Company Background
Stake Fastener Company, an operating division of Dupree, Inc., specializes in the design and manufacture of unique and novel special application color-matched fasteners. Our first products, introduced in the 1950s, were designed for specific aircraft/aerospace applications. Stake Fastener products continue to be found on all major aircraft in service today, as well as in other sectors of the transportation industry such as buses, trucks, trains, and agricultural equipment. Our products are also widely used on electronic instruments, medical and telecommunications devices, and rack-mounted equipment.

Manufacturing Capabilities
Designs are conceived, engineered, tooled, manufactured, assembled, stored, and shipped from our 60,000 sq. ft facility in Chino, California. We have expertise in cold heading, screw machine work, threading, injection molding, and coating processes, and work with customers on a global scale, shipping our products worldwide.

Quality
Stake Fastener Company’s quality management system (QMS) is ISO 9001:2015 and AS9100:2016 registered, enabling us to maintain close control over our manufacturing processes. Our business systems, inventory management, and quality system are fully integrated with an ERP platform, making this information seamless and accessible.

Summary
We welcome all inquiries for similar items not shown in this catalog and enjoy working with designers and engineers to propose recommendations for their particular application needs. Customers are also always welcome to speak with us in person. We have facilities with room to grow.

Note on RoHS Compliancy:
Products that are RoHS-compliant are labeled as such throughout this catalog. RoHS is the Restriction of Hazardous Substances Directive, which restricts the use of certain hazardous sub-

How To Order: Orders may be placed by email, telephone, fax or mail. Call (909) 597-4889, 8:30 a.m.- 4:30 p.m. Pacific Time, Monday through Friday or fax us at (909) 597-3043. To email an order, send it to sales@stakefastener.com.

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PAN-L-SCREWS
Screws with Captive Decorative Nylon Washer, Color-Matched Screw & Washer

PAN-L-SCREWS are pan head screws with a colored head and captive nylon washer molded in matching color. High tensile steel screws are used to provide maximum resistance to screwdriver damage.

Colored coating material on the screw head withstands normal abrasion, chipping and solvent action. The combination of a hardened base surface and the adhesive qualities of the coating material assure retention of quality appearance after repeated use.

The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment. PAN-L-SCREWS, color-matched to the equipment, blend with the background to eliminate distraction from the information being displayed on the panels.
### FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

### NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and stock colors listed in the forward section of this catalog are carried in stock to assure short lead times. Lengths not listed are also available on order.
4. For color-coated screw less washer, omit the letter P from the head type code.

### SPECIFICATIONS:
1. Screws meet all requirements of NAS600 series, including thread size .086-56 and .216-24 which are not listed as part of the NAS specification.
2. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2.
3. Threads are in conformance with MIL-S-8879, except parts with thread codes “2C” & “12C” which are IAW MIL-S-7742.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
### FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

### NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order. Length code designates nominal length in 1/16-inch increments (for example, length code 8 = 1/2-inch long screw).
4. For color-coated screw less washer, omit the letter P from the head type code.

### SPECIFICATIONS:

1. Screws meet all requirements of NAS600 series, including thread size,.086-.56 and .216-24 which are not listed as part of the NAS specification, except for plating requirements.
2. Plating: Zinc plate IAW ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-compliant.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order. Length code designates nominal length in 1/16-inch increments (for example, length code 8 = 1/2-inch long screw).
4. For color-coated screw less washer, omit the letter P from the head type code.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
6. Screws head coating and washer colors are matched to customer-furnished color chips or samples. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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<td>8</td>
<td>.625 .232 .057</td>
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**TYPICAL APPLICATION:**
Securing panels and rack mounted equipment.
**FEATURES:**

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, which increases the basic tensile strength of the corrosion resistant steel by 25%. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

**NOTES:**

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and stock colors listed in the forward section of this catalog are carried in stock to assure short lead times. Lengths not listed are also available on order.
4. For color-coated screw less washer, omit the letter P from the head type code.

**SPECIFICATIONS:**

1. Screws meet all requirements of MS51957 (UNC-2A) and MS51958 (UNF-2A).
2. Screws are stocked passivated per SAE-AMS2700.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066. Natural (translucent) washer is furnished with polished head screw.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

---

**TABLE:**

<table>
<thead>
<tr>
<th>HEAD TYPE</th>
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<td>.112-40 UNC-2A</td>
<td>4 5 6 7 8 9 10 12 14 16</td>
<td>CRES</td>
<td>A 0.312 B 0.117 D 0.037</td>
<td></td>
</tr>
<tr>
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<td>.138-32 UNC-2A</td>
<td>4 5 6 7 8 9 10 12 14 16</td>
<td>CRES</td>
<td>A 0.375 B 0.137 D 0.040</td>
<td></td>
</tr>
<tr>
<td>8C</td>
<td>.164-32 UNC-2A</td>
<td>5 6 7 8 9 10 12 14 16</td>
<td>CRES</td>
<td>A 0.438 B 0.158 D 0.043</td>
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<tr>
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<td>.190-24 UNC-2A</td>
<td>6 7 8 9 10 12 14 16 20</td>
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<td>CRES</td>
<td>A 0.625 B 0.232 D 0.057</td>
<td></td>
</tr>
</tbody>
</table>

---

**TYPICAL APPLICATION:**

Securing panels and rack mounted equipment.

---

**STAKE FASTENER CO.**

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FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates bending and yield of the substrate under the coating material.
4. The thermostetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:
1. TORX® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.
3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. For color-coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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PART NO. EXAMPLE: PS 10F 10 DT S07BL = PAN-L-SCREW .190-32 X 5/8" LG, ALLOY STEEL, TORX® RECESS, SEMI-GLOSS BLUE PER FED-STD-595 NO. 25109

HEAD TYPE | THREAD | L | LENGTH | +.00 | -.03 | +.00 | -.06 | MATERIAL | COLOR CODE | DIM DATA ±.020
--- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | 2C .086-56 UNC-2A | 3 | 4 | 5 | 6 | 7 | 8 | | | | | | | | | | | 250 | .086 | .034 | T8 |
| | 4C .112-40 UNC-2A | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 14 | 16 | | | | | | | | | | 312 | .117 | .037 | T10 |
| | 6C .138-32 UNC-2A | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 14 | 16 | | | | | | | | | | 375 | .137 | .040 | T15 |
| | 8C .164-32 UNC-2A | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 14 | 16 | | | | | | | | | | 438 | .158 | .043 | T20 |
| | 10F .190-32 UNF-2A | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 14 | 16 | 18 | 20 | | | | | | | | | | 500 | .179 | .046 | T25 |
| | 12C .216-24 UNC-2A | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 14 | 16 | 18 | 20 | | | | | | | | | | 562 | .201 | .050 | T27 |
| | 14C .250-20 UNC-2A | 8 | 9 | 10 | 11 | 12 | 14 | 16 | 18 | 20 | | | | | | | | | | 625 | .232 | .057 | T30 |

SEE STOCK COLOR LIST Doc No. SCL870115
PART NO. EXAMPLE: PS 10F 8 ZRT L46GY = PAN-L-SCREW .190-32 X 1/2" LG, STEEL, RoHS ZINC, TORX® RECESS, LUSTERLESS GRAY PER FED-STD-595 NO. 36270

FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:
1. TORX® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.
3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. For color-coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
4. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

REV 06-2014

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FEATURES:
1. CPS remains captive to the panel when the panel is removed.
2. CPS is color-matched with the mounting surface which eliminates distraction from the information display by blending with the background.
3. Allows up to .06 inch circular mismatch of panel clearance hole alignment with fixed threads in hardware plate.
4. The one piece screw and washer simplifies handling, installation and removal of attachment hardware.
5. May be installed and removed without use of special tools, or damage to either the host panel or the CPS.
6. Screw head is finished with a durable color coating that is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
7. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
8. CPS is recommended for use with Type BA or BB pressure displacement STAKE FASTENERS.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material.

SPECIFICATIONS:
1. The screw head dimensions & recess are based on NAS601 series. The screw material is heat treated alloy steel, 4037, 4140, 4340 or 8740.
2. Screws and captive metal washer are cadmium plated per QQ-P-416, Type II (yellow), Class 2 or zinc plated per ASTM B633, Type II (yellow) Class SC2
4. CPS is suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
7. Captivated metal washer is plated steel.
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aids entry of the Pan-L-Screw where hole misalignment could cause problems.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thicknesses. Refer to ASME B18.6.3 Appendix for details.
4. These Pan-L-Screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
5. These Pan-L-Screws are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
6. Inventory of all sizes listed in the table and colors listed in the forward section of this catalog are carried in stock to assure prompt deliveries. Lengths not listed are also available on order.
7. For color-coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:
1. Screws are in accordance with ASME Standard No. B18.6.3. Recessed Head Tapping Screws, Type AB.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

TYPICAL APPLICATION:
SECURING PANELS AND RACK MOUNTED EQUIPMENT

PART NO. EXAMPLE: PS 10SM 10 D S04GN = PAN-L-SCREW, SHEET METAL, 10-16 X 5/8" LG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS GREEN PER FED-STD-595 NO. 24300

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ZINC PLATING ON THIS PART SERIES IS BEING PHASED OUT IN FAVOR OF AN RoHS-COMPLIANT ZINC
FEATURES:

1. The one-piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aids entry of the Pan-L-Screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material.
3. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thicknesses. Refer to ANSI B18.6.4, Appendix VI.
4. These Pan-L-Screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
5. These Pan-L-Screws are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
6. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
7. For color-coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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PAN-L-SCREW
COLORED HEAD, SHEET METAL THREAD, STEEL, RoHS-COMPLIANT ZINC
FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.

2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.

3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.

6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.

7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.

8. Type 'AB' thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the Pan-L-Screw where hole misalignment could cause problems.

NOTES:

1. Torx® is a registered trademark of Camcar Textron.

2. The screws listed in this series reflect high quality with emphasis on the forming of the Torx® recess to meet design specification.

3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

4. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thickness. Refer to ASME B18.6.3, Appendix for details.

5. These Pan-L-Screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.

6. These Pan-L-Screws are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.

7. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

8. For color-coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB, except for recess.

2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.

3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.

4. Screw head coating and washer color are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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PAN-L-SCREW, SHEET METAL, 8-18 X 1/2" LG, STEEL, TORX® RECESS, SEMI-GLOSS BEIGE PER FED-STD-595 NO. 27722

PART NO. EXAMPLE: PS 8SM 8 DT S15BG = PAN-L-SCREW, ZINC PLATING ON THIS PART SERIES IS BEING PHASED OUT IN FAVOR OF AN RoHS-COMPLIANT ZINC
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type ‘AB’ thread style offers a fine pitch thread with a sharp gimlet point which aids entry of the Pan-L-Screw where hole misalignment could cause problems.

NOTES:
1. Torx® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the Torx® recess to meet design specification.
3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mistraining and subsequent damage to the drive recess and coating material.
4. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thickness. Refer to ANSI B18.6.4, Appendix VI.
5. These Pan-L-Screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
6. These Pan-L-Screws are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
7. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
8. For color-coated screw less washer, omit the letter P from the head type code.

SPECIFICATIONS:
1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB, except for recess.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer color are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. The drill point Pan-L-Screw drills a hole, taps, and fastens in steel up to 7/32" thick in one operation. In addition, better thread engagement and a tighter fit to the workpiece is realized since the screw produces the optimum hole size.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These Pan-L-Screws are primarily intended for application in steel up to 7/32" thick or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. For color-coated screw less washer, omit the letter W from the head type code.

SPECIFICATIONS:
1. Screws are in accordance with SAE Standard J78-1979, Self-Drilling Tapping Screws, Type BSD with Style 2 Point.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer color are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
**FEATURES:**

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. The drill point Pan-L-Screw drills a hole, taps, and fastens in steel up to 7/32” thick in one operation. In addition, better thread engagement and a tighter fit to the workpiece is realized since the screw produces the optimum hole size.

**NOTES:**

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These Pan-L-Screws are primarily intended for application in steel up to 7/32” thick or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
5. For color-coated screw less washer, omit the letter W from the head type code.

**SPECIFICATIONS:**

1. Screws are in accordance with SAE Standard J78-1979, Self-Drilling Tap-Ping Screws, Type BSD with Style 2 Point.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer color are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.

2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.

3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.

6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.

7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

4. For color-coated screw less washer, order head type code “MSP”.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.7M.

2. Screws are alloy steel and are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.

3. Pan-L-Screws are suitable for applications with temperatures up to 250°F.

4. Washer color is achieved by molding with pigmented nylon per ASTM D4066.

5. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
4. For color-coated screw less washer, order head type code "MSP".

SPECIFICATIONS:
1. Screws are in accordance with ANSI/ASME Standard No. B18.6.7M.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
4. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
5. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
4. For color-coated screw less washer, order head type code "MSP".

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.7M.
2. Screws are 300 series corrosion resistant steel and are stocked passivated.
3. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
4. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
5. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

| HEAD TYPE | THREAD | L | LENGTH | MATERIAL | COLOR CODE | DIM DATA
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METRIC PAN-L-SCREW, M5 X 0,8mm THREADS X 10mm LG, CORROSION RESISTANT STEEL, PHILLIPS DRIVE, SEMI-GLOSS BROWN PER FED-STD-595 NO. 20140
FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Torx® recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.
4. For color-coated screw less washer, order head type code “MSP”.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.7M, except for the Torx® recess.
2. Screws are 300 series corrosion resistant steel and are stocked passivated.
3. Pan-L-Screws are suitable for applications with temperatures up to 250°F.
4. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
5. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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Screws With Captive Washer, Color-Matched

This series of screws offers many of the same features as PAN-L-SCREWS and is intended for applications requiring both flush-mounted hardware and a low profile washer. Such applications include attaching hollow-core honeycomb colored panels in the crew station and interior of aircraft, attaching fabric-covered interior panels such as those found in aircraft interiors, special-purpose vehicles, and similar applications.
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
5. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
6. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and colors listed in the forward section of this catalog are carried in stock to assure prompt deliveries.

SPECIFICATIONS:
1. Screws with Material code “D” meet all requirements of NAS600 series, including thread size .086-56 which is not listed as part of the NAS specification. Screws covered on this document with other than Material code “D” meet all requirements of NAS600 series, except for plating requirements.
2. Plating:
   Code “D”: cadmium plated in accordance with QQ-P-416, Type II, Class 2.
3. Threads are in conformance with MIL-S-8879 and H-28 Federal Handbook for threads, except parts with thread code “2C” which are in accordance with MIL-S-7742.
4. Screw lengths are expressed in code for 1/16-inch increments. Lengths not listed in above table may be specified. Contact factory to determine availability.
5. These screw/washer assemblies are suitable for applications with temperatures up to 250°F.
6. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
7. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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SCREW / FLAT WASHER
COLORED PAN HEAD w/CAPTIVE NYLON FLAT WASHER, MACHINE THREAD, ALLOY STEEL

REV 06-2014 3-1
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
5. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
6. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

SPECIFICATIONS:
1. Screws meet all requirements of NAS600 series except for plating (see spec #2), including thread size .086-56 which is not listed as part of the NAS specification.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
4. These screw/washer assemblies are suitable for applications with temperatures up to 250°F.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

PART NO. EXAMPLE: SCFW 6C 12 ZR S09BG = PAN HEAD SCREW w/CAPTIVE NYLON FLAT WASHER, .138-32 X 3/4" LG, STEEL, RoHS ZINC, PHILLIPS DRIVE, SEMI-GLOSS BEIGE PER FED-STD-595 NO. 23522

<table>
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<tr>
<th>HEAD TYPE</th>
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TYPICAL APPLICATION: SECURING INSTRUMENTS WITH LIMITED SPACE TO DASH PANELS
**FEATURES:**
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the corrosion resistant steel by 25%. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
5. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the panel.
6. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the panel surface by the compression of the nylon washer.

**NOTES:**
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate marring and subsequent damage to the drive recess and coating material.
3. Inventory of all sizes listed in the table and colors listed in the forward section of this catalog are carried in stock to assure prompt deliveries. Lengths not listed are also available on order.

**SPECIFICATIONS:**
1. Screws are corrosion resistant steel (CRES) and meet all requirements of MS51957 (UNC-2A) and MS51958 (UNF-2A).
2. Screws are stocked passivated per SAE-AMS-2700.
4. Screw lengths are expressed in code for 1/16-inch increments. Lengths not listed in above table may be specified, however, contact factory to determine availability.
5. Washer color is achieved by molding with pigmented nylon per ASTM D4066. Natural (translucent) washer is furnished with polished head screw.
6. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

**TYPICAL APPLICATION:**
Securing instruments with limited space to dash panels.

---

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**PART NO. EXAMPLE:** SCFW 6C 12 CP S05BN = PAN HEAD SCREW w/CAPTIVE NYLON FLAT WASHER, .138-32 X 3/4” LG, COR. RES. STEEL, PHILLIPS DRIVE, SEMI-GLOSS BROWN PER FED-STD-595 NO. 20372
FEATURES:

1. Screws are furnished with captive nylon sealing washer. When installed in recommended clearance hole this assembly provides a liquid-tight seal.

2. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

3. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.

4. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws with material code CP meet all requirements of MS24693. Material is 300 series corrosion resistant steel. Screws are passivated per SAE-AMS-2700. Screws of this material have a class 2A thread fit per FED-STD-H28/2.

2. Screws with material code D meet all requirements of NAS514. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2. Screws of this material have a class 3A thread fit per MIL-S-8879.

3. Washer color matches screw head color and is achieved by molding with pigmented nylon per ASTM D4066.

4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

5. For an assembly with uncoated screw and natural colored sealing washer, order color code N02NA.
### FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type ‘AB’ thread style offers a fine pitch thread with a sharp gimlet point which aids entry of the screw where hole misalignment could cause problems.

### NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These screw assemblies are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
4. These screw assemblies are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
5. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

### SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.6.4, Recessed Head Tapping Screws, Type AB.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

### TYPICAL APPLICATION:

SECURING UPHOLSTERY-COVERED PANELS

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**PART NO. EXAMPLE:** OHCW 4SM 10 D S01YE = 82° OVAL HEAD SCREW w/CAPTIVE NYLON WASHER, SHEET METAL, 4-24 X 5/8” LG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS YELLOW PER FED-STD-595 NO. 26555

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**UPHOLSTERY SCREW**
COLORED 82° OVAL HEAD w/CAPTIVE NYLON WASHER,
SHEET METAL THREAD, STEEL
FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type ‘AB’ thread style offers a fine pitch thread with a sharp gimlet point which aids entry of the screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. These screw assemblies are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.
4. These screw assemblies are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.
5. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

CAGE 12324 sales@stakefastener.com
FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.

2. Attachment hardware, color-matched with the mounting surface eliminates distraction by blending with the background.

3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

4. The thermostetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.

6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.

7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.

8. Type ‘AB’ thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. These screw assemblies are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.

4. These screw assemblies are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.

5. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB.

2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.

3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.

4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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SF®
UPHOLSTERY SCREW
COLORED 82° OVAL HEAD
w/CAPTIVE LARGE O.D. NYLON WASHER,
SHEET METAL THREAD, STEEL

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TYPICAL APPLICATION:
SECURING UPHOLSTERY-COVERED PANELS

PART NO. EXAMPLE: OHCWL 4SM 6 D S42GY = 82° OVAL HEAD SCREW w/CAPTIVE LARGE O.D. NYLON WASHER, SHEET METAL, 4-24 X 3/8” LG, STEEL, PHILLIPS DRIVE, SEMI-GLOSS GRAY PER FED-STD-595 NO. 26622

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FEATURES:

1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.

2. Attachment hardware, color-matched with the mounting surface eliminates distraction by blending with the background.

3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

4. The thermostetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.

6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.

7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.

8. Type ‘AB’ thread style offers a fine pitch thread with a sharp gimlet point which aides entry of the screw where hole misalignment could cause problems.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. These screw assemblies are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.

4. These screw assemblies are primarily intended for application in light sheet metal, plywood, certain plastics or material similar in composition where frequent removal is not necessary. They are not recommended for installation into brittle materials.

5. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB.

2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.

3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.

4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachement hardware, color-matched with the mounting surface eliminates distraction by blending with the background.
3. Screw heads are formed by cold forging, followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The nylon washer provides a resilient cushion to protect the finished surface of panels and equipment.
6. A self-locking feature to prevent vibration from loosening the screw is achieved by the compression effect of the nylon washer between the screw head and the mounting surface.
7. A seal for moisture, low pressure gases and vapors can be affected between the screw head and the mounting surface by the compression of the nylon washer.
8. Type ‘AB’ thread style offers a fine pitch thread with a sharp gimlet point which aids entry of the screw where hole misalignment could cause problems.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

SPECIFICATIONS:
1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Washer color is achieved by molding with pigmented nylon per ASTM D4066.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The metal washer provides a low profile bearing surface to protect the finished surface of panels and equipment.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:
1. Screw material is heat treated alloy steel. Washer material is low carbon steel.
2. Screws are stocked cadmium plated per QQ-P-416, Type II, Class 2.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The metal washer provides a low profile bearing surface to protect the finished surface of panels and equipment.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:
1. Screw material is heat treated alloy steel. Washer material is low carbon steel.
2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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TYPICAL APPLICATION: SECURING COMPOSITE PANELS

100° FLAT HEAD SCREW w/CAPTIVE METAL WASHER, .190-32 X 5/8” LG, ALLOY STEEL, RoHS ZINC, PHILLIPS DRIVE, SEMI-GLOSS RED PER FED-STD-595 NO. 21105

PART NO. EXAMPLE: FCM 10F 10 ZR S03RD = 100° FLAT HEAD SCREW w/CAPTIVE METAL WASHER, .190-32 X 5/8” LG, ALLOY STEEL, RoHS ZINC, PHILLIPS DRIVE, SEMI-GLOSS RED PER FED-STD-595 NO. 21105

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COLOR CODE: A = ZR STEEL PHILLIPS DRIVE B = SEE STOCK COLOR LIST C = DOC NO. SCL870115 D = .00 - .03
FEATURES:
1. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.
2. Attachment hardware, color-matched with the mounting surface eliminates distraction from the information display by blending with the background.
3. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
4. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
5. The metal washer provides a low profile bearing surface to protect the finished surface of panels and equipment.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material.

SPECIFICATIONS:
1. Screw and washer material is 300 series corrosion resistant steel (Cres).
2. Screws and washers are passivated per SAE-AMS-2700.
4. Screw head coating and washer colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

TYPICAL APPLICATION:
SECURING COMPOSITE PANELS

PART NO. EXAMPLE: FCM 10F 14 CP S13BN = 100° FLAT HEAD SCREW w/CAPTIVE METAL WASHER, .190-32 X 7/8" LG, COR. RES. STEEL, PHILLIPS DRIVE, SEMI-GLOSS BROWN PER FED-STD-595 NO. 20122

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<tr>
<td>FCM</td>
<td>10F</td>
<td>.190-32</td>
<td>4 5 6 7 8</td>
<td>CP</td>
<td>CRES PHILLIPS DRIVE</td>
<td>A .75  B .23  C .41  D .15</td>
</tr>
</tbody>
</table>

1. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

3. The one piece screw and captive washer simplifies handling, installation and removal of attachment hardware.

REV 06-2014
Decorative Color-Coated Screws

Stake Fastener Co. offers industry standard fasteners with color-coated heads. This series of screws, including flat head, oval head and button head, combine the same features of high tensile strength material with the durable thermosetting coating material and colors as used for PAN-L-SCREWS. The thermosetting coating material used in combination with the relatively hard screw heads is resistant to abrasion and screw driver damage. This feature virtually eliminates the need for touch up painting after assembly.
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

SPECIFICATIONS:

1. Screws meet the requirements of NAS600 series, including thread size .086-56 and .216-24 which are not listed as part of the NAS specification, except for plating requirements.

2. Plating: Zinc plate IAW ASTM B633, Class SC1, Type VI-yellow, hexavalent chromium free, RoHS-compliant.

3. Threads are in conformance with MIL-S-8879, except parts with thread codes “2C” & “12C” which are IAW MIL-S-7742.

4. Thermosetting coating material is applied to screw head only, threads are free of coating.

5. Screw head coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
**FEATURES:**

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant.

**NOTES:**

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

---

**SPECIFICATIONS:**

1. Screws meet the requirements of NAS600 series, including thread size .086-56 and .216-24 which are not listed as part of the NAS specification, except for plating requirements.

2. Screws are cadmium plated per QQ-P-416, Type II, Class 2.

3. Threads are in conformance with MIL-S-8879, except parts with thread codes “2C” & “12C” which are IAW MIL-S-7742.

4. Thermosetting coating material is applied to screw head only, threads are free of coating.

5. Screw head coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

---

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---

**COLORED SCREW**

PAN HEAD, MACHINE THREAD, ALLOY STEEL

---

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<tr>
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<td>.112-40 UNC-3A</td>
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<td>6</td>
<td>7</td>
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<td>12C</td>
<td>.216-24 UNC-3A</td>
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<td>10</td>
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</tbody>
</table>

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order. Length code designates nominal length in 1/16-inch increments (for example, length code 8 = 1/2-inch long screw).

---

**PART NO. EXAMPLE:**

S 10F 10 D L11BN = PAN HEAD SCREW, .190-32 X 5/8" LG, ALLOY STEEL, CADMIUM PLT, PHILLIPS DRIVE, LUSTERLESS BROWN PER FED-STD-595 NO. 30140

---

**REV 03-2015**

4-2
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order. Length code designates nominal length in 1/16-inch increments (for example, length code 8 = 1/2-inch long screw).

SPECIFICATIONS:
1. Screws meet all requirements of MS51957 (UNC-2A) and MS51958 (UNF-2A).
2. Screws are stocked passivated per SAE-AMS2700.
4. Thermosetting coating material is applied to screw head only, threads are free of coating.
5. Screw head coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.

3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the hexagon socket to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.3, Socket Button Head Cap Screws.

2. Screws are alloy steel and are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.


4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.

3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the hexagon socket to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.3, Socket Button Head Cap Screws.

2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.


4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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BUTTON HEAD SCREW, 10-32 X 1/2" LG, STEEL, RoHS ZINC, HEXAGON SOCKET, SEMI-GLOSS BLUE PER FED-STD-595 NO. 25526

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<th>LENGTH</th>
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<th>MATERIAL</th>
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<td>.086-56 UNRC-3A</td>
<td>3</td>
<td>4</td>
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<td>ZR STEEL HEXAGON SOCKET RoHS COMPLIANT ZINC PLATE</td>
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<td>4C</td>
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<td>8C</td>
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</table>
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. The thermosetting coating material is both abrasion and solvent resistant. Screw heads are cleaned and prepared for maximum adhesion of the coating material.

3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the hexagon socket to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws are in accordance with ANSI/ASME Standard No. B18.3, Socket Button Head Cap Screws.

2. Screws are 300 series corrosion resistant steel and are stocked passivated per SAE-AMS-2700.


4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

---

**TABLE**

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<th>L/4</th>
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**COLORED SCREW**

COLORED BUTTON HEAD, MACHINE THREAD, CRES, RoHS-COMPLIANT

---

**PART NO. EXAMPLE:** BHCS 10F 10 C S17BL = BUTTON HEAD SCREW, 10-32 X 5/8” LG, CORROSION RESISTANT STEEL, HEXAGON SOCKET, SEMI-GLOSS BLUE PER FED-STD-595 NO. 25488
**TABLE 1: AVAILABLE DIAMETERS & LENGTHS**

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<th>&quot;L&quot; LENGTH</th>
<th>&quot;G&quot; GRIP</th>
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**TYPICAL APPLICATION:**
SECURING PANELS AND RACK MOUNTED EQUIPMENT

**WASHER HEAD SCREW, .190-32 UNF-3A X 5/8" LG, 7/32" GRIP, ALLOY STEEL, CRUCIFORM RECESS, SEMI-GLOSS BEIGE PER FED-STD-595 NO. 27722

**PART NO. EXAMPLE:**
WH 10 R10 D S15BG =

**HEAD TYPE**

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<th>SIZE</th>
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FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the cruciform recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are NASM525 standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production.

SPECIFICATIONS:
1. Screws meet all requirements of NASM525.
2. Screw material is alloy steel per NASM525.
3. Screws are cadmium plated per AMS-QQ-P-416, Type II, Class 3, or zinc plated per ASTM B633, Fe/Zn 13, Type II, as per NASM525.
5. Thermosetting coating material is applied to screw head only. Threads are free of coating.
6. Screw head coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
7. Previous to NASM525, Revision 2 (released 30-JUN-2010), the nominal length ("L" dimension) did not include the end chamfer. Part inventory manufactured to previous revisions may be procured and used until stock is depleted. For further details, refer to Stake Fastener Co. dwg no. 9-83-0401-105.
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:

1. Screws meet all requirements of NAS514. Screws are stocked cadmium plated per QQ-P-416, Type II. Class 2.

2. Threads are in conformance with MIL-S-8879 and H28 Federal Handbook for threads.

3. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Screws are wired with plating per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.

3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

SPECIFICATIONS:
1. Screws meet all requirements of NAS514 series except for plating (see spec #2).

2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.

3. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

4. Screws are wired with plating per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.

COLORED SCREW
100° FLAT HEAD, MACHINE THREAD, ALLOY STEEL, RoHS-COMPLIANT ZINC
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:
1. Screws meet all requirements of MS24693. Material is 300 series corrosion resistant steel. Screws are passivated per SAE-AMS-2700.
2. Threads are in conformance with H28 Federal Handbook for threads.
3. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect aircraft quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:
1. Screws meet all requirements of MS51959 (UNC-2A) and MS51960 (UNF-2A). Screws are passivated per SAE-AMS-2700.

2. Threads are in conformance with H28 Federal Handbook for threads.

3. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material.

SPECIFICATIONS:
1. Screws meet the requirements of DIN 965, Metric Machine Screws, Cross Recess. Dimensions shown in above table are for reference only; refer to current revision of DIN 965 for dimensions and tolerances. Dimensions are in mm.
2. Screw material is A2 (300 series) corrosion resistant steel (CRES), passivated.
3. Screw head coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

PART NO. EXAMPLE: FHM 4M 10 CP G24GY = FLAT HEAD METRIC SCREW, M4 X 0.7 THREADS X 10mm LG, CORROSION RESISTANT STEEL, CROSS RECESS, HEAD COATED GLOSS GRAY PER FED-STD-595 NO. 16376
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. TORX® is a registered trademark of Camcar Textron.
2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.
3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production.

SPECIFICATIONS:
1. Screws meet the requirements of ASME B18.6.7M, Metric Machine Screws, except with a TORX® Recess. Dimensions shown in above table are for reference only; refer to current revision of ASME B18.6.7M for dimensions and tolerances. Dimensions are in mm.
2. Screw material is 300 series corrosion resistant steel (CRES), passivated.
3. Screw head coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:


2. Screws are alloy steel and are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.

3. Threads are in conformance with H28 Federal Handbook for threads.

4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:
2. Screws are zinc plated per ASTM B633, Class SC-1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.
3. Threads are in conformance with H28 Federal Handbook for threads.
4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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PART NO. EXAMPLE: OHC 8C 10 ZR S17BL = 82° OVAL HEAD SCREW .164-32 X 5/8" LG, ALLOY STEEL, PHILLIPS DRIVE, SEMI-GLOSS BLUE PER FED-STD-595 NO. 25488

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82° OVAL HEAD SCREW 82° OVAL HEAD
MACHINE THREAD
ALLOY STEEL, RoHS-COMPLIANT

82° OVAL HEAD SCREW .164-32 X 5/8" LG, ALLOY STEEL, PHILLIPS DRIVE, SEMI-GLOSS BLUE PER FED-STD-595 NO. 25488
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.
3. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:
2. Screws are 300 series corrosion resistant steel and are stocked passivated per SAE-AMS-2700.
3. Threads are in conformance with H28 Federal Handbook for threads.
4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

DIMENSIONAL DATA

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COLOR CODE

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SF Dupree
82° OVAL HEAD, MACHINE THREAD, CRES, RoHS-COMPLIANT
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. TORX® is a registered trademark of Camcar Textron.

2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.

3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material.

4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:


2. Screws are stocked zinc plated in accordance with ASTM B633, Class SC1, Type II.

3. Threads are in conformance with H28 Federal Handbook for threads.

4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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COLORED SCREW
82º OVAL HEAD,
TORX® RECESS, MACHINE THREAD,
ALLOY STEEL, PLATED
FEATURES:

1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging, followed by a heat treating process which increases the basic tensile strength of the material. The resultant high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:

1. TORX® is a registered trademark of Camcar Textron.

2. The screws listed in this series reflect high quality with emphasis on the forming of the TORX® recess to meet design specification.

3. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

SPECIFICATIONS:


2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.

3. Threads are in conformance with H28 Federal Handbook for threads.

4. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.
2. Screw heads are formed by cold forging followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.
3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.
2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate misorting and subsequent damage to the drive recess and coating material.
3. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thicknesses. Refer to ANSI B18.6.4, Appendix VI.

SPECIFICATIONS:
1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB thread.
2. Screws are stocked zinc plated per ASTM B633, Class SC1, Type II.
3. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

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COLORED SCREW
100° OVAL HEAD, SHEET METAL THREAD, STEEL

REV 06-2014 4-18
FEATURES:
1. Screws are furnished with pre-colored heads to match panels and equipment. The coating material used in combination with the relatively hard screw heads is resistant to abrasion and screwdriver damage. This feature virtually eliminates the need for touch-up painting after assembly.

2. Screw heads are formed by cold forging followed by a case hardening and heat treating process which increases the basic tensile strength of the material. The resulting high tensile strength thus eliminates burring and yield of the substrate under the coating material.

3. Screw heads are cleaned and prepared for maximum adhesion of the coating material. The thermosetting coating material is both abrasion and solvent resistant. Slight overspray on underside of head is permissible.

NOTES:
1. The screws listed in this series reflect high quality with emphasis on the forming of the Phillips recess to meet design specification.

2. Care should be exercised to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismating and subsequent damage to the drive recess and coating material.

3. The recommended installation hole sizes shown in the table are for light gage (.030) sheet metals. Compensation should be made for other materials and thicknesses. Refer to ANSI B18.6.4, Appendix VI.

4. The thread diameters and lengths listed in the table are industry standard sizes. Inventory levels of these sizes may vary at any one time due to customer demands and lead time necessary for production. Lengths not listed are also available on order.

5. These screws are capable of forming mating threads in steel plate with a maximum Rockwell hardness of B70-85 without thread shearing or breakage.

SPECIFICATIONS:
1. Screws are in accordance with ASME Standard No. B18.6.3, Recessed Head Tapping Screws, Type AB thread.

2. Screws are zinc plated per ASTM B633, Class SC1 (min), Type VI-yellow, hexavalent chromium free, RoHS-Compliant.

3. Coating colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.

HEAD TYPE | THREAD | RECOMMENDED INSTALLATION HOLE SIZE | L | LENGTH | TOL. ±.03 | MATERIAL | COLOR CODE | HEAD DATA
---|---|---|---|---|---|---|---|---
| | | | | | | | | |
| 6SM | OH | .104 | 4 | 6 | 8 | 10 | 12 | 14 | 16 | ZR | STEEL PHILLIPS DRIVE RoHS COMPLIANT ZINC PLATE | .279 | .238 | .060 | .105 | .329 | .385 | .333 | .083 | .143 |
| 7SM | OH | .125 | 6 | 8 | 10 | 12 | 14 | 16 | .329 | .329 | .329 | .329 | .329 | .329 | .329 | .329 |

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Pressure Displacement Stake Fasteners

This catalog section covers pressure displacement STAKE FASTENERS. These fasteners are designed for use in applications where relatively strong threads are needed in a relatively soft mounting material. These pressure displacement fasteners must be installed into sheet material that is ductile and capable of forming into the knurled recess of the fastener without stress cracking, such as 2024-T3 or 6061-T6 aluminum. The principle which makes this product unique is the method of installation. The large flange is coined, or pressed, into the sheet until it is flush with the surface. The volume of displaced material is calculated to flow into and fill the void area around the knurled fastener undercut as the fastener is driven into the sheet. The effect of this principle is that deformation or rivet action occurs to the sheet, not to the fastener. Thus, the “Basic” fastener series listed in this catalog may be installed into a relatively soft metal, providing a relatively hard threaded hole, which is flush with the sheet on both surfaces.

The type “BA” and “BB” series fasteners also provide the grip area flush with both surfaces of the sheet after installation. However, in order to provide a self-locking thread feature, a thin-walled appendage is added which includes a spring action deformed thread. The “BA” series is used in the same manner of a conventional clinch nut with the screw entering through the grip area. The “BB” series is intended for housing the appendage in a thick sheet, such as an edge lighted panel, with the screw entering through the appendage. In both instances the self-locking feature is located on the appendage near the grip area, eliminating the need for the screw length to extend through and out of the fastener. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.
The type “Basic”, “BA”, and “BB” fasteners are designed to be installed using standard presses (mechanical, hydraulic, or impact) commonly found in a shop environment. The tooling required is simply a punch and an anvil which can be installed in the press to be used. For the type “Basic” fastener, both the punch and anvil are flat. For the type “BA” and “BB” fasteners, a clearance hole (F & G dimensions) is required in the punch for the appendage. See Table 1 below for recommended punch clearance hole size. Due to the wide variety of press equipment available and the simplicity of the punch and anvil required, it is intended that customers fabricate their own punch and anvil to fit their particular equipment and applications.

To install the fastener, a mounting hole must be punched or machined into the sheet per dimension ‘E’, shown on the part specifications. It is not necessary nor recommended that the mounting hole be deburred prior to installation. Place the sheet material with the mounting hole centered over the flat anvil. Locate the fastener with the small flange diameter towards the sheet (see Figure, INSERT) and centered over the mounting hole. Lower the punch over the fastener and locate the fastener appendage into the clearance hole for type ‘BA’ and ‘BB’ fasteners (see Figure, STAKE). Apply pressure between the punch and anvil to force the fastener into the sheet until the grip areas are flush with both surfaces of the sheet (see Figure, INSTALLED). This staking process should be performed in one continuous motion for best results. The amount of pressure to be applied will vary with fastener size, sheet thickness, and type of material used.

<table>
<thead>
<tr>
<th>THREAD CODE</th>
<th>THREAD SIZE</th>
<th>APP DIA</th>
<th>TOOLING CLEARANCE HOLE</th>
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<tr>
<td>2C</td>
<td>.086-56UNC-3B</td>
<td>.110</td>
<td>#31 .20</td>
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<tr>
<td>4C</td>
<td>.112-40UNC-3B</td>
<td>.139</td>
<td>#26 .23</td>
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<td>6C</td>
<td>.138-32UNC-3B</td>
<td>.165</td>
<td>11/64 .26</td>
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<tr>
<td>8C</td>
<td>.164-32UNC-3B</td>
<td>.204</td>
<td>#4 .26</td>
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<tr>
<td>10F</td>
<td>.190-32UNF-3B</td>
<td>.229</td>
<td>15/64 .29</td>
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<tr>
<td>14F</td>
<td>.250-28UNF-3B</td>
<td>.300</td>
<td>5/16 .29</td>
</tr>
</tbody>
</table>
FEATURES:
1. The pressure displacement principle provides a fastener made of a relatively strong material installed into a relatively soft mounting material.
2. The basic fastener provides a steel threaded hole in a relatively soft material, flush with both surfaces of the mounting sheet.

NOTES:
1. High carbon steel (Material Code D) parts are stock items. Parts made of type 303 corrosion resistant steel (MIL-S-7720) are available, on order, by using Material Code C.
2. Parts are installed by pressure displacement principle as illustrated by figures. Pressure is applied between two anvils which may be installed in any suitable equipment, such as hydraulic or impact punch presses. Pressure to be applied will vary with fastener size, sheet thickness and type of material used.
3. Sheet material must be ductile and capable of forming into knurled recess of fastener without stress cracking.
4. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

SPECIFICATIONS:
1. Steel fasteners (Material Code D) are made of chrome molybdenum alloy per AISI4140 (or equal).
2. Steel fasteners (Material Code D) are cadmium plated per QQ-P-416, Type II, Class 2.
3. Corrosion resistant steel fasteners (Material Code C) are passivated per SAE-AMS-2700.
### FEATURES:

1. The pressure displacement principle provides a fastener made of a relatively strong material installed into a relatively soft mounting material.

2. The BA fastener provides a steel threaded hole in a relatively soft material, flush with both surfaces of the mounting sheet, except for the protruding self-locking appendage.

### NOTES:

1. High carbon steel (Material Code D) parts are stock items. Parts made of type 303 corrosion resistant steel (MIL-S-7720) are available, on order, by using Material Code C.

2. Parts are installed by pressure displacement principle as illustrated by figures. Pressure is applied between a punch and an anvil which may be installed in any suitable equipment, such as hydraulic or impact punch presses. A clearance hole is shown in the punch to accommodate the self-locking appendage.

Pressure to be applied will vary with fastener size, sheet thickness and type of material used.

3. Sheet material must be ductile and capable of forming into knurled recess of fastener without stress cracking.

4. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

### SPECIFICATIONS:

1. Steel fasteners (Material Code D) are made of chrome molybdenum alloy per AISI4140 (or equal).

2. Steel fasteners (Material Code D) are cadmium plated per QQ-P-416, Type II, Class 2.

3. Corrosion resistant steel fasteners (Material Code C) are passivated per SAE-AMS-2700.

---

### TABLE: HEAD TYPE, THICKNESS, THREAD, APPENDAGE TYPE & LENGTH, MATERIAL

<table>
<thead>
<tr>
<th>HEAD TYPE</th>
<th>B THICKNESS</th>
<th>T THREAD</th>
<th>C APPENDAGE TYPE &amp; LENGTH</th>
<th>A</th>
<th>D</th>
<th>E</th>
<th>MATERIAL</th>
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<tbody>
<tr>
<td>SF</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>D HIGH CARBON STEEL (SEE NOTE 1)</td>
</tr>
<tr>
<td>4E 5E 6E</td>
<td>.04 .05 .06</td>
<td>2C</td>
<td>.086-56 UNC-3B BA3</td>
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<td>4F 5F 6F</td>
<td>.08 .09 .10</td>
<td>4C</td>
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<td>.188</td>
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<td>4H 5H 6H</td>
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<td>8C</td>
<td>.164-32 UNC-3B BA5</td>
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<td>.204</td>
<td>.250</td>
<td></td>
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<tr>
<td>6J 8J 9J</td>
<td>.20 .21 .22</td>
<td>10F</td>
<td>.190-32 UNF-3B BA6</td>
<td>.375</td>
<td>.229</td>
<td>.312</td>
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<tr>
<td>8L 9L 10L</td>
<td>.24 .25 .26</td>
<td>14F</td>
<td>.250-28 UNF-3B BA6</td>
<td>.438</td>
<td>.300</td>
<td>.375</td>
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</tr>
</tbody>
</table>
FEATURES:

1. The pressure displacement principle provides a fastener made of a relatively strong material installed into a relatively soft mounting material.

2. The BB fastener provides a steel threaded hole in a relatively soft material, flush with both surfaces of the mounting sheet, except for the protruding self-locking appendage.

NOTES:

1. High carbon steel (Material Code D) parts are stock items. Parts made of type 303 corrosion resistant steel (MIL-S-7720) are available, on order, by using Material Code C.

2. Parts are installed by pressure displacement principle as illustrated by figures. Pressure is applied between a punch and an anvil which may be installed in any suitable equipment, such as hydraulic or impact punch presses. A clearance hole is shown in the punch to accommodate the self-locking appendage.

Pressure to be applied will vary with fastener size, sheet thickness and type of material used.

3. Sheet material must be ductile and capable of forming into knurled recess of fastener without stress cracking.

4. In all cases the fastener should be installed to allow screw threads to enter the side opposite the large flange. When the screw is cinched at installation, the forces are applied against the large flange.

SPECIFICATIONS:

1. Steel fasteners (Material Code D) are made of chrome molybdenum alloy per AISI4140 (or equal).

2. Steel fasteners (Material Code D) are cadmium plated per QQ-P-416, Type II, Class 2.

3. Corrosion resistant steel fasteners (Material Code C) are passivated per SAE-AMS-2700.
Special Fasteners

Screws with head styles, special washers, drive shapes and thread forms, standard in the industry but not listed in this catalog, can be provided with pre-coated colored heads on order. Additionally, we often employ our expertise in cold heading, screw machine work, threading, injection and transfer molding, and coating processes to develop special items to meet our customer requirements. A few samples of these special items are shown below. We invite inquiries for such special items and look forward to working with our customers to provide products that will fulfill the needs of their special fastener application requirements.
FEATURES:
1. Hole Plugs are color-matched to blend with the mounting surface of panels and equipment.
2. Designed to snap in and hold firmly in place. Hole Plugs offer a simple cover for unneeded holes.
3. The durable nylon material allows the product to be snapped out and reused, or left permanently in place for the life of the equipment.

NOTES:
1. The Hole Plugs are designed to fit holes in panels detailed by dimensions “E” & “F” in the above table.
2. For available colors, see Stock Color List, document no. SCL870115. Additional colors will be added upon request.
3. Sizes or head styles other than those shown herein may be available. Contact factory for further inquiries.

SPECIFICATIONS:
1. Hole Plug color is achieved by molding with pigmented nylon per ASTM D4066.
2. Colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer-furnished color chips or samples.
FEATURES:

1. These nylon blind rivets are intended for applications involving very light loads, generally in plastic materials.

2. Rivets can be supplied in colors matched to customer requirements. Color can be matched to blend with mounting surfaces or to be a color indicator to suit customer needs.

NOTES:

1. These nylon blind rivets are installed by placing rivet prongs into panel holes; bring panels together and place rivet head in contact with top panel, and then drive pin into rivet body.

2. Rivets can be removed by driving pin through and out of rivet, and then removing rivet body from panels. It is recommended to replace these rivets with new once they are removed from an installation.

SPECIFICATIONS:

1. Rivet material is polyamide nylon 66 resin. Rivets are not load-rated.

2. Rivets can be supplied in either natural-colored nylon, color code is “G02NA”, or color matched to customer requirements. See Stock Color List, document no. SCL870115 for available colors.

3. Colors are matched to customer requirements. We recommend selection from FED-STD-595 whenever possible but we are also prepared to match customer furnished color chips or samples.

4. Recommended panel hole size is listed in above table and is based on application grip length (“G” dimension). For example, when using p/n: PRR8-4G02NA in panels where “G” = .188, the recommended hole size is .266 (17/64” drill).
Appendix A - Stock Colors

FED-STD-595 colors are preferred due to broad usage, however, we do match suitable color chips in any color.

The following list indicates our current stock colors. For surface finish, precede the color code (shown as [ X brackets] with G (Gloss), S (Semi-gloss), or L (Lusterless). FED-STD-595 lists the 10.000 series as gloss (G), 20,000 series as semi-gloss (S), and 30,000 series as lusterless (L).

Status of colors shown are either Active (A) or Reserved (R). Active colors are in stock and available for production, and reserved colors have been defined, but no order has been placed.

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<th>COLOR CODE</th>
<th>DESCRIPTION</th>
<th>STATUS</th>
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<td>01BG</td>
<td>1049 BEIGE</td>
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<tr>
<td>02BG</td>
<td>3578 FED-STD-595</td>
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</tr>
<tr>
<td>04BG</td>
<td>870 BEIGE</td>
<td>A</td>
</tr>
<tr>
<td>05BG</td>
<td>7500 SAND</td>
<td>A</td>
</tr>
<tr>
<td>06BG</td>
<td>6009-0026 SHELL WHITE</td>
<td>A</td>
</tr>
<tr>
<td>S07BG</td>
<td>22563 FED-STD-595</td>
<td>A</td>
</tr>
<tr>
<td>08BG</td>
<td>3817 FED-STD-595</td>
<td>A</td>
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<tr>
<td>09BG</td>
<td>3522 FED-STD-595</td>
<td>A</td>
</tr>
<tr>
<td>11BG</td>
<td>8925 BEIGE</td>
<td>A</td>
</tr>
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<td>12BG</td>
<td>A.T.L. WHITE</td>
<td>A</td>
</tr>
<tr>
<td>13BG</td>
<td>7409 OFF WHITE</td>
<td>A</td>
</tr>
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<td>8813 BEIGE</td>
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<td>S16BG</td>
<td>C.B.X. BEIGE</td>
<td>A</td>
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<td>S17BG</td>
<td>23590 FED-STD-595</td>
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</tr>
<tr>
<td>18BG</td>
<td>7801 PEPPER DUST</td>
<td>A</td>
</tr>
<tr>
<td>S19BG</td>
<td>COVERT BEIGE</td>
<td>A</td>
</tr>
<tr>
<td>S20BG</td>
<td>LIGHT FAWN</td>
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</tr>
<tr>
<td>S21BG</td>
<td>C.O. WHITE</td>
<td>A</td>
</tr>
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<td>22BG</td>
<td>A.T.T. WHITE</td>
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</tr>
<tr>
<td>S23BG</td>
<td>7393 WHITE (same as S20WH)</td>
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</tr>
<tr>
<td>24BG</td>
<td>FLORHAM BEIGE</td>
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<td>1225 BEIGE</td>
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<td>S26BG</td>
<td>HYBEIGE</td>
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<td>G27BG</td>
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<td>810-670 BEIGE TINT</td>
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<td>G29BG</td>
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<td>L36BG</td>
<td>CABINET BEIGE</td>
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<td>DESERT SAND A02530</td>
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<td>L38BG</td>
<td>MEDIUM BEIGE 250</td>
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<td>L39BG</td>
<td>TAUPE 91</td>
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14335 Ramona Avenue
Chino, CA 91710
Tel: (909) 597-4899
Fax: (909) 597-3043

Material: Finish
Dr. M.S.L. Date 7/13/1979
App. G.J.M. Date 09/15/2015
XXX Scale
XX
SCL870115

STOCK COLOR LIST

Sheet 1 of 4
Rev. EG
## STOCK COLOR LIST

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<th>COLOR CODE</th>
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<th>STATUS</th>
<th>COLOR CODE</th>
<th>DESCRIPTION</th>
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<td>L32BN</td>
<td>30040 FED-STD-595</td>
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<td>G38BL</td>
<td>P6279 MING BLUE II MET</td>
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<td>MIDNIGHT BLUE P2309</td>
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<tr>
<td>S39BL</td>
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<td>G41BL</td>
<td>CARINTHIA BLUE</td>
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<td>BLUE METALLIC #5 P6170</td>
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<td>G44BL</td>
<td>BLUE HAZE P6158</td>
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<td>( )0219 FED-STD-595</td>
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<td>( )0140 FED-STD-595</td>
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<td>S26BN</td>
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</tr>
<tr>
<td>[ ]28BN</td>
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<tr>
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<td>( )0372 FED-STD-595</td>
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<tr>
<td>[ ]32BN</td>
<td>( )017 FED-STD-595</td>
<td>A</td>
<td>G24BN</td>
<td>10049 FED-STD-595</td>
<td>R</td>
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<tr>
<td>S25BN</td>
<td>20206 FED-STD-595</td>
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<td>S26BN</td>
<td>80491 DEEP COPPER</td>
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**STAKE FASTENER CO.**

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CHINO, CA 91710

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FAX (909) 597-3043

CAGE 12324

www.stakefastener.com
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CAGE 12324

STOCK COLOR LIST

SCL870115

STAKE Fastener Company

www.stakefastener.com
Screwdrivers

Our fasteners are manufactured using high-quality materials with emphasis on the forming of the drive recess to meet design specifications. We urge customers to exercise care to assure that the screwdriver tools meet the same quality and design specification in order to eliminate mismatching and subsequent damage to the drive recess and coating material. We also suggest slightly de-burring the driver tools to remove extreme sharp edges to minimize cutting of the coating materials. This can be achieved by dressing the tool bit with a wire brush as a locksmith does to a newly cut key.

Material Handling

Parts are carefully packaged before shipment to customers. Parts are bagged, labeled, tightly wrapped, and properly boxed to protect the color coating during shipment. Package quantities are determined by fastener size to provide proper protection. We recommend that parts remain in their original packing material until just before use. If it is necessary to re-package, then necessary care must be exercised to minimize damage from threads rubbing against color-coated surfaces. The color coating material is very durable but it is a coated surface and can be damaged if proper care is not exercised.

PAN-L-SCREW Tightening Torque

Care must be exercised during installation of PAN-L-SCREWS to prevent over-tightening due to the nature of the nylon washer material. Over-tightening is possible and results in deformed washers. Several factors are involved with determining the proper installation torque, including PAN-L-SCREW size, clearance hole size and thread fit. In most applications we recommend tightening until snug and then tightening an additional 1/4 to 1/2 turn. The compression effect of the nylon washer between the screw head and panel will provide a self-locking feature to prevent vibration from loosening the screw in most applications.

Nominal Thread Sizes

To conform to accepted industry standard practices, the nominal thread sizes for machine threads which are specified in this catalog (for non-metric items) are called out in decimal inches, instead of using the screw number or fractional diameter as was customary in the past. The following table gives the equivalent of the screw number / fractional size to the decimal size:

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All products are subjected to our documented ISO 9001:2008 and AS9100C quality procedures and are lot-traceable.
## Appendix C - Detailed Product Listing

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<td><strong>Decorative Color-Coated Screws</strong></td>
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<td>Pan Hd, Machine Thd, CRES, Phillips</td>
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<td>Flat Hd (90°), Metric Thd, CRES, Cross</td>
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<td>Pressure Displacement Stake Fasteners</td>
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Stake Fastener Company has been the industry standard for color-coated screws and fasteners for over fifty years. Our products are suitable for most applications where a decorative, color-matched fastener is required.