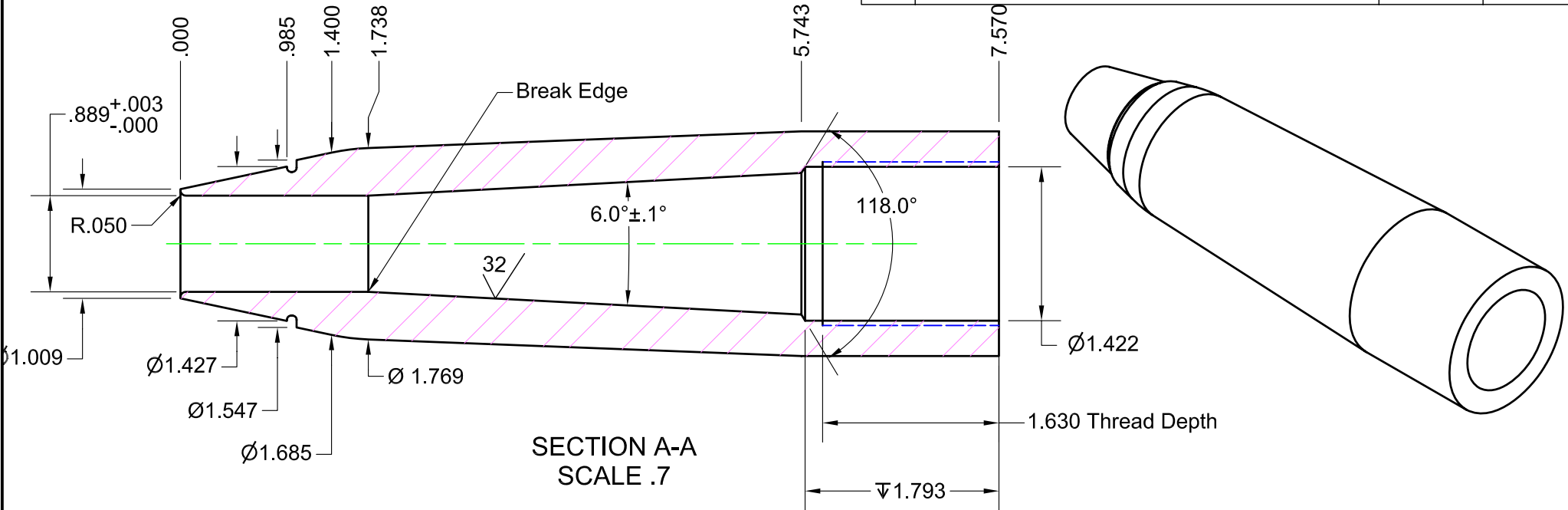
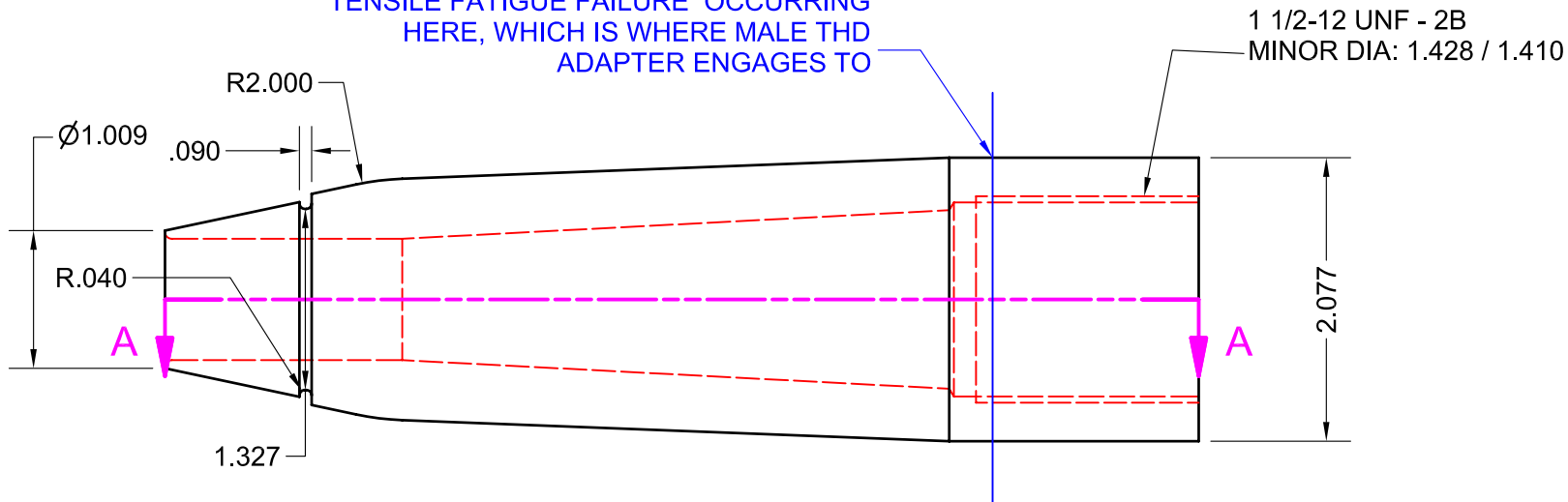


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

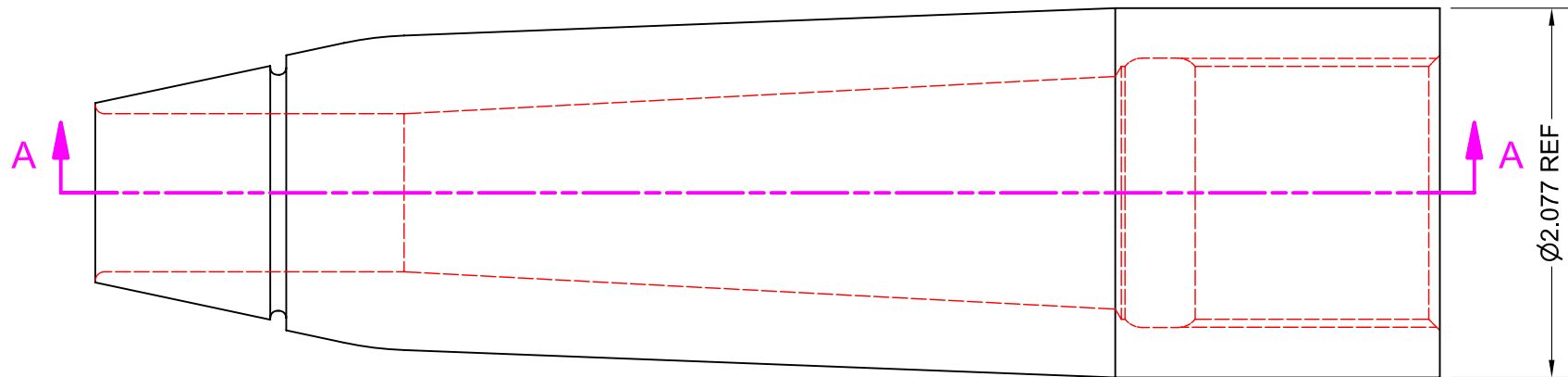
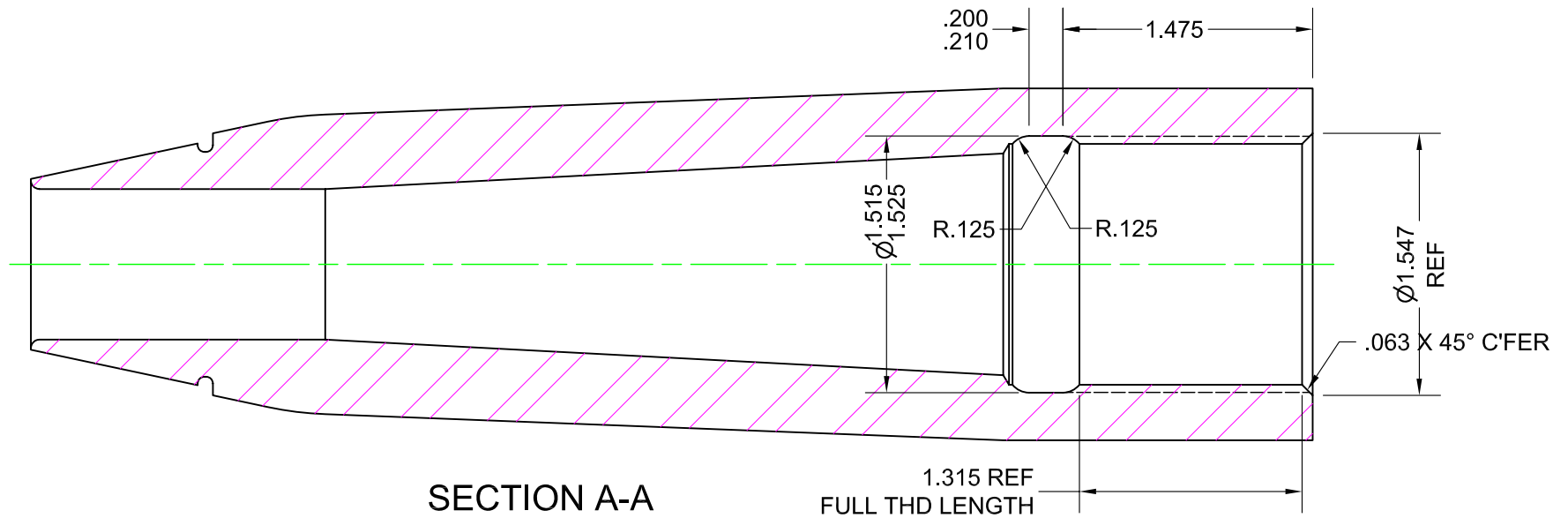


TENSILE FATIGUE FAILURE OCCURRING
HERE, WHICH IS WHERE MALE THD
ADAPTER ENGAGES TO



MATERIAL Titanium 6AL-4V		TOLERANCES: 0.XX = ± 0.010" 0.XXX = ± 0.005" FRACTIONS = ± 1/64" ANGLES = ± 1/2'	DESIGNED BY: MJC	DRAWN BY: MJC	APPROVED BY:	DATE: 8/23/2011	SCALE:
FINISH - DEBURR, BREAK ALL EDGES, SURFACE FINISH RMS 32 UNLESS SPECIFIED					Carbon Socket -91 Size		
A-SIZE	Any designs or drawings produced by Navtec Inc. and transmitted to a second party are the property of Navtec Inc. and are to be considered confidential and are to be used only for the purpose for which they were transmitted.				R531-06-09148	REVISION	SHEET 1 OF 1

MAKE FROM R531-06-09148 SOCKETS
ADD FEMAL THREAD RELIEF AND CHAMFER TO EXISTING SOCKETS



A-SIZE

Any designs or drawings produced by Navtec Inc. and transmitted to a second party are the property of Navtec Inc. and are to be considered confidential and are to be used only for the purpose for which they were transmitted.

TOLERANCES:
0.XX = ± 0.010 "
0.XXX = ± 0.005 "
FRACTIONS = $\pm 1/64$ "
ANGLES = $\pm 1/2^\circ$

DESIGNED BY:
CSF

CHECKED BY:
CSF

APPROVED BY:
CSF

DATE:
1/10/2012

SCALE:
1 : 1

NAVTEC[®]

Rigging SolutionsSM

-91 TITANIUM SOCKET - TEST

R531-06-09148 Test

REVISION

SHEET
1 OF 1



Ring of failure point on -91 titanium socket (Test #1), failed at 104k cycles



Ring of failure point on -91 titanium socket (Test #1), failed at 104k cycles



Ring of failure point on -91 titanium socket (Test #2), failed at 96k cycles



Photo of inside intact socket from opposite end of Test #2 sample, went 96k cycles