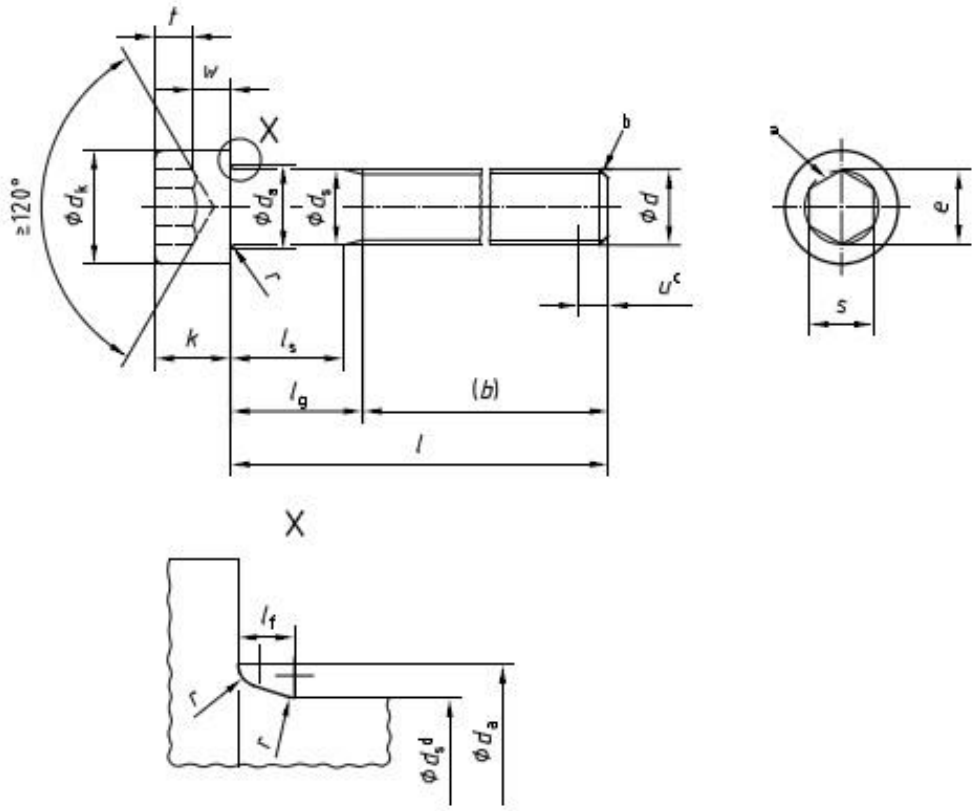
REV. NEW

KSP900912

■ DIMENSIONS

Voir Figure 1 et Tableau 1.

Les symboles et désignations des dimensions sont spécifiés dans l'ISO 225.



Raccordement sous tête maximal

$l_{f,\,max} = 1{,}7\, r_{max}$

$r_{max} = \frac{d_{a,\,max} - d_{s,\,max}}{2}$

r_{min}, voir Tableau 1

REV. "NEW" FIRST ISSUE.

DRAWN	DATE	SCREW, HEXAGON SOCKET HEAD CAP SCREW	STANDARD PART	
CHECKED	DATE		KSP900912	REV. NEW
CHECKED	DATE			
APPROVED	DATE		GEO-KOMPSAT PROGRAM	SHEET 1 OF 5

REV. NEW
KSP900912

Filetage (d)		M3	M4	M5	M6	M8
P[a]		0,5	0,7	0,8	1	1,25
b[b]	réf.	18	20	22	24	28
d_k	max.[c]	5,50	7,00	8,50	10,00	13,00
	max.[d]	5,68	7,22	8,72	10,22	13,27
	min.	5,32	6,78	8,28	9,78	12,73
d_a	max.	3,6	4,7	5,7	6,8	9,2
d_s	max.	3,00	4,00	5,00	6,00	8,00
	min.	2,86	3,82	4,82	5,82	7,78
e[e, f]	min.	2,873	3,443	4,583	5,723	6,863
l_f	max	0,51	0,6	0,6	0,68	1,02
k	max.	3,00	4,00	5,00	6,0	8,00
	min.	2,86	3,82	4,82	5,7	7,64
r	min.	0,1	0,2	0,2	0,25	0,4
s[f]	nom.	2,5	3	4	5	6
	max.	2,58	3,08	4,095	5,14	6,14
	min.	2,52	3,02	4,020	5,02	6,02
t	min.	1,3	2	2,5	3	4
v	max.	0,3	0,4	0,5	0,6	0,8
d_w	min	5,07	6,53	8,03	9,38	12,33
w	min.	1,15	1,4	1,9	2,3	3,3

l_g			Longueur de tige lisse l_s et longueur de serrage l_g									
			l_s	l_g	l_s	l_g	l_s	l_g	l_s	l_g	l_s	l_g
nom.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.
2,5	2,3	2,7										
3	2,8	3,2										
4	3,76	4,24										
5	4,76	5,24										
6	5,76	6,24										
8	7,71	8,29										
10	9,71	10,29										
12	11,65	12,35										

16	15,65	16,35										
20	19,58	20,42										
25	24,58	25,42	4,5	7								
30	29,58	30,42	9,5	12	6,5	10	4	8				
35	34,5	35,5			11,5	15	9	13	6	11		
40	39,5	40,5			16,5	20	14	18	11	16	5,75	12
45	44,5	45,5					19	23	16	21	10,75	17
50	49,5	50,5					24	28	21	26	15,75	22
55	54,4	55,6							26	31	20,75	27
60	59,4	60,6							31	36	25,75	32
65	64,4	65,6									30,75	37
70	69,4	70,6									35,75	42
80	79,4	80,6									45,75	52
90	89,3	90,7										
100	99,3	100,7										
110	109,3	110,7										
120	119,3	120,7										
130	129,2	130,8										
140	139,2	140,8										
150	149,2	150,8										

- MATERIAL : STAINLESS STEEL, GRADE 12.9

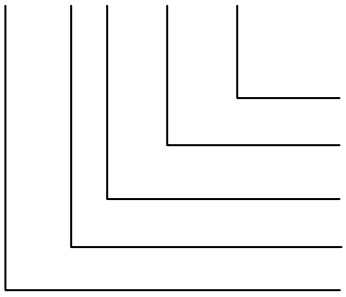
- FINISH : PASSIVATE IN ACCORDANCE WITH AMS-QQ-P-35 AND
  SOLID FILM LUBRICANT(EVERLUBE 620C)
  IN ACCORDANCE WITH KPR9-0902-5-1.

■ COC REQUIREMENTS

Subject	Test	Reference	Requirement	No. of Specimen
Dimensional	Visual Inspection	ECSS-Q-ST-70-46C	Microscope (X 15)	all
	Thread	ECSS-Q-ST-70-46C	Thread Gage	all
	Dimension	ECSS-Q-ST-70-46C	Measurement	all
	Surface Roughness	ECSS-Q-ST-70-46C	Visual Inspection	all
Mechanical	Tensile Test Shear Test	ECSS-Q-ST-70-46C	YS > 950MPa UTS > 1100MPa	3EA per LOT
	Hardness Test	ECSS-Q-ST-70-46C	HrC 33~42	3EA per LOT
Metallurgical	Head Structure /Grain Flow	ECSS-Q-ST-70-46C or ASTM E112	Grain flow have to be continuous (Machining processing have to be avoided)	3EA per LOT
NDI	RT(Radiographic Test) Fluorescent Penetrant	ECSS-Q-ST-70-46C	No micro crack	80EA per LOT
optional	Fatigue test (if possible)	ECSS-Q-ST-70-46C	> 65,000 cycle	3EA per LOT

■ PART NUMBER EXAMPLE :

KSP900912 - M 10 x 32 – 12.9



GRADE

LENGTH IN METRIC

SCREW SIZE

METRIC

BASIC PART NUMBER(DIN 912 or ISO 4762)

KSP900912-M10x32-12.9 = M5 SCREW, HEXAGON SOCKET HEAD CAP SCREW, 32MM LONG, SOLID FILM LUBRICANT.

- IDENTIFICATION : PARTS MUST BE BAGGED AND TAGGED WITH PART NUMBER, MANUFACTURER AND DATE PER KPR12-6-0900.

- NOTES : UNLESS OTHERWISE SPECIFIED,
  1. DIMENSIONS IN METRICS.
  1. APPLY SOLID FILM LUBRICANT IN ACCORDANCE WITH KPR9-0902-5-1 AFTER PASSIVATE IN ACCORDANCE WITH AMS-QQ-P-35.
     IF THE PASSIVATED SCREW PROCURED, IT CAN BE APPLIED SOLID FILM LUBRICANT IN ACCORDANCE WITH KPR9-0902-5-1 AFTER CLEANING IN ACCORDANCE WITH KPR2-8-3-1, KPR2-22-35 OR KPR2-22-49.

- ENGINEERING INFORMATION (REFERENCE) : THESE PARTS ARE BASICALLY EQUIVALENT PART WITH DIN 912(ISO 4762) EXCEPT FOR SOLID FILM LUBRICANT.

- PROCUREMENT INFORMATION : PARTS MAY BE PROCURED INITIALLY UNDER DIN NUMBER AND REPROCESSED AS REQUIRED TO COMPLY WITH KSP CODING, OR MAY BE PROCURED AS COMPLETELY FINISHED KSP PARTS.