4-20UNC-2B	.355	.352	.439	.191	.351	.065	4 - 5 - 6
428	1/4-28UNF-2B							
518	5/16-18UNC-2B	.411	.408	.534	.237	.407	.076	4 - 5 - 6 - 7
524	5/16-24UNF-2B							
616	3/8-16UNC-2B	.475	.472	.627	.292	.471	.097	5 - 6 - 7
624	3/8-24UNF-2B							
813	1/2-13UNC-2B	.612	.609	.815	.378	.608	.128	5 - 6 - 7
820	1/2-20UNF-2B							

SHANK CODE	TABLE II PLATE THICKNESS		E MAX.
	MIN.	MAX.	
1	.020	.031	.018
2	.032	.039	.030
3	.040	.055	.038
4	.056	.090	.054
5	.091	.122	.087
6	.123	.184	.120
7	.185	UP	.180

TABLE III RECOMMENDED ASSEMBLY PRESSURE			
NOMINAL SIZE	INSTALLATION PRESSURE LBS.	AVERAGE PUSH-OUT LBS.	AVERAGE TORQUE-OUT INCH PDS.
#2	1000-2000	190	13
#4	1500-2500	210	25
#6	2000-3000	275	45
#8	4000-5000	440	70
#10	4000-5000	440	120
1/4	5000-6000	675	270
5/16	6000-7000	810	475
3/8	7000-8000	1420	800
1/2	11000-12000	1680	1750

**NOTE:**  
The mounting hole may be drilled, reamed or punched, but correct hole tolerance must be observed to assure proper anchoring of the nut. Locking feature as per MIL-N-25027.

**FINISH:**  
Cadmium Plate Per QQ-P-416, Type 1; Class 3.

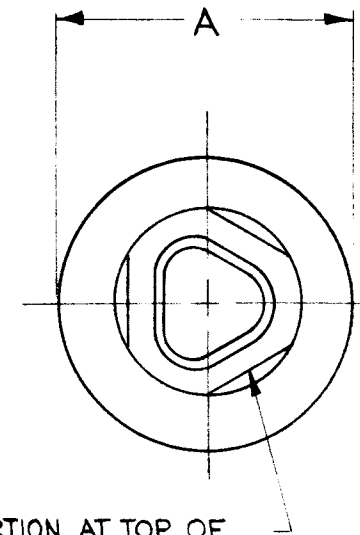
TMC PART NO. TO BE IN FOLLOWING FORM.

NT-136-832-7

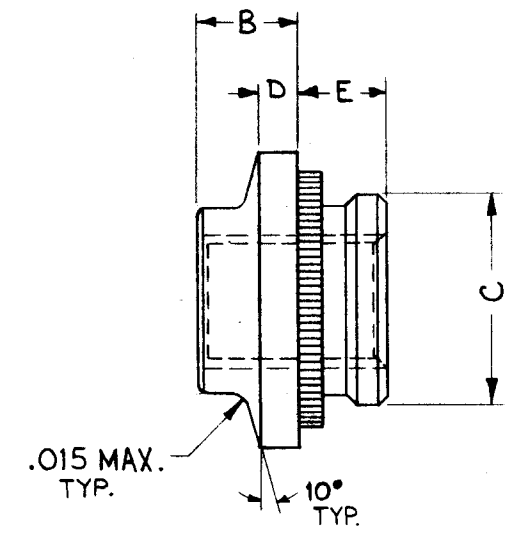
BASIC PART NO.      THREAD SIZE CODE. USE TABLE I.      SHANK CODE USE TABLE II

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 MAMARONECK, NEW YORK



DISTORTION AT TOP OF NUT DUE TO LOCKING FEATURE PERMISSIBLE.



**For Purchasing Information Only:**

Part No. - The SPS Part No. consists of "SNL" plus the dash number plus the shank code.  
 Example: - SNL-420-5 (SPS - Swage Nut, Self Locking 1/4-20 size w/ .087 shank length for use in .091-.122 plate.)

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	STEEL	NUT, ROUND, SWAGE TYPE SELF LOCKING.	
	MATERIAL		
.30 CARBON (MIN)	Rc .32 MIN.		
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKER
SEE NOTE			
FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
	UNLESS OTHERWISE SPECIFIED:					
	DIMENSIONS ARE IN INCHES					
	TOLERANCES ON FRACTIONS ± 1/64    DECIMALS ± .005    ANGLES ± 1/2°					
	SCALE: (S-401-21)					
	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					
	REQ. PER UNIT					
	MODEL					
	SECTION					
	ASS'Y. NO.					
	DATE					
	USED ON					