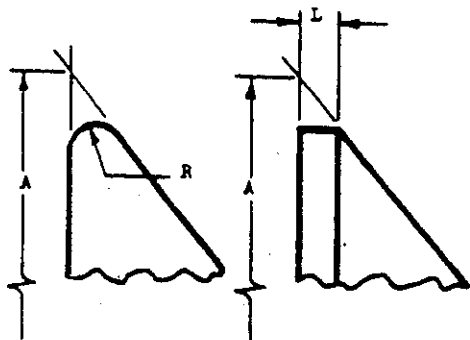
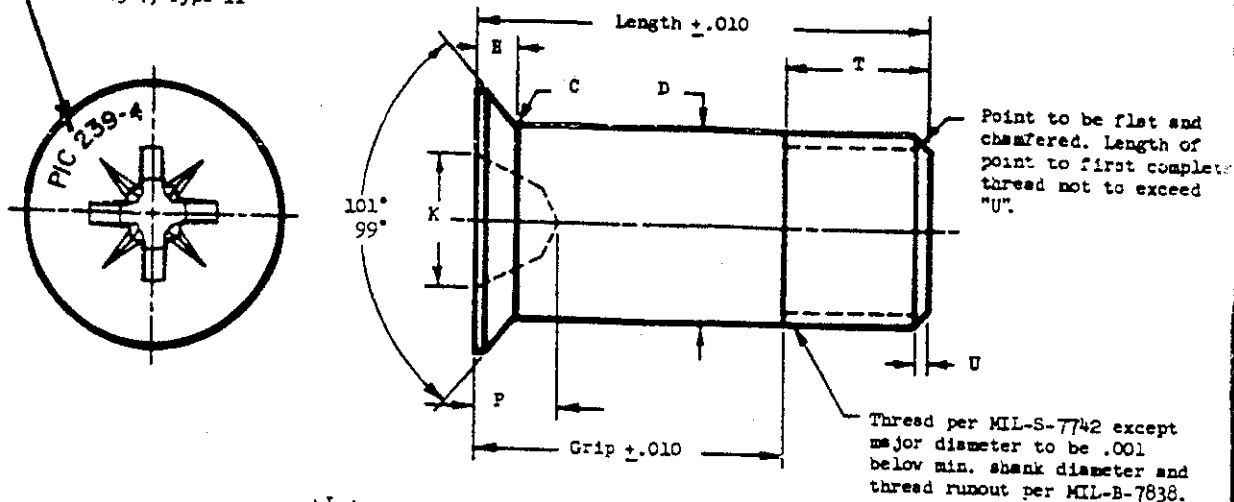


Head Marking per
NAS 1347, Type II



OPTIONAL HEAD
ENLARGED VIEW

BASIC PART NO.	THREAD	A THEO DIA.	D DIA.		C RAD.	H REF.	K DIA.	L	P MAX.	R MAX.	T REF.	U REF.	(F) MIN. TORQUE IN/LBS	Z (b)	Rec. Pen.	Rec. end bit size
			BEFORE PLATE	AFTER PLATE												
PIC239-3	10-32UNF-3A	.3016 .2966	.1887 .1881	.1895 .1885	.020 .010	.046	.169 .156	.015 .005	.101	.010	.276	.062	50	.0040	.086 .068	2
PIC239-4	1/4-28UNF-3A	.3948 .3898	.2487 .2481	.2495 .2485	.020 .010	.060	.184 .171	.015 .005	.116	.010	.316	.071	90	.0030	.101 .083	2
PIC239-5	5/16-24UNF-3A	.4739 .4689	.3112 .3106	.3120 .3110	.025 .010	.067	.247 .234	.015 .005	.135	.011	.375	.083	175	.0030	.114 .096	3
PIC239-6	3/8-24UNF-3A	.5604 .5554	.3737 .3731	.3745 .3735	.030 .015	.077	.317 .304	.015 .005	.172	.013	.391	.083	250	.0025	.145 .127	4
PIC239-7	7/16-20UNF-3A	.6680 .6620	.4362 .4356	.4370 .4360	.030 .015	.096	.342 .329	.022 .005	.196	.015	.453	.100	550	.0025	.170 .152	4
PIC239-8	1/2-20UNF-3A	.7540 .7480	.4987 .4981	.4995 .4985	.030 .015	.105	.366 .353	.022 .005	.221	.017	.453	.100	900	.0020	.194 .176	4
PIC239-9	9/16-18UNF-3A	.8380 .8310	.5607 .5601	.5615 .5605	.030 .015	.114	.393 .380	.025 .005	.248	.019	.511	.110	1440	.0020	.222 .204	4
PIC-239 -10	5/8-18UNF-3A	.9250 .9180	.6232 .6226	.6240 .6230	.030 .015	.125	.409 .396	.025 .005	.265	.021	.543	.110	1600	.0020	.238 .220	4

(F) Listed Values to be verified in production

CUSTODIAN:

PROCUREMENT
SPECIFICATION

NOTED
NOTED

NOTICE

This drawing embodies a proprietary design owned by Phillips Screw Company. It is provided under a conditional license for a specific purpose and the recipient agrees to use it only for such purpose. All patent, trademark and other claims in and to this drawing and design are expressly reserved by Phillips Screw Company, Phillips, Mass.

TITLE

SHEAR BOLT 100° FLAT RIVET HEAD
POZ+DRIV CLOSE TOLERANCE SHORT THREAD

DATE
L.P. & J.C.

DATE
8-16-66

PART NUMBER

DATE
L.P.

DATE
8-19-66

PIC 239

SHEET 1 OF 3

MATERIAL ALLOY STEEL PER NAS 498

HEAT TREATMENT 160,000-180,000 PSI UTS PER MIL-B-6875

FINISH CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 3. TYPE 1 PLATING DESIGNATED BY "W," SEE CODE.

CODE DASH NUMBER DESIGNATES GRIP AND LENGTH.
"W" AFTER DASH NUMBER DESIGNATES TYPE I PLATING.

EXAMPLE PIC239 - 4 - 8 = 1/4 DIA BOLT, .500 GRIP, TYPE II PLATING
PIC239 - 5 - 10 = 5/16 DIA BOLT, .625 GRIP, TYPE II PLATING
PIC239 - 5 - 10W = 5/16 DIA BOLT, .625 GRIP, TYPE I PLATING

NOTES

- (a) CONCENTRICITY
CONICAL SURFACE OF HEAD AND "D" DIAMETER
WITHIN .005 TIR.
RECESS TO SHANK WITHIN .016 TIR TIRU 1/4 SIZE
WITHIN .024 TIR ABOVE 1/4 SIZE
- (b) SHANK STRAIGHTNESS WITHIN "Z" VALUES TIR PER
INCH OF LENGTH
- (c) GRIP LENGTH FROM THE TOP OF HEAD TO END OF
FULL CYLINDRICAL PORTION OF SHANK
- (d) POZ-I-DRIV BOLTS SHALL WITHSTAND MINIMUM TORQUE
VALUES LISTED WITHOUT DAMAGE TO RECESS OR DRIVER
- (e) BOLTS SHALL BE FREE FROM BURRS AND SHARP EDGES

DIMENSIONS IN INCHES

PROCUREMENT SPECIFICATIONS NAS 498

CUSTODIAN:

PROCUREMENT
SPECIFICATION

NOTED

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REVISED:

A 1-19-79

C

D

TITLE:

SHEAR BOLT 100° FLAT RIVET HEAD
POZ-I-DRIV CLOSE TOLERANCE SHORT THREAD

DRAWN
L. P. & J. C.

DATE
8-17-66

PART NUMBER

PIC 239

CHECKED:

L.P.

DATE
8-19-66

SHEET 2 OF 3

PHILLIPS INTERNATIONAL CO. - Natick, Mass.

Div. of Phillips Screw Co.