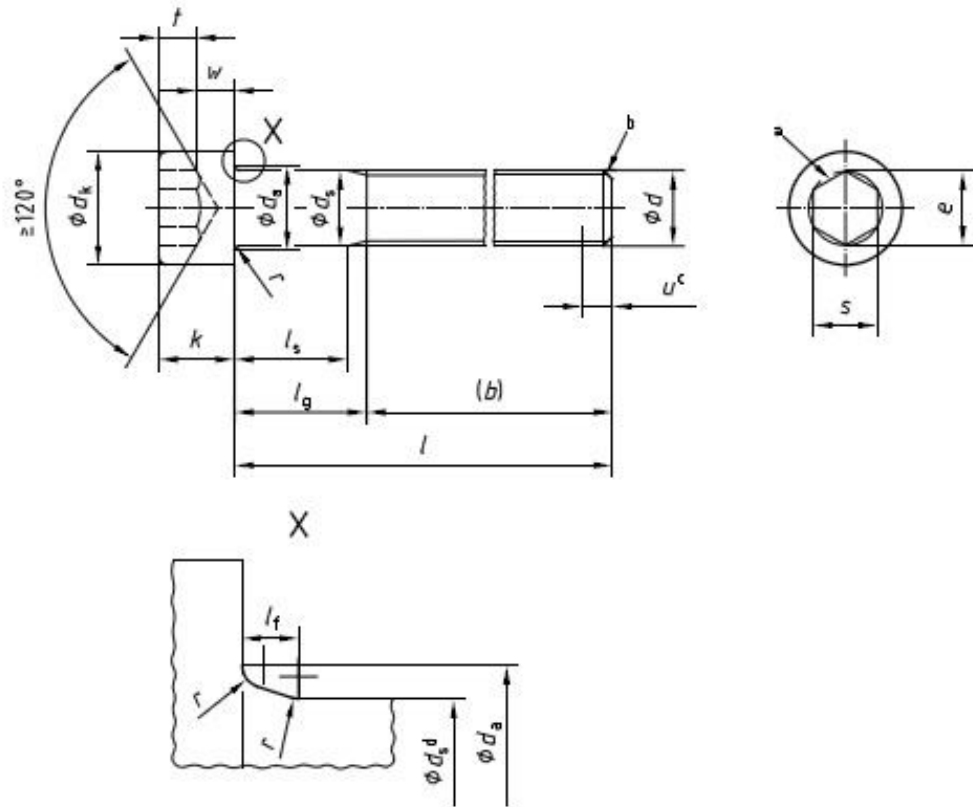


REV. NEW
KSP900912

■ DIMENSION

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

Fig. 1 Configuration of Fastener

REV. "NEW" FIRST ISSUE.

DRAWN	DATE	FULLY THREADED TITANIUM HEXAGONAL SOCKET HEAD CAP SCREW	STANDARD PART	
CHECKED	DATE		KSP900912	REV. NEW
CHECKED	DATE			
APPROVED	DATE		GEO-KOMPSAT PROGRAM	SHEET 1 OF 7

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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									
nom.	min.	max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g 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										

STANDARD PART	
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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											

- CONFIGURATION : FULL THREAD FASTENER ($l_s = 0$) AS SHOWN IN Fig. 1.
- MATERIAL : TITANIUM(6Al-4V) IN ACCORDANCE WITH AMS4928 or AMS4967.
- FINISH : PASSIVATE IN ACCORDANCE WITH AMS2487 or AMS2488 AND
SOLID FILM LUBRICANT(MOLYKOTE 106 or EQUIVALENT)



<SCREW WITH PASSIVATION AND SOLID FILM LUBRICANT>

STANDARD PART	
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GEO-KOMPSAT PROGRAM	SHEET 3 OF 7

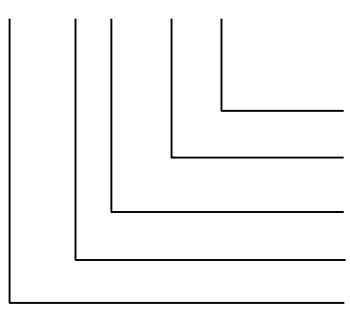
REV. NEW
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- COC REQUIREMENT: CONDUCT VERIFICATION TEST WITH SAMPLES AND SUBMIT ITS TEST REPORT AS SHOWN IN THE FOLLOWING EXAMPLE.

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 - 5



GRADE
LENGTH IN METRIC
SCREW SIZE
METRIC
BASIC PART NUMBER(DIN 912 or ISO 4762)

KSP900912-M10x32-5 = M10 SCREW, HEXAGON SOCKET HEAD CAP SCREW, 32MM LONG, SOLID FILM LUBRICANT.

STANDARD PART	
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REV. NEW
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- 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.
 2. 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.
- FASTENER TYPE AND NUMBER OF FASTENER

L/I	TYPE	NUMBER
1	M4x10	1000
2	M4x12	150
3	M4x14	300
4	M4x16	20
5	M4x20	200
6	M4x26	50
7	M4x28	20
8	M4x32	20
9	M4x44	20
10	M5x12	50
11	M5x16	30

STANDARD PART	
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12	M5x18	30
13	M5x20	80
14	M5x22	200
15	M5x24	30
16	M5x26	70
17	M5x42	150
18	M6x14	170
19	M6x16	50
20	M6x18	60
21	M6x20	280
22	M6x22	280
23	M6x24	10
24	M6X28	70
25	M6X30	450
26	M6x40	20
27	M6x46	370
28	M6x50	300
29	M6x52	50
30	M6x54	10
31	M6x56	10
32	M6x62	20
33	M8x14	30
34	M8x24	70
35	M8x26	20
36	M8x30	10
37	M8x32	80
38	M8x36	10
39	M8x46	120

STANDARD PART	
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REV. NEW
KSP900912

40	M8x52	100
41	M8x56	20
42	M10x32	10
43	M10x50	10
44	M10x56	10
TOTAL		5060

■ DELIVERY TIME

1. FOR M5, M6, M8 SCREWS – 16 WEEKS AFTER RECEIPT OF ORDER
2. FOT M4, M10 SCREWS – 20 WEEKS AFTER RECEIPT OF ORDER

STANDARD PART	
KSP900912	REV. NEW
GEO-KOMPSAT PROGRAM	SHEET 7 OF 7