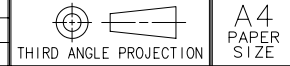
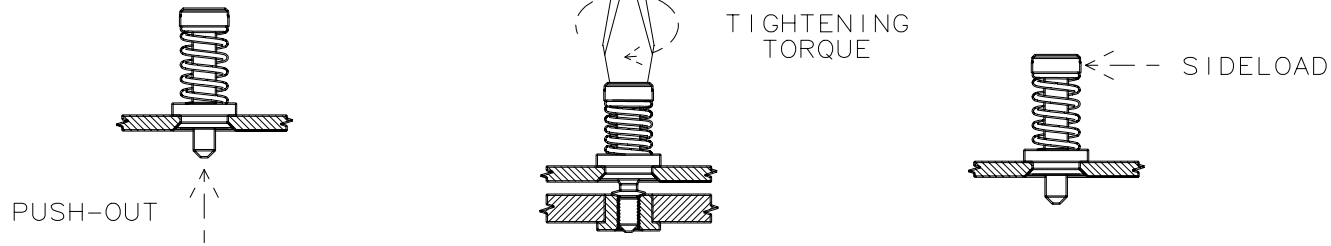


REV	DATE	DRAWN/CHKD	DESCRIPTION
A	07APR2006	MJS/MDY	ADDED 4-40 SCREW TO TABLE



SOUTHCO PERFORMANCE GUIDELINES  
 THE PERFORMANCE GUIDELINES SHOWN ON THIS PAGE ARE SUPPLIED AS A GENERAL GUIDE ONLY, AS CONDITIONS VARY WITH EACH APPLICATION AND METHOD OF INSTALLATION. STRENGTH DATA GIVEN IS FOR FAILURE OF THE PRODUCT OR FOR SUFFICIENT DEFORMATION TO MAKE THE PRODUCT INOPERABLE. NO SAFETY FACTOR HAS BEEN APPLIED. IT IS RECOMMENDED THAT THE USER REQUEST A PRODUCT SAMPLE FOR TESTING TO DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURPOSE INTENDED AND USER'S PARTICULAR APPLICATION.



ASSEMBLY PART NUMBER	SCREW SIZE	RECOMMENDED INSTALLATION FORCE N (lbf)	AVERAGE PUSH-OUT FORCE N (lbf) ②	RECOMMENDED TIGHTENING TORQUE N <sub>cm</sub> (lbf <sub>in</sub> ) ③	AVERAGE ULTIMATE TIGHTENING TORQUE N <sub>cm</sub> (lbf <sub>in</sub> ) ④	AVERAGE ULTIMATE SIDELOAD FORCE N (lbf) ⑤
5T-AA-06-222-K	6-32	2200(500)	400 (90)	110 (9.6)	285 (25)	540 (121)
5T-AA-M3-222-K	M3	2200(500)	495(111)	60(5.2)	313 (27)	490 (110)
5T-AA-04-222-K	4-40	2200(500)	422(95)	60(5.2)	403 (36)	490 (110)

1. ALL ASSEMBLIES WERE INSTALLED AND TESTED IN 1.5mm (.060in) THICK ALUMINUM PANELS.
2. FAILURE OCCURED IN THE SCREW PUSHING OUT OF THE ASSEMBLY OR THE ASSEMBLY PUSHING OUT OF THE PANEL.
3. REFERENCE - ASSEMBLY ENGINEERING MASTERS CATALOG;VOL. 10, 1971(C)HITCHCOCK PUBLISHING CO.
4. M3/4-40 ASSEMBLIES BROKE ABOVE THE COLLAR WHILE 6-32 HAD THE RECESS STRIP OUT AND NOT BREAK.
5. ENTIRE ASSEMBLY RELEASED FROM PANEL.

SAMPLES TESTED TO ASTM B117 SALT FOG TEST PROCEDURE LASTED A MINIMUM OF 144 HOURS BEFORE OCCURANCE OF RED RUST.