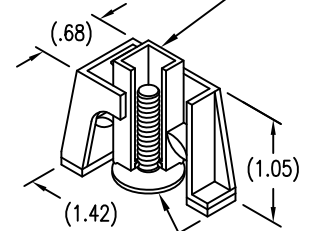


DISPOSABLE PRESSURE SENSITIVE ADHESIVE FIXTURE HOLDS STUD WHILE ADHESIVE CURES.



STUD ATTACHED BY ADHESIVE APPLIED TO THIS SURFACE.

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 L IN SIXTEENTHS OF AN INCH)

CODE	4	6	8	10	12	14	16	18	20	22	24
L	.250	.375	.500	.625	.750	.875	1.000	1.125	1.250	1.375	1.500

MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA	ALUMINUM		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, 4967	NONE	

THREAD DATA

CODE	THREAD SIZE	TD DIA
04	.1120-40 UNJC-3A	.1065-.1085
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

OPTIONAL BASEPLATE PRIMER

CODE	MATERIAL SPEC.
P	MIL-PRF-85582 EPOXY PRIMER
W	CBPS-211 FILM PRIMER

MANUFACTURER'S OPTION: REDUCED MAJOR DIA TD

EXAMPLE PART NUMBER

CB5000 CRA 3-12 P

OPTIONAL BASEPLATE PRIMER
 STUD LENGTH L - .750
 THREAD SIZE - .1900-32 UNJF-3A
 STUD MATERIAL - A-286 CRES
 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.

PROPRIETARY PARTS SHOWN IN THIS DRAWING ARE THE SUBJECT OF ISSUED UNITED STATES AND FOREIGN PATENTS AND PATENTS PENDING. UNAUTHORIZED REPRODUCTION AND/OR DISTRIBUTION OF THIS DRAWING IS SPECIFICALLY PROHIBITED.

CLICK BOND

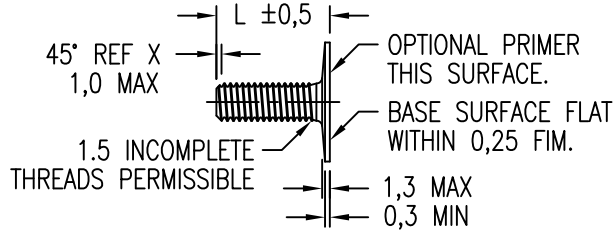
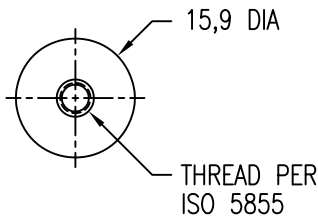
CARSON CITY
NEVADA 89706

CAD CB5000-1

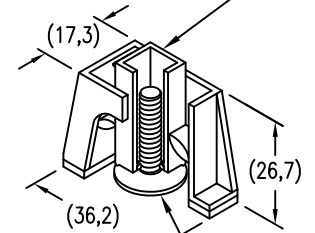
APPROVALS	DATE
DRAWN RJT	3JAN12
CHECKED <i>JAC</i>	3JAN12
RELEASED <i>ABC</i>	3JAN12
REVISED RJT	3JAN12

TITLE
STUD, SMALL BASE, ADHESIVE BONDED

SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB5000	19
SCALE	1/1		3JAN12
SHEET			1 OF 2



DISPOSABLE PRESSURE SENSITIVE ADHESIVE FIXTURE HOLDS STUD WHILE ADHESIVE CURES.



STUD ATTACHED BY ADHESIVE APPLIED TO THIS SURFACE.

SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 0,8 MICROMETERS. OTHER SURFACES 3,2 MICROMETERS. GRIT BLASTED SURFACES 3,2 TO 6,3 MICROMETERS.

STUD STRAIGHT WITHIN 0,004 mm PER mm OF LENGTH. PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN 0,5 FIM. PITCH DIA PERPENDICULAR TO BASE WITHIN $\pm 1^\circ$.

LENGTH L DATA (LENGTH L IN MILLIMETERS)

CODE	6M	8M	10M	12M	15M	20M	25M	30M	35M
L	6	8	10	12	15	20	25	30	35

MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA	ALUMINUM		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, 4967	NONE	

THREAD DATA

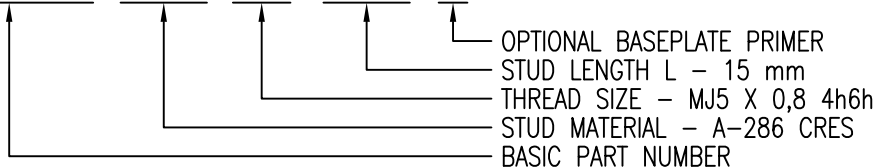
CODE	THREAD SIZE
3M	MJ3 X 0,5 4h6h
4M	MJ4 X 0,7 4h6h
5M	MJ5 X 0,8 4h6h
6M	MJ6 X 1,0 4h6h

OPTIONAL BASEPLATE PRIMER

CODE	MATERIAL SPEC.
P	MIL-PRF-85582 EPOXY PRIMER
W	CBPS-211 FILM PRIMER

EXAMPLE PART NUMBER

CB5000 CRA 5M 15M P



UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN MILLIMETERS AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

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CARSON CITY
NEVADA 89706

CAD CB5000-2 METRIC DIMENSIONS	
ANGLES	$\pm 1^\circ$
.X	$\pm 0,8$
.XX	$\pm 0,25$

APPROVALS	DATE
DRAWN RJT	3JAN12
CHECKED <i>[Signature]</i>	3JAN12
RELEASED <i>[Signature]</i>	3JAN12
REVISED RJT	3JAN12

TITLE STUD, SMALL BASE, ADHESIVE BONDED			
SIZE A	CAGE CODE 66530	DWG. NO. CB5000 (METRIC)	REV. 19
SCALE 1/1	3JAN12	SHEET 2 OF 2	