

SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 32 MICROINCHES. OTHER SURFACES 125 MICROINCHES. GRIT BLASTED SURFACES 125 TO 250 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	26	28	30	32
L	.250	.375	.500	.625	.750	.875	1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000

STUD MATERIAL AND FINISH DATA

NOTE: 304 CRES TRIM WASHER ON C, E, AND G CODE STUDS

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
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
CRA	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700
T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, OR 4967	NONE	

THREAD DATA

CODE	THREAD SIZE	TD DIA
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
5	.3125-24 UNJF-3A	.3020-.3060

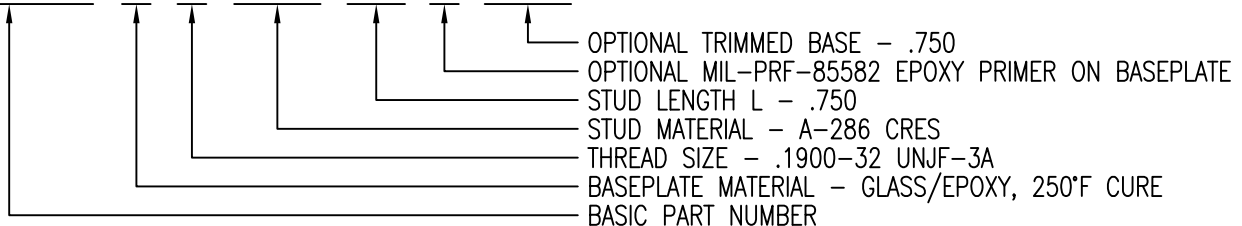
BASEPLATE MATERIAL

CODE	MATERIAL	SPEC.
C	CARBON/EPOXY, 350°F CURE	CBMS-105
E	GLASS/EPOXY, 350°F CURE	CBMS-106
G	GLASS/EPOXY, 250°F CURE	CBMS-107
P	GLASS/PEEK	CBMS-103
U	30% GLASS/PEI	CBMS-102
UC	30% CARBON/PEI	CBMS-109
V	40% GLASS/PEI	CBMS-101
VC	40% CARBON/PEI	CBMS-108

MANUFACTURER'S OPTION: REDUCED MAJOR DIA TD

EXAMPLE PART NUMBER

CB4000 G 3 CRA 12 P 750



OPTIONAL TRIMMED BASE - .750
 OPTIONAL MIL-PRF-85582 EPOXY PRIMER ON BASEPLATE
 STUD LENGTH L - .750
 STUD MATERIAL - A-286 CRES
 THREAD SIZE - .1900-32 UNJF-3A
 BASEPLATE MATERIAL - GLASS/EPOXY, 250°F CURE
 BASIC PART NUMBER

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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CLICK BOND

CARSON CITY
 NEVADA 89706

CAD CB4000-1

APPROVALS	DATE
DRAWN <i>DAC</i>	5SEP13
CHECKED <i>DAC/mtm</i>	31MAY18
RELEASED <i>CGH</i>	31MAY18
REVISED <i>DAC</i>	31MAY18

TITLE
 STUD, COMPOSITE BASE, ADHESIVE BONDED

ANGLES	±1°
.XX	±.03
.XXX	±.010
.XXXX	±.001

SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB4000	23
SCALE	1/1	31MAY18	SHEET 1 OF 2

